

RAAJCORED-70

An all position rutile type flux cored wire for MAG/MIG welding.

CLASSIFICATION : AWS/SFA-5.20: E70T1
JIS YFW-C50DM

CHARACTERISTICS : Flux-cored welding wire with rutile type slag base. Quite and smooth running characteristics, very low spatter loss, easy deslagging, weld seams uniformly shaped with smooth edges. Particularly suited for fillet welds.

APPLICATION : Suitable for welding of structural's and boilers, pressure vessel components made of steel with minimum UTS requirements up to 510 N/mm².

SHIELDING GAS : Welding with CO₂ gas and Ar+ CO₂ gas mixture.

CHEMICAL COMPOSITION % (Weld Metal Chemistry under CO₂ Gas)

C	Mn	Si	S	P	Others
0.060	1.55	0.55	0.030 Max	0.030 Max	----

ALL WELD MECHANICAL PROPERTIES FOR MIG (under CO₂ Gas)

YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT
450-540	540-650	22-30	0 ⁰ C : 60-80 J -20 ⁰ C : 40-60 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm)	Size(inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
1.20	5/ 64"	120-300	24-34	15-25	√	√	√
1.40	1/ 18"	130-330	26-34	15-25	√	√	√
1.60	1/ 16"	150-350	28-36	15-30	√	√	√

Raajratna offer a wide range of Flux-cored welding wires for MIG welding.

Customer packing on request.