

**MIG/MAG WELDING  
WIRES**

TECHNICAL SPECIFICATION SHEET

**Co<sub>2</sub> Mig Welding Wire**

Sizes (mm) :  
0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60, 2.00

Grades :  
AWS - 5.18 ER 70S 6,  
IS - 6419 S-4  
EN – 440 G 46 3 M G4 Si 1

Packing :  
100% Precision Layer Winded in Plastic Spools  
5 kg / 12.5 kg / 15 kg  
Fibre Drum Pack. :- 100 kgs / 250 kgs



Applications :  
Automobile Body, Chassis, Frames and Brackets  
Automobile Silencers, Petrol/Diesel/Gas Tanks & all other Automobile, Scooter, Cycle spare parts & accessories, LPG Gas Cylinders, Compressors, Railway Wagons, Boilers, Poles & Steel Towers. Steel furniture, Scaffoldings, Gratings & all other welding in steel fabrication

**WELDING CURRENT SETTINGS AND PARAMETERS**

S.No	SIZE in MM	CURRENT (DC+) AMPS	CURRENT (DC+) VOLTS	GAS FLOW L/M
1	Ø 0.60	50 -- 150	18 -- 25	10 -- 25
2	Ø 0.80	50 -- 180	18 -- 25	10 -- 25
3	Ø 0.90	80 -- 200	18 -- 25	10 -- 25
4	Ø1.00	80 -- 200	20 -- 26	12 -- 20
5	Ø1.20	130 -- 300	22 -- 36	15 -- 25
6	Ø1.60	200 -- 400	24 -- 38	16 -- 28

**CHEMICAL COMPOSITION OF WELD METAL**

C %	Mn %	Si %	S %	P %	Cr %	Ni %	V %	Mo %	Cu %
0.06--0.15	1.40--1.85	0.80--1.15	0.035	0.025	0.15	0.15	0.03	0.15	0.5
Note :- Single values mentioned above are maximum*									

**MECHANICAL PROPERTIES OF WELD METAL**

U.T.S (N/mm <sup>2</sup> )	Y .S. (N/mm <sup>2</sup> )	ELONGATION (L = 4d)%	IMPACT (CVN) AT -30°C
490	400	22	27 J
Note :- Single values mentioned above are Minimum.			

\*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- [info@rasielectrodes.com](mailto:info@rasielectrodes.com)

storage - Store in warm and dry place.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

[www.rasielectrodes.com](http://www.rasielectrodes.com)