

RAAJCORED-81W

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

CLASSIFICATION : AWS/SFA-5.29: E81T1-W2
JIS YFA-C58W

CHARACTERISTICS : Flux-cored welding wire designed to produce weld metal that matches the corrosion resistance the coloring of the ASTM weathering-type structural steels. These special properties are achieved by the addition of about 0.5 % Copper to weld metal. To meet strength, ductility and notch toughness in the weld metal.

APPLICATION : Suitable are used to weld typical weathering steel, such as ASTM A 242 and A 588 and weather proof steel for structures, buildings, vehicles and bridges.

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

CHEMICAL COMPOSITION % (Weld Metal Chemistry under CO₂ Gas)

C	Mn	Si	Cr	Ni	Cu	S&P
0.050	1.05	0.65	0.50	0.60	0.50	0.018/ 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
550-620	620-680	24-32	- 30 ⁰ C : 60-100 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.