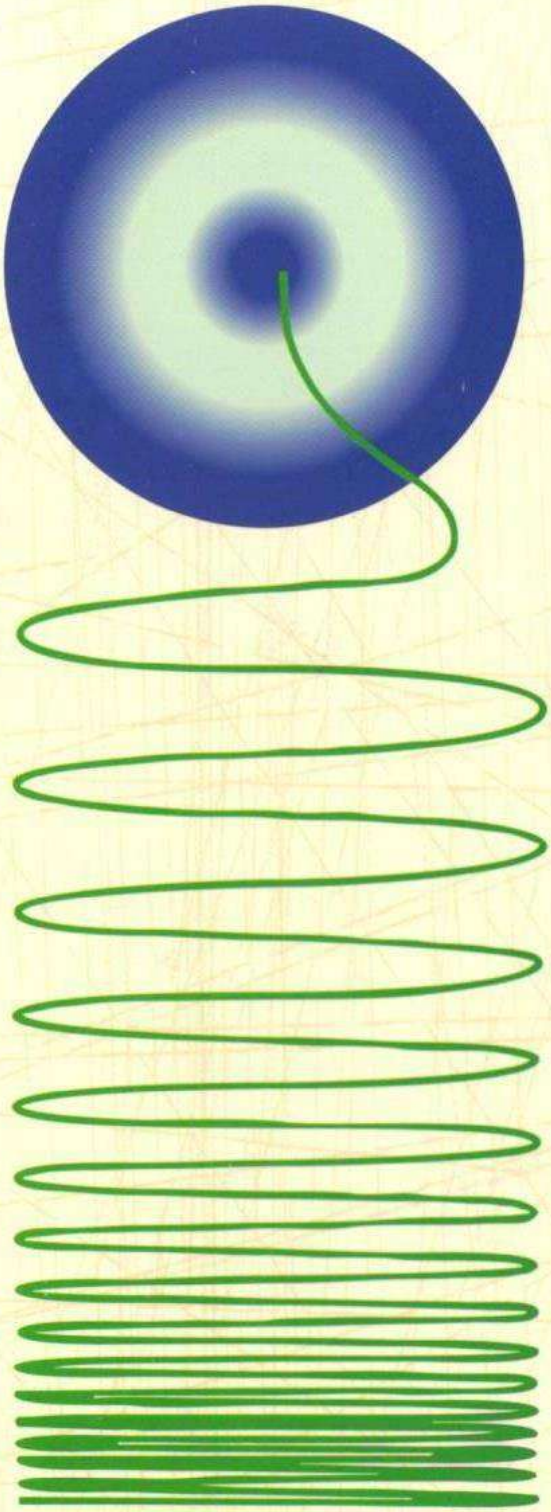

MARUTI
WELDING WIRES

Director's Message

Since the inception in 2011, MW WIRETEC has undertaken a path breaking innovation which has placed us as a leader in welding wire industry. We have carved a niche for ourselves in the Indian welding Industry and we look forward to do the same in the world market. This is not a dream, but a distant reality.

I take this opportunity to thank our valued customers whose continued patronage and confidence in our products inspire us to extend the best of services and enables us to provide value for their money.

We are committed to total customer satisfaction, by identifying their specific needs, translating them into quality products and providing dependable after sales service. This forms the foundation of our quality policy.

Our highly skilled staff is our greatest asset. They respond quickly to provide solution to our clients. We have a self-motivated team comprising of Engineers, Technicians, Quality Controllers, and Research Analysts who take care of each aspect of manufacturing.

A set of skilled workforce converts each parameter into a reality.

This catalogue is designed to reflect an extensive range of our products with the exacting standards required by today's welding industry. We would love your feedback which would enable us to provide better services.

AJAY KAPUR
MANAGING DIRECTOR
MW WIRETEC PVT LTD

MARUTI
WELDING WIRES

MARUTI
WELDING WIRES

Maruti Welding Wires are one of the leading welding consumables in the country. Extensive research and development leading to superior product quality has made us one of the premier suppliers to the industry. Quality and safety is our main concern. We provide exceptional quality meeting the requirements of all international standards. A host of customers from Power Sector, Railways, Automobiles etc. to the smallest fabricators are testimony to our quality.

