

ROYALFIL GS 80 RB (E80T5-B2 C)

AWS A / SFA 5.29 E80 T5 - B2 CEN ISO 17634 A TCrMo1BC3H5

Applications

Since all Cr-Mo electrodes produce weld metal which will harden in still air, both preheat & post weld heat treatment are required for most applications. Specially design for Cr-Mo Steels with high temp & pressure service condition in steam pipes of boilers.

Characteristics on Usage

RoyalFil GS 80 RB is low hydrogen type flux cored wire with highly basic slag having stable & smooth arc, good slag detachability. Weld metal is of radiographic quality. It is used for flat & horizontal position welding with CO₂ shielding.

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%
0.05-0.12	1.25 Max	0.80 Max	0.030 Max	0.030 Max
Cr%	Mo%			
1.00-1.50	0.40 - 0.65			

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %
550-690	470-545 Min	19-24.5 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)
1.20	180-250	26-30
1.60	210-280	26-30

Packing

15 kgs. Vacuum packed plastic spool