

RAAJSAW-A1

Copper coated continuous solid wire for SA welding.

CLASSIFICATION : AWS: SFA/A 5.23 EA1

CHARACTERISTICS : RAAJSAW-A1 is used for submerged arc welding unalloyed And low alloy steels with impact requirements higher than Those obtainable with mild steel filler wires.

APPLICATION : Suitable for welding two run technique with medium and high Tensile steels.

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S&P	Mo	Cu
0.05-0.15	0.65-1.00	0.20 Max.	0.025 Max	0.45-0.65	0.35 Max

All Weld Metal Chemical composition (Typical %)

Under Fluxes	C	Mn	Si	S&P	Mo
Raajmelt-2	0.08 Max.	1.10 to 1.60	0.60 Max.	0.040 Max.	0.45
Raajmelt-Spl	0.10 Max.	1.30 to 1.75	0.50 Max.	0.040 Max.	0.50

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-2	460	540	26	40 J	35 J
Raajmelt-Spl	480	580	25	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)

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.