

RAAJMIG-7

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

CLASSIFICATION : AWS/SFA-5.18: ER70S-7

CHARACTERISTICS : Copper coated double oxidized solid wire for all position CO₂ 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 steels upto UTS 500 N/mm² and Carbon steel and low alloy steels for single and multi pass with higher travel speeds compared to others filler metals.

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

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Cu
0.07-0.15	1.50-2.00	0.50-0.80	0.035 Max	0.025 Max	0.50 Max

ALL WELD MECHANICAL PROPERTIES FOR MIG (UNDER CO₂ GAS SHIELD)

YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT
420-480.	510-610	22-32	Minus 20 ⁰ C : 70-90 J Minus 30 ⁰ C : 40-60 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 100/200kg
0.60	0.023	40-100	16-20	10-15	√	√	X
0.80	0.031	70-220	16-24	10-20	√	√	X
0.90	0.035	60-180	16-28	10-20	√	√	X
1.00	0.039	100-250	18-28	10-25	√	√	X
1.20	0.047	150-300	24-34	15-25	√	√	√
1.60	0.062	150-350	24-36	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	√	√
2.0	5/ 64"	1000	36"	100-150	12-18	√	√
2.4/ 2.5	3/ 32"	1000	36"	130-180	14-20	√	√
3.2	1/ 8"	1000	36"	150-220	16-24	√	√
4.0	5/ 32"	1000	36"	200-280	18-28	√	√

Raajratna offer a wide range of copper coated welding wires for MIG/TIG/SAW.

Customer packing on request.