

ROYALFIL GS 91 D (E91T1-D1 C)

AWS A / SFA 5.29 E 91T1-D1 CEN ISO 18276 A T554MnMoRC1H5

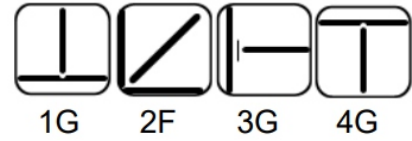
Applications

Royalfil-GS-91D is used for welding steel to IS 8500-91 grade 540B and 590B, IS 2002-92 grade III, IS:1875-92 class III A or other equivalent steel.

Characteristics on Usage

Royalfil GS-91 D is all position flux cored wire for welding of low alloy steel, Carbon – Moly steel. It gives stable and smooth arc with good slag detachability & excellent bead finish with radiographic quality with CO₂ shielding.

Welding Positions



Recommended Stick Out

15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) shielding
Gas Flow: 15-20 Lit/Min.

Approvals

RDSO, IRS CLASS III

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12 Max	1.25- 2.00	0.80 Max	0.030 Max	0.030 Max
Mo%				
0.25-0.55				

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)
620-760	570-580 Min	17-24 Min	27-50 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