

# ROYALFIL OA 435

## Applications

Royalfil GS -12H4R is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-36 /SA-36M and A,B,C,D grades of SA-283 / SA-283M & SA-414 / SA414M.(P.No.1) e.g. Fabrication in chemical plant machinery structures & Steel frames in ship building, heavy bridges & towers.

## Characteristics on Usage

Royalfil GS-12H4R is low hydrogen all position Rutile flux cored wire designed for optimum performance when using CO<sub>2</sub> shield. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce fewer fumes, minimal spatter.

## Welding Positions



## Recommended Stick Out

30-40 mm

FLUX CORED WIRE : HARDFACING

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	Cr%	Ni%	Mo%
0.080	1.00	0.60	13.50	4.00	0.50

## Mechanical Properties Of Weld Metal

HARDNESS ON III rd LAYER	Y.S. (N/mm <sup>2</sup> )	ELONGATION (L = 4d) %	IMPACT ( CVN ) AT - 30° C ( J )
42 – 48 HRC	390-470	22-26 Min	27-60 Min

## Packing and Welding Current

SIZE ( mm )	Flat & Horizontal (A)	Flat & Horizontal (V)
12.40 / 2.80	250-400	26-32

## Packing

Drum packing in 100Kgs / 250 Kgs.