



Approved by  
R. D. S. O  
IRS CLASS - I  
L & T

**ANAND MIG-1**

Copper Coated  
MIG Welding Wire

## Description

ANAND MIG-1 is a double deoxidised Copper Coated MIG Welding Wire for general engineering and structural applications. The cast, helix tensile strength and chemistry of the wire are controlled to yield high quality welds with least spatter.

## Typical Applications

It is ideally suited for continuous welding of unalloyed and structural steels. Finds extensive use in the automobile and container industry. Also used for welding bicycle frames. Railways bogies earth moving equipments etc.

## Classifications

AWS : A 5.18 ER 70S - 6  
IS : 6419

## Welding Current (Amps.)

DC (+)

Size (mm)	0.8	1.0	1.2	1.6
Amps	50 - 160	80 - 200	110 - 250	200 - 400

## Weld Metal Analysis (%)

C	Mn	Si	S	P
0.08	1.50	0.80	0.016	0.018

## Typical Mechanical Properties

UTS (mpa (N/mm <sup>2</sup> ))	YS (mpa (N/mm <sup>2</sup> ))	EL %	CVN Impact at - 30°C (Kg/m)
585	455	26.0	5.0

## Packing Specifications

Spool of 12.5 Kg. Nett. Wt. In Moisture resistant packing  
Drum Packing available.

**ANAND ARC LTD.**

**(AN ISO 9001 COMPANY)**

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**ANAND MIG-4**  
Low Alloy Steel Wire for  
Gas Shielded Arc Welding

**Technical Data**

**Description:** ANAND MIG - 4 contain a high level of deoxidizers (Mn and Si), to control porosity when welding with CO2 as the shielded gas and molybdenum for increased strength. It will give radio graphic quality welds with excellent bead appearance in both ordinary and difficult-to-weld carbon and low alloy steels.

**Typical Application:** The combination of weld soundness and strength marks ANAND MIG - 4 suitable for single and multiple pass welding of verity of carbon and low alloy steels.

**Classification:** AWS: A5.28 ER 90SD2

<b>Welding Current (Amps) AC/DC (+)</b>	0.8mm 50-160	1.0mm 80-200	1.2mm 110-250	1.6mm 200-400
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Chemical Analysis (%)	C	Mn	Si	Mo	Cu	S	P
	0.07 to 0.12	1.60 to 2.10	0.50 to 0.80	0.40 to 0.60	0.20 to 0.40	0.025 max	0.025 max

<b>Mechanical Properties Of All Weld Metal</b>	UTS N/mm2 620MPa (min)	Y.S N/mm2 540MPamin	% EL L=5d 17 min	CVN Impact at -29°C=27J(min) -20°C=47J(min)
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**Packing Specification** Spool of 12.5 Kg. Nett. Wt. In moisture resistant packing.

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**ANAND TIG-2**  
Copper Coated cut length solid  
wire for TIG welding

**Technical Data**

**Description:** **ANAND TIG - 2** is a triple deoxidised (silicon, manganese, aluminum) mild steel wire. It will give radiographic quality welds with minimum spatter and smooth flow, stable arc under optimum conditions.

**Typical Application:** **ANAND TIG-2** is recommended for high quality pipe welding of mild and medium tensile steels and is ideal for root passes in thick walled material.

**Classification:** AWS: A5.18 ER 70S-2

**Sizes :** 1.60mm 2.00mm 2.50mm 3.15mm 4.00mm

**Typical Wire Analysis (%)**

C	Mn	Si	S	P	Cr	Mo	Ni	Cu	V	Ti	Al	Zr
0.07	0.9	0.40	0.035	0.025	0.15	0.15	0.15	0.50	0.03	0.05	0.05	0.02
Max	1.40	0.70	Max	Max	Max	Max	Max	Max	Max	0.15	0.15	0.12

**Typical Mechanical** UTS : 480 Mpa (N/mm<sup>2</sup>)

YS : 400 Mpa (N/mm<sup>2</sup>)

**Properties of Weld Deposit** Elongation % (I=5d) : 27

CVN Impact at -30° C : 60 Joules

**Packing Specification:** 500 and 1000mm cut length Packed in 5.0 kgs plastic corrugated tube.

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ANAND TIG-3  
Copper Coated Solid Wire  
For TIG Welding

Technical Data

**Description:** ANAND TIG - 3 is Copper coated carbon steel that contains well Balanced levels of manganese and silicon and is designed for use with various gas mixtures such as 100% CO<sub>2</sub>, 75/25 Ar/CO<sub>2</sub>, or 98/2 Ar/O<sub>2</sub>. Yielding a slag free quality weld deposit, a smooth stable arc with low spatter and smooth flow.

**Typical Application:** Extensive use in the automotive structure, frame fabrication, construction equipments, pressure vessels, pipe fabrication, railcar construction and repair and also used in high speed robotic, automatic and semi automatic welding application.

**Classification:** AWS: A5.18/ER70S3

**Sizes** 1.60mm 2.00mm 2.50mm 3.15mm 4.00mm

**Chemical Analysis (%)**

C	Mn	Si	S	P	Cr	Ni	Mo	V	Cu
0.06-0.15	0.90-1.40	0.45-0.75	0.035 Max	0.025 Max	0.15 Max	0.15 Max	0.15 Max	0.03 Max	0.50 Max

**Mechanical Properties Of All Weld Metal**

UTS	Y.S	% Elongation	CVN
N/mm <sup>2</sup>	N/mm <sup>2</sup>	I=5d	at -20°C
480MPa (min)	400MPamin	22 min	27J min

**Packing** 500 and 1000mm cut length Packed in 5.0 kgs plastic corrugated tube.

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