

GMAW - MS & CS SOLID FILLER WIRE

RASI CO₂

MIG/MAG WELDING

CLASSIFICATIONS

AWS-A5.18 ER70S-6
IS 6419 - 96 : Grade S-3
IRS M 46 - 2020 **Class -I**

CHARACTERISTICS :

RASI - CO₂ is a double deoxidized Copper coated Mn - Si wire for GMAW using CO₂ or 80% Ar, 20% CO₂ mixtures for shielding of welded Metal. The Weld metal is of Radiographic Quality.

APPLICATIONS :

RASI - CO₂ is all position and is used for :

- ◆ Welding of all sheet metal and structural steels.
- ◆ Carbon & Low alloy steels
- ◆ Pressure vessels etc.

CHEMICAL COMPOSITION OF WIRE :

ELEMENTS	C	Mn	Si	S	P	Cu
PERCENTAGE	0.07 - 0.15	1.00 - 1.5	0.65 - 0.85	0.025	0.025	0.2 - 0.4

All single values are Maximum %

MECHANICAL PROPERTIES OF ALL WELD METAL (Under CO₂)

U.T.S. (N/mm ²)	Y.S (N/mm ²)	ELONGATION (%) on 5 x d GL	CVN-IMPACT
510	350	26	at -20°C 47J

All single values are Minimum Requirement

WELDING CURRENT : DC(+)

Size	0.8 mm	1.00mm	1.2 mm	1.6 mm
Current (A)	80 - 250	80 - 260	160 - 290	160 - 350
Voltage	18 - 25	18 - 26	20 - 30	20 - 35

Note : Current & Voltage may change depends on welding parameter & Shielding gas.

PACKING : Spools (Layer Winding)
SIZE : 300 mm x 50 mm x 100 mm
WEIGHT : 15 Kg net / 12.5 Kg (Gross)

Precautions :

Use short arc during welding. Storage the wire in dry condition.

Approvals : IBR, Schwing Stetter, BHEL, RDSO