

ROYALFIL GS 80 M (E80C-GM)

AWS A / SFA 5.28 E80C-GMEN ISO 17632 A T460MM3H5

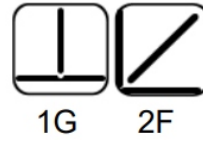
Applications

Intended for single & multiple pass applications. Used for welding of medium & high tensile low alloy steel with (80 %Ar - 20% CO2). It can be used on 1.25 Cr. & 0.5 Mo steels. Recommended for welding of steam boiler plates and high temperature steels.

Characteristics on Usage

ROYALFIL GS-80M is a low alloy steel metal cored welding wire. It gives low spatter, higher deposition rate, and good penetration & generates less fumes. Faster travel speeds are achievable than with solid wire, thus increasing productivity.

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%
0.10Max	1.00-1.50	0.3-0.6	0.030 Max	0.030 Max	1.0-1.50
Mo					
0.4-0.65					

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT - 0°C (J)
550-630 Min	470-540 Min	19-24 Min	47-90 Min

Packing and Welding Current

SIZE (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	180-250	28-34
1.60	200-300	28-34

Packing

15 Kgs. vacuum packed plastic spool.