

## RAAJCORED-71

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

**CLASSIFICATION** : AWS/SFA-5.20: E71T-1C/1M  
JIS YFW-C50DR

**CHARACTERISTICS** : Titania type Flux-cored welding wire suitable for all welding position of mild steel and structure steel, suitable for high tensile steel up to 510 N/mm<sup>2</sup>. The slag full coverage on weld bead and easy to remove. The smooth and stable arc and wire surface special coating provided for very long shelf life and smooth wire feeding. Weld metal is gives radio graphically sound.

**APPLICATION** : Suitable for chemical machinery equipment, shipbuilding, Automobile industry, bridges, towers, rolling stocks etc.

**SHIELDING GAS** : Welding with CO<sub>2</sub> gas and Ar+ CO<sub>2</sub> gas mixture.

### CHEMICAL COMPOSITION % (Weld Metal Chemistry under CO<sub>2</sub> Gas)

C	Mn	Si	S	P	Others
0.055	1.42	0.58	0.030 Max	0.030 Max	----

### ALL WELD MECHANICAL PROPERTIES FOR MIG (under CO<sub>2</sub> Gas)

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL %	CHARPY "V" NOTCH IMPACT AT
460-550	550-640	22-32	0°C : 80-100 J Minus 20°C : 50-80

### 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.