

ROYALFIL GS 81 B (E 81T1-G C)

AWS A / SFA 5.29 E 81T1- G CEN ISO 17632 A T462Mn1NiRC1H5

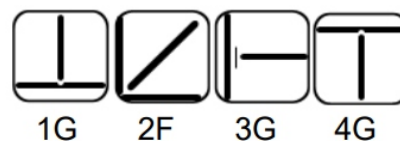
Applications

RoyalFil GS-81B is designed for all position single and multipass welding of ship-building steels etc.

Characteristics on Usage

RoyalFil GS-81B is a semi-automatic type gas shielded flux-cored wire, whereby CO₂ shield is applicable. The weld metal is of radiographic quality with excellent impact strength at sub-zero temperatures up to minus 20°C. The slag coverage is complete and designed for easy removal. The wire is specially designed for welding of ship building steels, etc

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	1.75 Max	0.90 Max	0.030 Max	0.030 Max
Ni%				
0.50 Min				

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT -20 °C (J)
550-690 Min	470-560 Min	19-25 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