

# ROMIG-45

COPPER COATED OR WITHOUT COATED CUT  
LENGTH SOLID WIRE FOR OXYFUEL WELDING

BASIC ALLOY: FE, MN,  
AWS: SFA/A 5.2 RG45

## KEY FEATURES:

RG45 is a copper coated low carbon steel rod which is widely used for oxyfuel welding on mild steel. It has good ductility and good machinability. Its typical minimum weld tensile strength is 45 ksi and it conforms to AWS A5.2.

## APPLICATIONS

- suitable for tensile strength requirement of the steel does not exceed 300 N/mm<sup>2</sup>.
- welding sheet and pipe where high strength is not required.

## SHEILDING GAS:

- Oxyfuel Gas

## CHEMICAL COMPOSITION:

| C          | Mn        | Si        | S         | P          | Cu       |
|------------|-----------|-----------|-----------|------------|----------|
| 0.080 Max, | 0.50 Max. | 0.10 Max. | 0.040 Max | 0.035 Max. | 0.30 Max |

## MECHANICAL PROPERTIES:

| YS (N/mm <sup>2</sup> ) | UTS (N/mm <sup>2</sup> ) | EL % (l=5d) | CHARPY "V" NOTCH<br>IMPACT @ |
|-------------------------|--------------------------|-------------|------------------------------|
| 270 min.                | 300 min.                 | 22 min.     | 0C : 27-50 J                 |

## WELDING POSITION



Welder's First Choice

## DIEMENSION, CURRENT CONDITION & PACKING DATA ( FOR TIG WELDING)

| Size (mm) | Size (inch) | Length (mm) | Length (Inch) | Current Condition (DC-) | Voltage (V) | Tube packing 5 kg | Box packing 20 kg |
|-----------|-------------|-------------|---------------|-------------------------|-------------|-------------------|-------------------|
| 1.60      | 1/ 16"      | 1000        | 36"           | 40-80                   | 10-16       | ✓                 | ✓                 |
| 2.0       | 5/ 64"      | 1000        | 36"           | 50-100                  | 12-18       | ✓                 | ✓                 |
| 2.4/ 2.5  | 3/ 32"      | 1000        | 36"           | 60-120                  | 14-20       | ✓                 | ✓                 |
| 3.2       | 1/ 8"       | 1000        | 36"           | 100-150                 | 16-24       | ✓                 | ✓                 |
| 4.0       | 5/ 32       | 1000        | 36"           | 140-200                 | 18-28       | ✓                 | ✓                 |