



# MODI MAG 1

## CO<sub>2</sub> 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 (CO<sub>2</sub>)

**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 <sup>2</sup>	N/mm <sup>2</sup>	(%)	(%)	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



**MODI ARC ELECTRODES CO.**  
Modinagar - 201 204 (U.P.)  
Fax : 01232 - 242147  
Phone : (01232) 325700, 325925, 243912  
E-mail : modiarc@ndb.vsnl.net.in  
Web Site : www.modielectrodes.com