

ROYAL PRIME-85G

BASIC ALLOY: FE, MN, SI, NI MO
AWS/SFA-5.29: E80T5-G

LOW-ALLOY FLUX-CORED WELDING WIRE FOR
LOW TEMPERATURE SERVICES

KEY FEATURES:

ROFIL-85G a low alloy steel flux cored wire designed for welding of medium & high tensile strength steel, quenched & tempered steels, etc. where sub-zero impact resistance property of the weld metal is desired. The weld has excellent bead appearance and easy slag removal.

APPLICATIONS

- Welding single and multi-pass welding of similar composition steels and equivalent grade steels like; NAXTRA-60/65, Sumiten-610, A/B grades of SA-203, D/ E/ F/ G grades of SA-414, steel grades conforming to SA-455, Gr.60 & Gr.65 steels of SA-515 & SA-516, etc.

SHEILDING GAS

- Welding with CO₂ gas and Ar+ CO₂ gas mixture.

CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Ni	Mo
0.10 Max.	0.50-1.50	0.80 max.	0.030 Max	0.60-1.20	0.60 max.

MECHANICAL PROPERTIES

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
470Min.	550 min,	20 Min	- 40C : 27 J min.

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Spool packing 12.5 kg.	Spool packing 15kg
1.20	3/ 64"	120-300	18-22	✓	✓
1.40	1/ 18"	160-340	18-22	✓	✓
1.60	1/ 16"	180-360	18-22	✓	✓