

ROYALFIL GS T9R MOD-M BW (E71T-12MJ)

AWS A / SFA 5.20 E71T-12 MJ EN / ISO 17632 A T384RM1H5

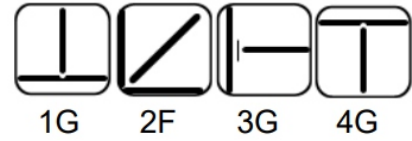
Applications

It is used for all position single and multipass welding of tank, pressure vessels where low temp. service is required.

Characteristics on Usage

Royalfil GS-T9R MOD-M BW is a Titania base all position flux core welding wire designed for optimum performance when using 80% Ar + 20% CO₂ shield. It gives smooth metal transfer with excellent flat bead, least spatter and easy slag removal. The weld deposits content 0.5 % Ni while retaining excellent impact properties at low temp. service. Weld metal is of radiographic quality.

Welding Positions



Recommended Stick Out

15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) Shielding
Gas Flow : 15-20 Lit / Mi

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12Max	1.60 Max	0.90 Max	0.030 Max	0.030 Max
Ni%	Cr%	Mo%	Cu%	V%
0.50 Max	0.20 Max	0.30 Max	0.35 Max	0.08 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	MPACT(CVN) AT - 30°C (J)
585-620 Min	390-520 Min	22-26 Min	27-75 Min

Packing and Welding Current

SIZE (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (A)	Vertical - Up (V)	Overhead (A)	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. vaccum packed plastic spool.