

ROYALFIL GS 12 R (BW) (E71T-1C)AWS A / SFA 5.20 E71T-1C,
EN / ISO 17632 A T422RC1H5**Applications**

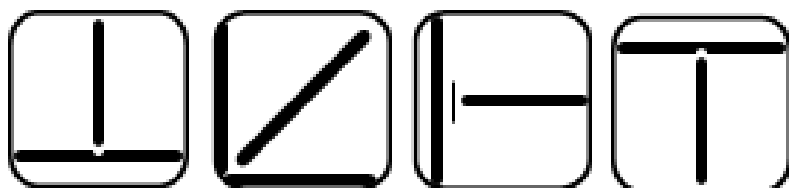
Royalfil GS-12R (BW) is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-36 /SA-36M and A,B,C,D grades of SA-283 / SA-283M & SA-414 / SA-414M.(P.No.1) e.g. Fabrication in chemical plant machinery structures & Steel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

Characteristics on Usage

Royalfil GS-12R (BW) is an all position Rutile flux cored wire designed for optimum performance when using CO₂ shielding. 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**

15-20 mm

Shielding GasCarbon Dioxide (CO₂) Shielding
Gas flow : 20-25 Lit/Min

1G

2F

3G

4G

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%
Typical Values	0.050	1.25	0.40	0.010	0.018
Spec. Req'd.	0.12 Max	1.75 Max	0.90 Max	0.030 Max	0.030 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 20°C
Typical Values	580	485	26.5	80
Spec. Req'd.	490-670	390 Min	22 Min	27 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal	Flat & Horizontal	Vertical - Up	Vertical - Up	Overhead	Overhead
	(A)	(V)	(A)	(V)	(A)	(V)
1.00	140-220	24-28	100-190	22-26	140-190	25-28
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.