

ROYALFIL GS D2 (E309LT1-1)

AWS A / SFA 5.22 E309LT1-1 EN ISO 17633 A T2312LRC1

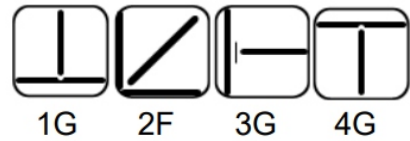
Applications

Royalfil-GS-D2 is suitable for the welding of dissimilar metals such as stainless steel and carbon steel or stainless steel and low alloy steel.

Characteristics on Usage

Royalfil GS-D2 is a stainless steel flux core welding wire for all position welding with CO₂ gas shielding. It gives the 23% Cr and 12% Ni weld deposit with excellent all around performance and resistance to chemical corrosion. Weld metal is of radiographic quality with easy slag removal and low spatters.

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%	Cr%
0.04 Max	0.5-2.50	1.0 Max	0.03 Max	0.04 Max	22.0-25.0
NI%	Mo%	Cu%			
12.0-14.0	0.75 Max	0.75 Max.			

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION. (L = 4d) %
520-600 Min	30-36 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	160-210	26-30	120-160	22-26	150-180	26-30
1.60	190-250	26-30	160-200	22-27	180-210	26-30

Packing

15 kgs. Vacuum packed plastic spool