

No	Product	AWS Coding	W I R E C H E M I S T R Y (%)															MECHANICAL PROPERTIES				APPLICATION
			C	Mn	Si	Mo	Ni	Cu	Ti	Zr	Al	S	P		Cr	Nb	V	UTS Mpa	YS MPa	Elongation	CVN Impact	
SOLID MILD STEEL WIRES FOR MIG/ MAG WELDING																						
55	MIGFAST - 1 Approvals : BHEL Trichy, NPCIL, M. N. Dastur & Co., Thermax, IBR (CIB Maharashtra)	ER 70S-6	0.06-0.15	1.40 -1.85	0.80 -1.15	0.15 max	0.15 max	0.50 max	–	–	–	0.035 max	0.025 max		0.15 max	–	0.03 max	500min.	420min.	22% min	27J at -30°C	A copper coated solid Steel wire for MIG/MAG welding of carbon steels. Used in Automobile Industry, Construction and Mining Equipment, Railway Wagon and Coaches, Storage tanks, Pressure Vessels, Steel Furniture, Pipes, LPG cylinders and Structural fabrications.
56	MIGFAST - 2 Approvals : RDSO Class III (Part-I)	ER 90S-D2	0.07-0.12	1.60 - 2.10	0.50 - 0.80	0.40-0.60	0.15 max	0.50 max	–	–	–	0.025 max	0.025 max		–	–	–	620 min.	540 min.	17% min.	27J at -30°C	A copper coated MIG wire for MIG/MAGwelding of high tensile steels. Welding of SAILMA 450/450H1 steel used in CONCOR wagons is typical application for this wire. Is used for welding of high tensile steels like IS 8500 Grades 540 B, 570 B and 590B;IS 2002 Gr. III,IS 1875 Cl.
57	MIGFAST - 3	ER 70S-2	0.07 max	0.90-1.40	0.40-0.70	0.15 max	0.15 max	0.5 max	0.05-0.15	0.02-0.12	0.05-0.15	0.03 max	0.025 max		0.15 max	–	–	480 min.	400 min.	22% min.	27J at -30°C	Deoxidized copper coated mild steel wire. Structural, pressure vessels and boilers involving unalloyed and micro-alloyed structural steels. It meets HIC & SSOC test as per NACE specification.
58	MIGFAST - 4	ER 80S-D2	0.07-0.12	1.60 - 2.10	0.50-0.80	0.40-0.60	0.15 max	0.50 max	--	--	--	0.025 max	0.025 max		–	–	–	590 min.	490 min.	17% min.	27J at -30°C	A copper-coated, low-alloy, solid wire with 0.5% Mo for the GAW of creep-resistantsteels of the same type, such as pipes in pressure vessels and boilers with a working temperature of up to 500°C. It can also be used for welding low-alloy high tensile strength steels. MIGFAST-4 is usually welded with 100% Argon as the shielding gas. The mechanical properties are given in the stress-relievedcondition.
59	MIGFAST - 5	ER 90SG	0.07-0.12	1.60 - 2.15	0.50-0.85	0.40-0.65	0.15 max	0.50 max	--	--	--	0.025 max	0.025 max		–	–	–	625 min.	550 min.	18% min.	27J at -46°C	A copper-coated low-alloy steel gas-shielded welding wire. It is use for welding of high tensile strength steel, such as steel construction.
60	MIGFAST - 6	ER 80SG	0.10 max	1.80 max	0.55 max	0.50 max	0.15 max	0.50 max	--	--	--	0.025 max	0.025 max		–	–	–	600 min.	470 min.	16% min.	40J at -20°C	

SOLID CARBON MOLYBDENUM STEEL WIRES FOR MIG WELDING

61	MIGFAST-70S A1	ER 70S-A1	0.12 max	1.30 max	0.30-0.70	0.40-0.65	–	0.35 max	–	–	–	0.025 max	0.025 max		–	–	–	515 min*	400 min*	19% min*	–
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SOLID CHROMIUM MOLYBDENUM STEEL WIRES FOR MIG WELDING

62	MIGFAST - 80S B2	ER 80S-B2	0.07-0.12	0.40-0.70	0.40-0.70	0.40-0.65	0.20 max	0.35 max	–	–	–	0.025 max	0.025 max		1.20-1.50	–	–	550 min*	470 min*	19% min*	–
63	MIGFAST - 80S B6	ER 80S-B6	0.10 max	0.40-0.70	0.50 max	0.45-0.65	0.60 max	0.35 max	–	–	–	0.025 max	0.025 max		4.50-6.00	–	–	550 min***	470 min***	17% min***	–
64	MIGFAST - 80S B8	ER 80S-B8	0.10 max	0.40-0.70	0.50 max	0.80-1.20	0.50 max	0.35 max	–	–	–	0.025 max	0.025 max		8.00-10.50	–	–	550 min***	470 min***	17% min***	–
65	MIGFAST - 90S B3	ER 90S-B3	0.07-0.12	0.40-0.70	0.40-0.70	0.90-1.20	0.20 max	0.35 max	–	–	–	0.025 max	0.025 max		2.30-2.70	–	–	620 min**	540 min**	17% min**	–
66	MIGFAST - 90S B9	ER 90S-B9	0.07-0.13	1.20 max	0.15-0.50	0.85-1.20	0.80 max	0.20 max	–	–	0.04 max	0.01 max	0.01 max		8.00-10.50	–	0.15-0.30	620 min****	410 min****	16% min****	–