BENEFITS OF MARUTI WELDING WIRES

- Special process to remove residual lubricant from wire surface to insure good feeding & arc stability.
- Copper coating that is tightly adherent to wire eliminates troublesome copper flaking.
- Higher tensile strength to insure that there are no tangles when restrictions occur in the feed system.
- Excellent spray arc at lower voltages, providing precise control of the welding process.
- Excellent surface finish reduces contact tip erosion, hence providing a sizable saving in replacement cost and down time.
- Special surface treatment prevents rusting for a prolonged period.

ADVANTAGES OF MIG WIRE OVER CONVENTIONAL ELECTRODES

- High quality welds can be produced much faster.
- Since a flux is not used, there is no chance for the entrapment of slag in the weld metal, resulting in high quality welds.
- The gas shield protects the arc so that there is very little loss of alloying elements. Only minor weld spatter is produced.
- MIG welding is versatile and can be used with a wide variety of metals and alloys.
- The MIG process can be operated in several ways, including semi and fully automatic.
- Mig wire have no absorbent coating and no moisture pickup. Hence low weld hydrogen.
- No need for drying ovens to recondition electrodes.

MARUTI
MIG WIRES

APPROVAL

RDSO : CLASS - I, BHEL, CE

CLASSIFICATION

AWS : A/SFA 5.18	: ER 70S-6
IS 6419 : 1996	: GRADE S4-C 501
EN ISO 14341-A	: G4Si1
	: G3Si1

CHARACTERISTICS

Copper coated continuous solid wire for CO_2 Welding. Suitable for all position welding. Smooth flow with stable arc and minimum spatter are its special characteristics. Thin and uniform copper coating ensures good conductivity useful for high speed feeding. Gives Excellent radiographic quality welds. Suitable for welding of sheets metal, carbon steels and low alloy steels and low alloy steels including structural steels with tensile strength upto 540 Nmm^2.

WIRE COMPOSITION %

C	Mn	Si	S	P	Cu
0.07 - 0.15	1.40 - 1.85	0.80 - 1.15	0.035 Max.	0.025 Max.	0.50 Max.

ALL WELD MECHANICAL PROPERTIES

(UNDER CO_2 SHIELD AND NORMAL WELDING CONDITIONS)

YS (N/MM^2)	U.T.S. (N/MM^2)	Elong. (GL=4D)	Charpy-V Impact Values at
400 Min.	500 - 640 mpa	22% Min.	(-30°C) > 27J

WELDING CURRENT

DC (+)

SHIELD GAS

CO_2

PACKING SPECIFICATIONS

Weight	Packing Boxes
13.5 Kg. - 15 Kg.	Supplied on Plastic spools, sealed in polythene bags and then packed in corrugated boxes.
100 Kg. - 250 Kg,	Drum Packaging

MARUTI
SAW WIRES

WT : 08
MILD STEEL SOLID ELECTRODE

APPROVAL
RDSO : CLASS - W1, CE

CLASSIFICATION
AWS A5.17 : EL 8
EN ISO 14171 - S1

CHARACTERISTICS

- A low carbon, low manganese general purpose filler wire.
- Good bead appearance and easy stag removal. Suitable for single or multiple pass welding of mild and high tensile steel.
- Useful for steel structures, ship, bridges and general fabrication.
- Best suited with our combination flux.

WIRE COMPOSITION %

C	Mn	Si	S	P	Cu
0.10 Max.	0.25 - 0.60	0.07 Max.	0.030 Max.	0.030 Max.	0.35 Max.

ALL WELD MECHANICAL PROPERTIES
(TYPICAL) WHEN USED WITH MARUTI SAW FLUX SF:08

YS (N/MM^2)	U.T.S. (N/MM^2)	Elong. (GL=4D)	Charpy-V Impact Values at
450	530	28%	(-20°C) 60 J

WELDING CURRENT DC (+)

PACKING SPECIFICATIONS

Weight	Packing
25 Kg.	2.00 MM – 4.00 MM CORELESS LAYER WOUND SPOOLS

MARUTI
SAW WIRES

WT : 12 K

MILD STEEL SOLID ELECTRODE

APPROVAL

RDSO : CLASS - W2, CE

CLASSIFICATION

AWS A5.17 : EM 12K
EN ISO 14171 - S2Si

CHARACTERISTICS

- Low carbon, medium manganese, low silicon electrode.
- Coated with proprietary surface lubricant which is designed to eliminate all contamination.
- Improved contact tip life when compared to non-copper coated wire alternatives.
- Useful for PEB, I-Beams, Pipe Mill etc.

