

RAAJMIG-1

Copper coated continuous or cut length solid wire for TIG/MIG welding.

CLASSIFICATION :AWS/SFA-5.18 : ER70S-6
 DIN 8559 : SG2
 IS 6419-1971 : Gr-S4

CHARACTERISTICS :Copper coated double oxidized solid wire for all position CO₂ welding. The special characteristics are smooth and stable arc low spatter Thin and uniform copper coating ensure good Conductivity useful for high speed feeding.

APPLICATION : Suitable for welding structural steel sheet metal Carbon steel and low alloy steels for high finish, precision and better productivity.

SHIELDING GAS : Welding with CO₂ gas and Ar+ CO₂ gas mixture.

CHEMICAL COMPOSITION % (solid wire chemistry)

C	Mn	Si	S	P	Cu
0.070-0.15	1.40-1.85	0.80-1.15	0.035 Max	0.025 Max	0.50 Max

ALL WELD MECHANICAL PROPERTIES FOR MIG (UNDER CO₂ GAS SHIELD)

YS (N/mm ²)	UTS (N/mm ²)	EL %	CHARPY "V" NOTCH IMPACT AT
420-480.	510-610	22-32	Minus 20 ⁰ C : 70-90 J Minus 30 ⁰ C : 40-60 J

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJMIG-1)

Size(mm)	Size(inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min.	Spool packing 12.5 kg.	Spool packing 15 kg	Drum packing 100/200kg
0.60	0.023	40-100	16-20	10-15	√	√	X
0.80	0.031	60-180	16-24	10-20	√	√	√
0.90	0.035	60-180	16-28	10-20	√	√	√
1.00	0.039	80-220	18-28	10-25	√	√	√
1.20	0.047	120-300	24-34	15-25	√	√	√
1.60	0.062	150-350	24-36	15-30	√	√	√

DIEMENSION, CURRENT CONDITION & PACKING DATA (RAAJTIG-1)

Size(mm)	Size(inch)	Length (mm)	Length (inch)	Current Condition (DC+)	Voltage (V)	Tube packing 5 kg	Box packing 20 kg
1.60	1/ 16"	1000	36"	80-110	10-16	√	√
2.0	5/ 64"	1000	36"	100-150	12-18	√	√
2.4/ 2.5	3/ 32"	1000	36"	130-180	14-20	√	√
3.2	1/ 8"	1000	36"	150-220	16-24	√	√
4.0	5/ 32"	1000	36"	200-280	18-28	√	√

Customer packing on request.