

ROYAL ARCPRO-8

COPPER COATED CONTINUOUS SOLID MILD
STEEL WIRE FOR SA WELDING

AWS: SFA/A 5.17 EL8
DIN 8557: S2

KEY FEATURES:

Copper coated mild steel solid wire for welding of mild and medium carbon structural' s steels, unalloyed. steels in combination with agglomerated SAW flux

APPLICATIONS

- Suitable for welding continuously mild steels and low carbon Structural' s steels and pipe welding etc

CHEMICAL COMPOSITION: (SOLID BARE WIRE CHEMISTRY)

C	Mn	Si	S	P	Cu
0.10 max.	0.25-60	0.070 max.	0.030 max.	0.035 max	0.035 max

CHEMICAL COMPOSITION:

Under fluxes	C	Mn	Si	S	P
ROFLX-1	0.085	1.10	0.55	0.016	0.020
ROFLX-2	0.095	1.20	0.45	0.015	0.018

MECHANICAL PROPERTIES:

Under fluxes	YS (N/mm2)	UTS (N/mm)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @ 0°C- 20°C	
ROFLX-1	450	530	28	60 J	-----
ROFLX-2	460	555	26	80 J	60 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

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

PACKING SPECIFICATION

- 1.On MS former: - 25.00 kgs approx. (ID-300mm, W-100mm).
- 2.MS bobbin: - 250 kgs. approx.
- 3.Drum Pac: - 600 kgs. approx.