

RAAJMIG 80G

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

CLASSIFICATION : AWS/SFA-5.28: ER 80S-G

CHARACTERISTICS : Copper coated solid wire for all position 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 with UTS up to 550 N/mm². Ideal for joining steels Conforming to ASTM grade SA-36,SA-36M and SA-283 SA-283M and also suitable for carbon steel and low alloy Steel.

SHIELDING GAS : **MIG** welding with CO₂ gas and Ar+ CO₂ gas mixture
TIG welding with Argon gas

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Cu	Mo
0.06-0.14	1.30-2.10	0.40-1.00	0.035 Max	0.025 Max	0.50 Max	0.60 Max.

ALL WELD MECHANICAL PROPERTIES (UNDER CO2 GAS SHIELD)

YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT
500 Min.	550 Min.	20.0 Min.	Minus 30 ⁰ C : 27 J Min

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIG 80SG)

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
0.80	0.031	70-220	16-24	10-20	√	√	X
1.20	0.047	150-300	24-34	15-25	√	√	√

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIG 80SG)

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/SA welding.

Customer packing on request.

