

RAAJSAW-3

Copper coated continuous solid wire for SA welding.

CLASSIFICATION : AWS: SFA/A 5.17 EH14

CHARACTERISTICS : Copper coated Manganese alloyed semi-killed solid wire for Submerged Arc welding of medium and high tensile steels.

APPLICATION : Suitable for welding Medium and high tensile steels.

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Cu
0.10-0.20	1.70-2.20	0.10 Max.	0.030 Max	0.030 Max	0.35 Max

All Weld Metal Chemical composition (Typical %)

Under Fluxes	C	Mn	Si	S	P
RAAJMELT-3	0.15 Max.	1.30-1.75	0.40 Max.	0.040 Max.	0.040 Max.

All Weld Metal Mechanical properties (Typical)

Under Fluxes	YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT	
				-20°C	-30°C
RAAJMELT-3	400-480	480-650	22-28	60 J	40 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)

Weight : 25 Kgs

Drum Pack: ~600 kgs

Customer packing on request.