



## COPPER COATED SOLID WIRE FOR MIG/CO2 WELDING

### CHARACTERISTICS :

"Premier" MIG wires are copper coated solid Steel wires suitable for continuous welding for general purpose fabrication on low to medium carbon steels. These wires are manufactured by wet drawing and special coppersing process ensuring longer shelf life, easy feed and current pick up. The Random/Layer Wound wire gives uniform and sound weld metal deposit.

### APPLICATION :

Mild and structural steels with Tensile Strength up to 55 kg/mm<sup>2</sup>

### CLASSIFICATION :

IS 6419-1996 Grade S4      AWS A5-18 : ER70S-6  
BS 2901 : A-18              DIN 8559 : SG2

### WIRE CHEMISTRY (%) :

C	SI	Mn	S	P
0.06-0.12	0.80 to 1.15	1.40 to 1.60	0.025 Max	0.025 Max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm <sup>2</sup>	Yield Strength Kg/mm <sup>2</sup>	Elongation % (L=5d)	CVN Impact Value at - 29 °C. Kgfm
Minimum Required Values:			
51	42.8	22	2.80
Typical Values:			
57.8	46.9	31	6.40

### WELDING CURRENT AND PACKING DATA :

Wire Dia. mm	0.8	1.0	1.2	1.6
Current Amps.	50-180	75-200	90-300	180-500
Welding Position	Downhand / Horizontal / Vertical			
Spool Size	300 mm OD X 50.5 mm ID x 103 mm Width			
Net Weight	12.50/15.00 kgs. per Spool.			



## COPPER COATED SOLID WIRE FOR MIG/CO2 WELDING (JUMBO PAC)

### CHARACTERISTICS :

"Premier" Jumbo Pac wires are copper coated solid steel wires particularly suitable for robotic welding. "Premier" wires are of unsurpassed quality & deposit excellent quality weld metal at high deposition rates. Labour and overhead are the most expensive factors in a welding operation, usually comprising more than 50% of the total cost. Welding with Jumbo Pac wires provides an immediate means of cost reduction without an exorbitant investment in equipment. Whether you are using wire on spools or bulk pack from other sources, it is easy to change to Jumbo Pac. The only accessories you will need are a wire conduit attachment, wire conduit & a quick connector. "Premier" Jumbo Pac wires are manufactured by special coppersing process ensuring longer shelf life, easy feed & current pickup.

### APPLICATION :

Mild and structural steels with Tensile Strength up to 55 kg/mm<sup>2</sup>

### CLASSIFICATION :

IS 6419-1996 Grade S4      AWS A5-18 : ER70S-6  
BS 2901 : A-18              DIN 8559 : SG2

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

Ultimate Tensile Strength Kg/mm <sup>2</sup>	Yield Strength Kg/mm <sup>2</sup>	Elongation % (L=5d)	CVN Impact Value at - 29 °C. Kgfm
57	48	27	6.50

### TYPICAL WIRE CHEMISTRY (%) :

C	SI	Mn	S	P
0.07	0.95	1.52	0.017	0.020

### WELDING CURRENT AND PACKING DATA :

Wire Dia. mm	0.8	1.0	1.2	1.6
Current Amps.	50-180	75-200	90-300	180-500
Welding Position	Downhand / Horizontal / Vertical			
Drum Size	510 x Height 790 mm for 250 kg.			
Net Weight	100 kg and 250 kg drums.			

