

# ROMIG-60

BASIC ALLOY: FE, MN, SI,  
AWS: SFA/A 5.2 RG60

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

## KEY FEATURES:

RG60 is a high strength steel rod which is used for oxyfuel welding on castings, steel plates, structural pipe and shapes with a minimum weld deposit strength of 60 ksi. RG60 conforms to AWS A5.2 R 60.

## APPLICATIONS

- suitable for tensile strength requirement of the steel does not exceed 400 N/mm<sup>2</sup>.
- welding on castings, steel plates, structural pipe and shapes

## SHEILDING GAS:

- Oxyfuel Gas

## CHEMICAL COMPOSITION:

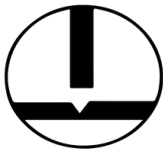
C	Mn	Si	S	P	Cu
0.15 Max,	0.90-1.35	0.10-0.35	0.035 Max	0.035 Max.	0.30 Max

## MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=5d)	CHARPY "V" NOTCH IMPACT @
370 min.	400 min.	22 min.	Minus 30C : 47J min.

## WELDING POSITION

1G/1F



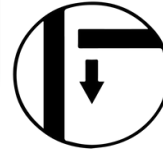
2G/2F



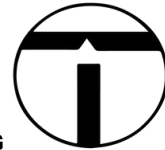
3G UP



3G DOWN



4G



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	✓	✓