

# ROYALFIL GS 46R (E111T1-GC)

AWS A / SFA 5.29 E111T1 - GC EN ISO 18276 A T694Mn2NiMoRC1H5

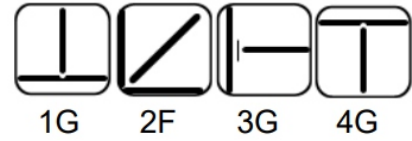
## Applications

RoyalFil GS 46 R is primarily intended for as welded applications for welding of low alloy high strength steels. Weld metal provides excellent Notch toughness at low temperature.

## Characteristics on Usage

RoyalFil GS 46 R is rutile based low hydrogen type all position flux cored wire designed for single and multiple pass welding with Co2 shielding gas. Weld metal is of radiographic quality. .

## Welding Positions



## Recommended Stick Out

15-20mm

## OutShielding Gas

Carbon Dioxide (CO<sub>2</sub>) shielding  
Gas Flow: 15-20 Lit/Min.

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12 Max	1.20-2.00	0.80 Max	0.030 Max	0.030 Max
Ni%	Mo%			
2.00-2.75	0.35-0.65			

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	MPACT(CVN) AT -40 °C ( J )
760-900 Min	680-780 Min	15-20 Min	27-60 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