

ROYALFIL GS 45 R (E121T1-G C)

AWS A / SFA 5.29 E121T1- G CEN ISO 18276 A T793Mn2NiMoRC1H5

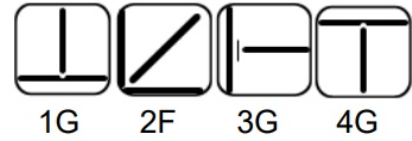
Applications

For welding of high strength fine grain structured steel having yield strength around 750 N/mm². Also use to weld high strength steel such as HY-80, Hy-100 grade & other similar steels

Characteristics on Usage

RoyalFil GS - 45R is Rutile base flux cored wire for all position welding. It gives stable arc easily detachable slag, uniform bead & less spatters with Co₂ shield. Weld metal is of radiographic quality.

Welding Positions



Recommended Stick Out

15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) shielding
Gas Flow: 15-20 Lit/Min.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12 Max	1.50 -1.80	0.80 Max	0.030 Max	0.030 Max
Ni%	Mo%			
2.00-2.60	0.40-0.65			

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT -30 °C (J)
830-900 Min	830-745 Min	14-18Min	27-50 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (V)	Vertical - Up (V)	Overhead (V)	Overhead (V)
1.20	180-250	26-30	120-210	22-26	150-200	26-30
1.60	210-280	26-30	160-250	22-27	190-240	26-30

Packing

15 kgs. Vacuum packed plastic spool