

ROYALFIL GS 2 C (E316LT1-1)

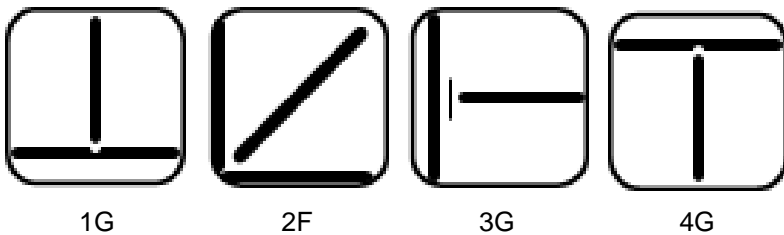
AWS A / SFA 5.22 E 316LT1-1

Applications

It is used for welding of 18% Cr, 12% Ni & 2.50% Mo steel also use for welding of AISE 316L & 317L type of stainless steel in chemical plant, paint, pulp paper & textile industries, CF-8M, CF-3M

Characteristics on Usage

Royalfil GS – 2C is an extra low carbon rutile coated all position stainless steel flux core welding wire with CO₂ gas shielding. It gives the weld deposit of 18% Cr, 12% Ni & 2% Mo etc. It runs smoothly & gives uniform weld metal deposit with easily slag removal. The weld metal is highly resistance to intergranular corrosion. Weld metal is of radiographic quality with easy slag removal and low spatters.

Welding Positions**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %
Typical Values	0.030	1.50	0.70	0.010	0.030	18.50	12.00
Spec. Req'd.	0.040 Max	0.50-2.50	1.0 Max	0.030 Max	0.040 Max	17-20	11-14

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	ELONGATION (L = 4d) %
Typical Values	580	38
Spec. Req'd.	485 Min	30 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat & Horizontal (A)	Flat & Horizontal (V)	Vertical - Up (A)	Vertical - Up (V)	Overhead (A)	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

12.5 kgs. vacuum packed plastic spool.