

## RAAJMIG-S2

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

**CLASSIFICATION** : AWS : SFA/A 5.18: ER70S-2  
DIN 8559 SG1

**CHARACTERISTICS** : Copper coated Triple oxidized solid mild steel wire, smooth flow, stable arc and minimum spatter under optimum welding conditions. Gives radiographic quality welds.

**APPLICATION** : Suitable for welding structural steel, pressure vessels and boilers involving unalloyed and micro alloyed structural steels with specified tensile strength upto 520 N/mm<sup>2</sup> to meet sub-zero impact requirements down to -51°C.

**SHIELDING GAS** : MIG welding with CO<sub>2</sub> gas and Ar+ CO<sub>2</sub> gas mixture  
TIG welding with Argon gas

#### CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Cu
0.07 max.	0.90-1.40	0.40-0.70	0.035 Max	0.025 Max	0.50 Max
Ti	Zr	Al			
0.05-0.15	0.02-0.12	0.05-0.15			

#### ALL WELD MECHANICAL PROPERTIES (UNDER CO<sub>2</sub> GAS SHIELD)

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL %	CHARPY "V" NOTCH IMPACT AT
420 Min.	510 Min.	22.0 Min.	Minus 30 <sup>0</sup> C : 27 J Min

#### DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIG S2)

Customer packing on request.

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