

RAAJSAW-1

Copper coated continuous solid Mild steel wire for SA welding.

CLASSIFICATION : AWS: SFA/A 5.17 EL8
DIN 8557: S2

CHARACTERISTICS : Copper coated mild steel solid wire
for welding of mild and medium carbon structural's steels, unalloyed
steels in combination with agglomerated SAW flux.

APPLICATION : Suitable for welding continuously mild steels and low carbon
Structural's steels etc.

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Cu
0.10 Max.	0.25-0.60	0.07 Max	0.030 Max	0.030 Max	0.35 Max

All Weld Metal Chemical composition (Typical %)

Under Fluxes	C	Mn	Si	S	P
Raajmelt-1	0.085	1.10	0.55	0.016	0.020
Raajmelt-2	0.095	1.20	0.45	0.015	0.018

All Weld Metal Mechanical properties (Typical)

Under Fluxes	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT	
				0°C	-20°C
Raajmelt-1	450	530	28	60 J	-----
Raajmelt-2	460	555	26	80 J	60 J

DIEMENSION, CURRENT CONDITION

Size(mm)	Size(inch)	Current Condition Amps.(DC+)	Voltage (V)	Electrodes Extension	Travel speed (mm/sec.)±0.5
2.0	5/64"	300-400	26-29	13-19	5.5
2.4/2.5	3/32"	350-450	27-30	19-32	6.0
3.2	1/8"	425-525	27-30	25-38	6.5
4.0	5/32	475-575	27-30	25-38	7.0

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

Packing Specification : Normally supplied in spool form (On MS former)

Inner dia : 300 mm

Width : 100 mm

Weight : 25 Kgs Approx

MS bobbin DIN-630 : 250 kgs. Approx.

Drum Pack : 600 kgs. Approx

Customer packing on request.