WIRE COMPOSITION %

C	Mn	Si	S	P	Cu
0.05 - 0.15	0.80 - 1.25	0.10 - 0.35	0.030 Max.	0.030 Max.	0.35 Max.

ALL WELD MECHANICAL PROPERTIES

(TYPICAL) WHEN USED WITH MARUTI SAW FLUX SF:12

YS (N/MM^2)	U.T.S. (N/MM^2)	Elong. (GL=4D)	Charpy-V Impact Values at
450	530	24%	(-20°C) 50 J

WELDING CURRENT

DC (+)

PACKING SPECIFICATIONS

Weight	Packing
250 Kg.	1.60 MM (Drum Packing)
25 Kg.	2.00 MM - 4.00 MM (Coreless Layer Wound Spools)

MARUTI
SAW WIRES

WT : 14

H-HIGH MANGANESE STEEL ELECTRODE

CLASSIFICATION

AWS A5.17 : EH 14

CHARACTERISTICS

- AWS EH 14 is a high-manganese type welding wire.
- It matches with low-manganese and low-silicon type welding flux.
- It has excellent bead molding and slag detachability.
- Best suited with our combination flux.

WIRE COMPOSITION %

C	Mn	Si	S	P	Cu
0.10 - 0.20	1.70 - 2.20	0.10 Max.	0.035 Max.	0.030 Max.	0.35 Max.

ALL WELD MECHANICAL PROPERTIES

(TYPICAL) WHEN USED WITH MARUTI SAW FLUX

YS (N/MM^2)	U.T.S. (N/MM^2)	Elong. (GL=4D)	Charpy-V Impact Values at
400 - 480	480 - 650	22% - 28%	(-20°C) 50 J

WELDING CURRENT

DC (+)

PACKING SPECIFICATIONS

Weight	Packing
25 Kg.	2.50 MM - 5.00 MM (Coreless Layer Wound Spools)

APPROVAL

RDSO : CLASS - F1

CLASSIFICATION

GB/T5263 F4A0-H08A
GB/T5293 F5A2-H08MnA

CHARACTERISTICS

- Welding flux not sensitive to rusty spot, incrustation, paint, filth of parent metal.
- Excellent welding performance, stable electric arc, excellent slag removal and good bead appearance.
- The deposited metal has good mechanical properties.
- Used for general pressure vessel, structural steel, pipe steel, LPG cylinder, wheel welding.

GENERAL INFORMATION

Silicon - Manganese agglomerated flux	
Basicity Index : 1.1	Grain Size : 10 - 40 Mesh
Density : 1.25g / cm^3	Polarity : DCEP or AC

ATTENTION

Re-dry flux at 300-350°C (572-662°F) for 60 mins before welding.
Add new flux regularly to achieve excellent welding characteristics.

PACKING SPECIFICATIONS

Weight	Packing
25 Kg.	Fluxes are packed in Moisture Repellent Bag.

MARUTI
SAW FLUX

SF : 12
SUBMERGED ARC WELDING FLUX

APPROVAL
RDSO : CLASS - F2

CLASSIFICATION
GB/T12470 F48A4-H10Mn2 F48A2-H08MnA
AWS A5.17 F7A4 - EM12K

CHARACTERISTICS
- Multi-purpose flux, meet various welding conditions, used for industrial welding of low carbon steel, structural steel.
- The flux belongs to the metallurgy neutral and weldingbead doesn't increase Si and Mn.
- With different welding wire, welding bead obtains good impact values.
- The flux has excellent welding performance, easy to take of slag, not sensitive to rust and scale.
- Excellent Beads.

GENERAL INFORMATION

Fluoride-basicity type agglomerated flux	
Basicity Index : 1.1	Grain Size : 10 - 40 Mesh
Density : 1.5g / cm^3	Polarity : DCEP or AC

ATTENTION

Re-dry flux at 300-350°C (572-662°F) for 60 mins before welding.
Low current & welding speed are required in multi-layer welding & groove welding.

PACKING SPECIFICATIONS

Weight	Packing
25 Kg.	Fluxes are packed in Moisture Repellent Bag.

