DMRG60 - Steel / Low Alloy Rod for Oxyfuel Gas Welding

Classification: **RG60 AWS A5.2 / ASME SFA 5.2**

Characteristics & Application:

DURAMAX RG60welding rods are used for the oxyfuel gas welding of steels, where the minimum tensile strength requirement of the steel does not exceed 60 ksi (400 MPa).

DMRG60 rods have a carbon steel composition.

DMRG60 may be used to join wrought Iron and are a general purpose oxyfuel gas welding rod.

Typical Chemical Composition of Wire (%)

C	Mn	Si	S	P
0.15 max	0.90 - 1.40	0.10 - 0.35	0.035 max	0.035 max
Ni	**Cr**	**Mo**	**Al**	**Cu**
0.30 max	0.20 max	0.30 max	0.02 max	0.30 max

Typical Mechanical Properties of All-Weld-Metal.

Gas	Yield ksi/MPa	Tensile ksi/MPa Minimum	Elongation %	Notes:
OXYFUEL	----	60ksi (400 MPa)	20% min	Not Specified

Recommended Welding

DURAMAX RG60 may be used either forehand or backhand welding. Use a neutral flame or with a slight excess of acetylene. In the making of it is possible to produce a weld with a composition intermediate between those of the base metal and the filler metal.