

**ROYALFIL GS D2 (E309LT1-1)**

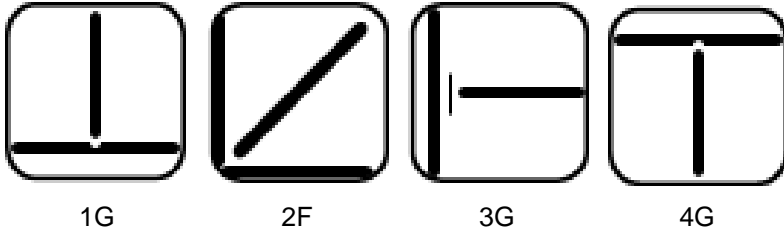
AWS A / SFA 5.22 E309LT1-1

**Applications**

Royalfil-GS-D2 is suitable for the welding of dissimilar metals such as stainless steel and carbon steel or stainless steel and low alloy steel.

**Characteristics on Usage**

Royalfil GS-D2 is a stainless steel flux core welding wire for all position welding with co2 gas shielding. It gives the 23% Cr and 12% Ni weld deposit with excellent all around performance and resistance to chemical 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	1.60	0.65	0.010	0.030	23.20	12.00
Spec. Reqd.	0.04 Max	0.5 – 2.50	1.00 Max	0.030 Max	0.040 Max	22.0 - 25.0	12.0 - 14.0

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
Typical Values	600	36
Spec. Reqd.	520 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

**Approvals**

RDSO:IRS M46 CLASS VII,DNV

**Packing**

12.5 kgs. vacuum packed plastic spool.