

## RAAJSAW-2

### Copper coated continuous solid Semi Killed wire for SA welding.

**CLASSIFICATION** : AWS: SFA/A 5.17 EM12K  
DIN 8557: S2Si

**CHARACTERISTICS** : Copper coated medium Manganese alloyed steel solid wire for welding of mild, medium and high tensile steels, unalloyed steels in combination with agglomerated SAW flux.

**APPLICATION** : Suitable for welding continuously weld pipes, thicker steel section, LPG cylinders etc.

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

C	Mn	Si	S	P	Cu
0.050-0.15	0.80-1.25	0.10-0.35	0.030 Max	0.030 Max	0.35 Max

#### All Weld Metal Chemical composition (Typical %)

Under Fluxes	C	Mn	Si	S	P
<b>Raajmelt-1</b>	0.080	1.40	0.50	0.016	0.020
<b>Raajmelt-2</b>	0.080	1.60	0.35	0.014	0.021

#### All Weld Metal Mechanical properties (Typical)

Under Fluxes	YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL %	CHARPY "V" NOTCH IMPACT AT	
				-20°C	-30°C
<b>Raajmelt-1</b>	440	520	26	50 J	-----
<b>Raajmelt-2</b>	480	550	24	80 J	50 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.