

Superior Quality Flux Cored Arc Welding Wire



The flux cored arc welding process was introduced in early 1950. It is a modification of MIG/MAG welding process, in which solid wire is replaced by a flux cored electrode.

We manufacture polished, clean, precision layer wound flux cored arc welding wires. The material is manufactured to the ultimate quality standards and the wire diameter, cast diameter, helix and tensile strength are engineered to precise tolerances. The wire is specially cleaned to ensure perfect "pay-off" and feed, and to avoid weld contamination.

RAAJRATNA offers you a complete range of global standard flux cored arc welding wire to suit your specific needs. Our wire products are manufactured at latest state of the art manufacturing plant.



Raajratna
electrodes pvt. ltd.

An ISO 9001:2008 Company and Government Recognized Export House

Flux Cored Arc Welding Wire

Properties and Applications

| Raajratna Grade & Classification | Typical Chemical Composition of Weld Metal Elements (% by Weight) | | | | | | | | Typical Mechanical Properties of Weld metal | | | | | Heat Treatment | Applications |
|--|---|------|------|---------------|---------------|------|------|------------|---|--------------------------|------------|-----------------|-------------------|------------------|---|
| | C | Mn | Si | S | P | Cr | Ni | Mo | YS N/mm ² | UTS N/mm ² | % Elong | Impact | | | |
| | | | | | | | | | | | | J | Temp. °C | | |
| RAAJCORED 70 AWS 5.20 E 70 T-1/1M | 0.060 | 1.55 | 0.55 | 0.030 max. | 0.030 max. | --- | --- | --- | 560 | 600 | 28 | 50 90 | -20 0 | --- | Metal type FCW for H, H-fillet welding. |
| RAAJCORED 71 AWS 5.20 E 71 T-1/1M | 0.055 | 1.42 | 0.58 | 0.030 max. | 0.030 max. | --- | --- | --- | 550 | 620 | 26 | 50 90 | -20 0 | --- | Titania type FCW for all welding position of mild steel and suitable for high tensile upto 600 N/mm ² . |
| RAAJCORED 71 (Spl) AWS 5.20 E 71 T-5/5M | 0.058 | 1.40 | 0.65 | 0.015 | 0.020 | --- | --- | --- | 460 | 550 | 30 | 75 90 125 | -50 -40 -20 | 650°C x 2hrs. | Basic type FCW for heavy fabrication of mild steels with superior toughness and crack resistance. |
| RAAJCORED 81 AWS 5.29 E 81T1-Ni1/Ni1M | 0.050 | 1.25 | 0.40 | 0.016 | 0.018 | --- | 0.98 | 0.25 | 600 | 660 | 25 | 60 100 | -40 -20 | --- | Welding suitable for steel frames, bridges, pressure vessels and welding upto 600 m/mm ² high tensile steels. |
| RAAJCORED 81 W AWS 5.29 E 81T1W2 | 0.050 | 1.05 | 0.65 | 0.018 | 0.020 | 0.50 | 0.60 | Cu 0.50 | 600 | 650 | 27 | 75 | -30 | --- | Welding for upto 600 N/mm ² tensile strength weather proof steel for structures, buildings, vehides and bridges. |
| RAAJCORED 81 B2 AWS 5.29 E 81T1-B2 | 0.065 | 0.65 | 0.60 | 0.020 | 0.022 | 1.30 | --- | 0.55 | 560 | 625 | 24 | --- | --- | 620°C x 1hrs. | Suitable FCW wire for welding of 1.00%Cr-0.50%Mo low alloy steel. |
| RAAJCORED 91 B3 AWS 5.29 E 91T1-B3 | 0.060 | 0.60 | 0.52 | 0.018 | 0.020 | 2.25 | --- | 1.05 | 580 | 670 | 20 | --- | --- | 620°C x 1hrs. | Suitable FCW wire for welding of 2.25%Cr-1.00%Mo low alloy steel. |

SPOOL PACK : Layer wound on D-300 plastic spools

Standard Sizes :

| Diameter in mm | Diameter in inch | Plastic Spools | | Metal Baskets |
|-------------------|---------------------|------------------------|-------|------------------------|
| | | D-300 | D-200 | K-300 |
| 1.2 | 0.047 | 12 Kgs to 15 Kgs | 5 Kgs | 12 Kgs to 15 Kgs |
| 1.4 | 0.055 | | | |
| 1.6 | 0.062 | | | |

Identification : Each spool and carton is labeled with type (grade), size, quantity and batch / lot number.

We can also supply drum pac in 100 Kgs & 250 Kgs.



Raajratna Electrodes Pvt. Ltd.

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Manufacturer-Exporter of Welding Consumables

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