



MODI MAG 1

CO₂ WELDING WIRE

CLASSIFICATION : IS : 6419-1996 : GRADE S4-C504
AWS/A 5.184 : ER 70S-6

APPROVAL : DNV, IRS

CHARACTERISTICS : Double deoxidised copper coated Mn-Si wire suited for Gas Metal Arc Welding in all position for mild and fine grained steels. Produce weld with excellent radiographic qualities. Thin and uniform copper coating ensures good electrical contact, reduces friction during high speed feeding and obviates corrosion possibilities.

APPLICATIONS :

- Suitable for Welding of Sheet-Metal
- Carbon Steels and Low Alloy Steels
- High Finish, Precision and Better Productivity

WIRE COMPOSITION (%) :

	C	Mn	Si	S	P	Cu
	0.07-0.12	1.4-1.85	0.8-1.15	0.025 max	0.025 max	0.50 max

HARDNESS : CARBON DIOXIDE (CO₂)

MECHANICAL PROPERTIES OF ALL WELD-METAL :

	Yield Strength	Ultimate Tensile Strength	Elongation (%)	Reduction in Area (%)	CVN Impact Values(min) at 27°C/-30°C
	N/mm ²	N/mm ²	(%)	(%)	Joules
	420	500	22	55	100/28
	min	min	min	min	

CURRENT CONDITIONS : USE DC (+) ONLY

Size (mm)	0.8	1.0	1.2	1.6
Range (Amps.)	100-200	140-240	180-280	200-360



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