

Applications

Royal Super -71 is Rutile type flux cored wire designed for all position single and mulipass welding of low and medium carbon steels.Used for welding in bridges,structural fabrication,vehicles, peb etc.

Characteristics on Usage

Royal Super -71 is 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 - 20mm

Shielding Gas

Carbon Dioxide (CO2) shielding
Gas Flow :20-25 Lit / Min

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%
Typical Values	0.045	1.20	0.35	0.010	0.020
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 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 (J)
Typical Values	575	480	26.5	80
Spec. Reqd.	490-670	390 Min	22 Min	27 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat (A)	Flat (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

Packing

15 kgs. vaccum packed plastic spool.