

SAW-EL12

Copper coated continuous solid Mild steel wire for SA welding.

CLASSIFICATION : AWS: SFA/A 5.17 EL12

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
0.040-0.14	0.25-0.60	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-1	0.12 Max.	1.00 to 1.40	0.25 to 0.55	0.040 Max.	0.040 Max
Raajmelt-2	0.10 Max	1.10 to 1.60	0.60 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	
				0°C	-20°C
Raajmelt-1	440	535	26	50 J	-----
Raajmelt-2	480	565	25	70 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.