

# ROYALFIL GS 91 R (E91T1-G C)

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

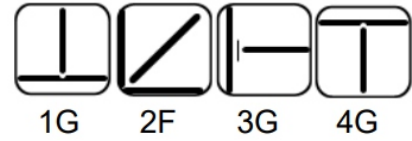
## Applications

Royalfil-GS-91R fcw wire is used for high tensile, fine grain structural steel, creep resistant fine grain structural steels, heat treated fine grain structural steel.

## Characteristics on Usage

Royalfil GS-91 R is Rutile base gas shielded flux cored wire welding for all position welding with Co<sub>2</sub> shielding depositing radiographic quality metal. Arc is smooth & stable with low spatter and good bead appearance. Slag.

## Welding Positions



## Recommended Stick Out

15-20mm

## OutShielding Gas

Carbon Dioxide (CO<sub>2</sub>) shielding  
Gas Flow: 15-20 Lit/Min.

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.05 - 0.08	1.20-1.60	0.25-0.40	0.030 Max	0.030 Max
Ni%	Mo%			
1.0-1.40	0.3-0.50			

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION (L = 4d) %	MPACT(CVN) AT -30 °C ( J )
620-670	540-590 Min	17-22 Min	27-80 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