

ROYALFIL GS 706 C (E70C-6M)

AWS-SFA A 5.18 E70C- 6MH4 EN ISO 17632 A T383MM3H5

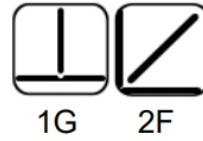
Applications

It is used for welding of medium & high tensile steel with mixed gas 80%Ar + 20% Co2 shielding in ship building, machineries, structural fabrication and bridge constructions.

Characteristics on Usage

Royalfil GS 706-C is a metal Cored arc welding wire. It gives good penetration high resistance to porosity with controlled hydrogen. Intended for both semi automatic, automatic single & multiple welding with 80%Ar + 20% Co2 shielding. Characterized by a spray arc, excellent bead wash characteristics and no slag covering. Elimination of slag removal is especially beneficial in hard to reach areas.

Welding Positions



Recommended Stick Out

20-40 mm

OutShielding Gas

80% Ar + 20% CO2 shielding
Gas Flow:20-25 Lit/Min

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr%
0.12Max	1.75 Max	0.90 Max	0.030 Max	0.030 Max	0.020 Max
Ni%	Cu%				
0.50 Max	0.50 Max				

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 30°C (J)
480-585 Min	400-490 Min	22-26 Min	27-60 Min

Packing and Welding Current

SIZE (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	160-210	28-34
1.60	180-250	28-34

Packing

15 Kgs. vaccum packed plastic spool.