

RAAJER 80S -D2

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

CLASSIFICATION : AWS/SFA-5.28: ER80S-D-2

CHARACTERISTICS : Copper coated solid wire for all position
Welding, 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.

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
0.07-0.12	1.60-2.10	0.50-0.80	0.025 Max	0.025 Max	0.50 Max
Ni	Mo				
0.15 max.	0.40-0.60				

ALL WELD MECHANICAL PROPERTIES (UNDER CO₂ GAS SHIELD)

YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT
470 Min.	550 Min.	17.0 Min.	Minus 30 ⁰ C : 27 J Min

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIG 90SG)

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	0.047	150-300	24-34	15-25	√	√	√
1.60	0.0625	200-350	26-36	15-30	√	√	

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIG 90SG)

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.