

Applications

Suitable for welding of structural steel with tensile strength up to 540N/mm², welding of automobile bodies, bridges ship containers railway rolling stock, bogies, storage tanks and general structural fabrication works.

Characteristics on Usage

Royal – 70S-3 wire is a copper coated solid wire for Co₂ welding for general engineering and structural application. It gives spatter free welding with Co₂ gas and Ar+Co₂ gas mixtures The weld deposit is free from porosities with smooth and uniform weld bead.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cu %
0.06 – 0.15	0.90 – 1.40	0.40 – 0.75	0.035 Max	0.025 Max	0.50 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 20°C (J)
490	400	22	27

Packing and Welding Current

SIZE (mm)	Current (Amps)	In Amps	In Volts	GAS FLOW L/M
0.8	DC (+)	50 - 160	18 - 25	10 - 25
1.0		80 – 200	20 – 26	12 – 20
1.2		110 – 250	22 – 36	15 – 25
1.6		200 - 400	24 - 38	16 - 28

Packing

Standard plastic spool of 300 mm dia and weight 12.5/15kg sealed in an air tight polythene bag and then packed in a corrugated box. Silica gel drying agent provided inside to prevent moisture pick up and increase shelf life.

We can also manufacture wire according to customer requirements.