SOLID STAINLESS STEEL WIRES FOR MIG WELDING

67	MIGFAST 308	ER 308	0.08 max	1.00-2.50	0.30-0.65	–	9.00-11.00	–	–	–	–	–	–		19.50-22.00	–	–	550 min	–	35% min	–
68	MIGFAST 308L	ER 308L	0.03 max	1.00-2.50	0.30-0.65	–	9.00-11.00	–	–	–	–	–	–		19.50-22.00	–	–	520 Min	–	35% min	–
69	MIGFAST 347	ER 347	0.08 max	1.00-2.50	0.30-0.65	–	9.00-11.00	–	–	–	–	–	–		19.00-21.50	1.0 max	–	520 min	–	30% min	–
70	MIGFAST 316	ER 316	0.08 max	1.00-2.50	0.30-0.65	2.00-3.00	11.00-14.00	–	–	–	–	–	–		18.00-20.00	–	–	520 min	–	30% min	–
71	MIGFAST 316 L	ER 316L	0.03 max	1.00-2.50	0.30-0.65	2.00-3.00	11.00-14.00	–	–	–	–	–	–		18.00-20.00	–	–	490 min	–	30% min	–
72	MIGFAST 309	ER 309	0.12 max	1.00-2.50	0.30-0.65	–	12.00-14.00	–	–	–	–	–	–		23.00-25.00	–	–	550 min	–	30% min	–
73	MIGFAST 309L	ER 309L	0.03 max	1.00-2.50	0.30-0.65	–	12.00-14.00	–	–	–	–	–	–		23.00-25.00	–	–	520 min	–	30% min	–
74	MIGFAST 309 Mo	ER 309Mo	0.12 max	1.00-2.50	0.30-0.65	2.00-3.00	12.00-14.00	–	–	–	–	–	–		23.00-25.00	–	–	550 min	–	30% min	–
75	MIGFAST 310	ER 310	0.08-0.15	1.00-2.50	0.30-0.65	–	20.00-22.50	–	–	–	–	–	–		25.00-28.00	–	–	550 min	–	30% min	–
76	MIGFAST 312	ER 312	0.15 max	1.00- 2.50	0.30-0.65	–	8.00-10.50	–	–	–	–	–	–		28.00-32.00	–	–	660 min	–	22% min	–
77	MIGFAST 410	ER 410	0.12 max	0.60 max	00.50 max	–	–	–	–	–	–	–	–		11.50-13.50	–	–	520 min [®]	–	20% min [®]	–
78	MIGFAST 430	ER 430	0.10 max	0.60 max	00.50 max	–	–	–	–	–	–	–	–		15.50-17.00	–	–	450 min ^{®®}	–	20% min ^{®®}	–

Note : Weld Metal Properties with 100% Ar Gas Shielding. * PWHT at 620° C For 1 Hr/ ** PWHT at 690° C For 1 Hr/ *** PWHT at 745° C For 1 Hr/ **** PWHT at 760° C For 1 Hr

SOLID INCONEL WIRES FOR MIG WELDING

No	Product	Coding	W I R E C H E M I S T R Y (%)															MECHANICAL PROPERTIES			
			C	Mn	Si	Mo	Ni	Cu	Ti	Fe	Al	S	P		Cr	Nb+Ta	V	UTS MPa	YS MPa	Elongation	CVN Impact
79	MIGFAST - 625	ER NiCrMo3	0.10 max	0.50 max	0.50 max	8.0-10.0	58% min	0.50 max	0.40 max	5.00 max	0.40 max	0.015 max	0.02 max		20.0-23.0	3.15-4.15	—	760 Typical	—	—	—

Note : Weld metal properties with 100 % Ar gas shielding. [®] After PWHT at 750° C for 1 Hr, furnace cooled to 315° C and then air cooled to ambient.

^{®®} After PWHT at 770° C for 2 Hr, furnace cooled to 595° C and then air cooled to ambient.

MIGFAST wires are Supplied in 12.5 Kg or 15.0 Kg Plastic Spools



MIG / MAG WIRES

