

ROYALFIL GS 48R (E111T1-K3C)

AWS A / SFA 5.29 E111T1 -K3C EN ISO 18276 A T692Mn2NiMoRC1H5

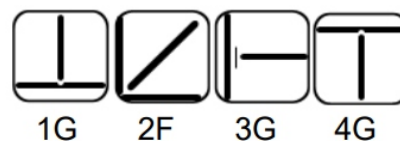
Applications

RoyalFil GS 48 R is designed for welding of high strength, low alloy steels such as HY 100, A514 & similar HSLA and Q & T steels. Used in Shipbuilding, Crane building, Platforms, Pipe works etc.

Characteristics on Usage

RoyalFil GS 48 R is low alloy rutile type all position flux cored wire with 100% with CO₂ gas shielding. The weld deposit of radiographic quality with low diffusible hydrogen, stable and smooth arc with good slag detachability. Suitable for single & multi pass welding of high strength low alloy steel.

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	0.75-2.25	0.80 Max	0.030 Max	0.030 Max
Ni%	Mo%			
1.25-2.60	0.25- 0.65			

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT -40 °C (J)
760-900 Min	680-760 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