

# RAAJMIG-1

## Copper coated continuous or cut length solid wire for TIG/MIG welding.

**CLASSIFICATION** : AWS/SFA-5.18: ER70S-6; IS 6419

**APPROVALS** : ABS, RDSO (IRS Class I), BHEL

**CHARACTERISTICS** : Copper coated double oxidized solid wire for all position CO<sub>2</sub> welding. The special characteristics are smooth and stable arc low spatter Thin and uniform copper coating ensure good Conductivity useful for high speed feeding.

**APPLICATION** : Suitable for welding structural steel, sheet metal Carbon steel and low alloy steels for high finish, precision and better productivity.

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

### CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Cu
0.06-0.15	1.40-1.85	0.80-1.15	0.035 Max	0.025 Max	0.50 Max

### Typical All Weld Mechanical Properties for MIG (UNDER CO<sub>2</sub> GAS SHIELD)

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	ELONGATION %	CHARPY "V" NOTCH IMPACT AT
420 min.	510 - 610	22 - 32	Minus 20 <sup>0</sup> C : 70 - 90 J Minus 30 <sup>0</sup> C : 40 - 70 J

### DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIG-1)

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 100/250kg
0.60	0.023	50-200	15-24	10-15	√	√	X
0.80	0.030	70-220	18-24	10-15	√	√	X
0.90	0.035	100-250	20-28	10-20	√	√	X
1.00	0.039	100-250	20-28	10-20	√	√	√
1.20	0.047	150-300	24-30	15-25	√	√	√
1.60	0.062	150-350	26-30	15-30	√	√	√

### DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIG-1)

Size (mm)	Size (inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/16"	1000	36"	80-110	10-16	√	√
2.00	5/64"	1000	36"	100-150	12-18	√	√
2.4 / 2.5	3/32"	1000	36"	130-180	14-20	√	√
3.20	1/8"	1000	36"	150-220	16-24	√	√
4.00	5/32"	1000	36"	200-280	18-28	√	√

Tailor made packing available on request.