CLASSIFICATION

GB/T12470 F48A4-H10Mn2 F48A4-H08MnMoTiB
AWS A5.17 F7A2 - EH14

CHARACTERISTICS

- Applied in a variety of low alloy structural steel's welding, for example boiler, pressure vessel, bridge, ship, wind tower and wing power welding act with high impact toughness at low temperature.
- Excellent Bead finish and deslagging.

GENERAL INFORMATION

Fluoride-basicity type agglomerated flux	
Basicity Index : 2.0	Grain Size : 10 - 40 Mesh
Density : 1.3g / cm^3	Polarity : DCEP or AC

ATTENTION

Re-dry flux at 300-350°C (572-662°F) for 60 mins before welding.

Removing rust, water scale, primer & other contaminants to obtain excellent weld deposit.

PACKING SPECIFICATIONS

Weight	Packing
25 Kg.	Fluxes are packed in Moisture Repellent Bag.

MARUTI
SAW FLUX

SF : HS

SUBMERGED ARC WELDING FLUX

CLASSIFICATION

AWS: SFA 5.17 F7A0 - EI8, F7A2 - EM12K

CHARACTERISTICS

- High speed welding acidic flux for spiral pipe welding. The flux is suitable for single and multi-pass welding with single wire & multi-wire applications in both AC & DC polarity. Slag detachability is good and deposited weld metal is of radiographic quality.
- Suited for fabrication and welding of spiral pipes, smaller diameter pipes (internal and external), penstock pipelines, wind mill towers, pressure vessels, girder, earthmoving equipment, structures of off-shore platforms, etc.

GENERAL INFORMATION

$SiO_2 + Ti\ O_2$	$CaO + MgO$	$Al_2O_2 + MnO$	CAF_2
20%	5%	55%	15%
Basicity Index : - 0.5		Grain Size : 0.20 - 1.50 mm	

ATTENTION

Re-dry flux at 300-350°C (572-662°F) for 60 mins before welding.

Removing rust, water scale, primer & other contaminants to obtain excellent weld deposit.

PACKING SPECIFICATIONS

Weight	Packing
25 Kg.	Fluxes are packed in Moisture Repellent Bag.

MARUTI
WELDING WIRES

WT - 4043

ALUMINIUM ALLOY WELDING WIRE

FEATURES

WT - 4043 is one of the oldest and most widely used welding and brazing alloy. It can be classified as a general-purpose type of filler alloy. The Silicon addition result is improved fluidity to make the alloy a preferred choice by welders. This alloy is less sensitive to weld cracking and produces brighter, almost smut free weld.

APPLICATIONS

- General Fabrication
- Automotive
- Mobile Machinery
- Shipbuilding

CLASSIFICATIONS

- AWS A5.10 : ER4043
- EN ISO 18273 designation AlSi5

CHEMICAL PROPERTIES %

Si	Fe	Cu	Mn	Mg	Zn	Ti	Al	Be	Each	Total
4.5-6.0	0.80	0.30	0.05	0.05	0.10	0.20	Rem.	0.0003	0.05	0.15

TYPICAL MECHANICAL PROPERTIES

Base Alloy	Yield Strength		Tensile Strength		Elongation
	ksi	MPa	ksi	MPa	%
2014-T4	28	195	34	235	04
6061-T4	18	125	27	185	08
6061-T6	18	125	27	185	08
6063-T4	10	70	20	140	12

OTHER TYPICAL MECHANICAL PROPERTIES

Melting Range	:	1065°F to 1170°F	574°C to 632°C
Density	:	0.097 lbs./cu. in.	
Anodize colour	:	Grey	

SIZE & PACKAGING

MIG -	0.80 – 2.40mm	Spool -	6.5 Kgs.
TIG Rod -	1.60 – 4.00mm	Tubes -	4.0 Kgs.

MARUTI
WELDING WIRES

WT – 307 Si

MIG / MAG WIRES (GMAW) STAINLESS STEEL WIRE

DESCRIPTION

A continuous solid corrosion resisting chromium-nickel-manganese wire for welding of austenitic stainless alloys of 18%Cr – 8%Ni – 7%Mn type. WT – 307Si has a general corrosion resistance similar to that of the corresponding parent metal. The higher silicon content improves the welding properties, such as wetting. The product is a modified variant of ER307, basically with a higher Mn content to make the weld less sensitive to hot cracking. When use for joining dissimilar materials the corrosion resistance is of secondary importance. The alloy is used in a wide range of applications across the industry such as the joining of austenitic, manganese, work hardenable steels as well as armour plate and heat resistance steels.

