

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

AWS A / SFA 5.20 E71T-12 CEN / ISO 17632 A T383RC1H5

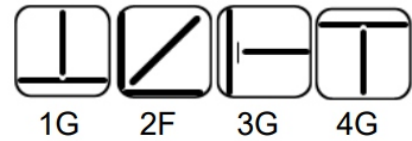
Applications

RoyalFil GS- T12 R is suitable for single and multipass welding of oil and gas constructions, pipe and offshore constructions where low temperature service is required

Characteristics on Usage

RoyalFil GS-T12R is Rutile base flux cored wire for all position optimum performance when using with CO₂ shielding. Metal transfer is smooth, slag coverage is complete and easy removal. Weld metal is consistently free from inclusions and porosity for X ray soundness. Weld deposit is with 0.5 % Ni to improve impact toughness at low temperature service down to - 30 °C even after stress is relieving . The wire is formulated to produce fewer fumes, minimum spatter. Weld metal with 0.5 % Ni. Max and 1.60 % Mn. Max. conforms to the A- no.1 analysis group in the ASME boiler and pressure vessel code, section IX

Welding Positions



Recommended Stick Out

15-20mm

OutShielding Gas

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

FLUX CORED WIRE : CARBON STEEL

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.