

RAAJCORED-71 Sp1

Basic type flux cored wire for MAG/MIG welding.

CLASSIFICATION : AWS/SFA-5.20: E71T-5
JIS YFW-C50DR

CHARACTERISTICS : **Basic type** Flux-cored welding wire producing very low hydrogen quality weld metal with high resistance to cracking in joints under restraint. The smooth metal transfer facilities easy deposition even in position welding.

APPLICATION : welding of heavy fabrication of a number of mild steels where superior toughness and crack resistance. welding suitable in tensile strength up to 520 N/mm² in constructions, bridges, pressure vessels and offshore structures boiler quality steels like SA 515-70, 285 grade C, IS :2002-2A and 2B, IS : 2062 , IS: 226 and DIN 17155 HIV etc.

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
0.058	1.40	0.65	0.015	0.020	----

ALL WELD MECHANICAL PROPERTIES FOR MIG (under CO₂ Gas)

YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT
400-520	510-640	24-32	- 30 ⁰ C : 50-100 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"	160-340	26-34	15-25	√	√	√
1.60	1/ 16"	180-360	28-36	15-30	√	√	√

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

Customer packing on request.