CLASSIFICATIONS

EN ISO 14343-A:G 18 8 Mn

TYPICAL WIRE COMPOSITION %

C	Mn	Si	S	P	Ni	Cr	Mo	N	Cu
0.080	7.0	0.90	0.010	0.020	8.10	18.70	0.20	0.040	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	450 MPa	640 MPa	41

WELDING CURRENT

Size (mm)	Current (Amp)	Voltage (V)	Wire Feed Speed
0.80	50 – 160	15 – 24	4.0 – 17.0 m/min.
1.00	80 – 240	15 – 28	4.0 – 16.0 m/min.
1.20	100 – 300	15 – 29	3.0 – 14.0 m/min.

Polarity : DC+

Shielding Gases : Ar/O_2 or Ar/CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI
WELDING WIRES

WT – 308L

MIG / MAG WIRES (GMAW) STAINLESS STEEL WIRE

APPROVAL

RDSO: CLASS - VI

DESCRIPTION

A continuous solid corrosion resisting chromium-nickel wire. WT – 308L has a good general corrosion resistance. The alloy has a low carbon content which makes this alloy particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers.

APPLICATIONS

For joining of stainless steels of 18%Cr - 8Ni type and Nb-stabilised steel of the same type if the service temperature will not exceed 350°C.

CLASSIFICATIONS

- SFA/AWS A5.9: ER308L
- EN ISO 14343-A:G 19 9 L

TYPICAL WIRE COMPOSITION %

C	Mn	Si	S	P	Ni	Cr	Mo	N	Cu
0.020	1.6	0.45	0.010	0.020	9.80	20.10	0.20	0.050	0.25

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	420 MPa	590 MPa	36

WELDING CURRENT

Size (mm)	Current (Amp)	Voltage (V)	Wire Feed Speed
0.80	50 – 180	15 – 24	4.0 – 17.0 m/min.
1.00	80 – 240	15 – 28	4.0 – 16.0 m/min.
1.20	80 – 280	19 – 28	3.0 – 14.0 m/min.

Polarity : DC+

Shielding Gases : Ar/O_2 or Ar/CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI
WELDING WIRES

WT – 308L Si

MIG / MAG WIRES (GMAW) STAINLESS STEEL WIRE

DESCRIPTION

A continuous solid corrosion resisting chromium-nickel wire for welding of austenitic chromium nickel alloys of 18%Cr – 8%Ni type. WT – 308LSi has a good general corrosion resistance. The alloy has a low carbon content making it particularly recommended where there is a risk of intergranular corrosion. The higher silicon content improves the welding properties, such as wetting. The alloy is widely used in the chemical and food-processing industries, as well as for pipes, tubes and boilers.

CLASSIFICATIONS

- SFA/AWS A5.9: ER308LSi
- EN ISO 14343-A:G 19 9 L Si

TYPICAL WIRE COMPOSITION %

C	Mn	Si	S	P	Ni	Cr	Mo	N	Cu
0.010	1.70	0.90	0.010	0.020	10.50	19.9	0.15	0.050	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	400 MPa	570 MPa	36

WELDING CURRENT

Size (mm)	Current (Amp)	Voltage (V)	Wire Feed Speed
0.80	50 – 180	15 – 24	4.0 – 17.0 m/min.
1.00	80 – 240	15 – 28	4.0 – 16.0 m/min.
1.20	100 – 300	15 – 28	3.0 – 14.0 m/min.

Polarity : DC+

Shielding Gases : Ar/O_2 or Ar/CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI
WELDING WIRES

WT – 309L

MIG / MAG WIRES (GMAW) STAINLESS STEEL WIRE

DESCRIPTION

A continuous, solid, corrosion resisting Chromium-nickel wire for welding of similar steels, wrought and cast steels 23%Cr – 12%Ni types. The alloys is also used for welding of buffer layers on C-Mn steels and welding of dissimilar joints. When using the wire of buffer layers and dissimilar joints it is necessary to control the dilution of the weld. WT – 309L has a good general corrosion resistance. When used for joining dissimilar materials the corrosion resistance is of secondary importance.

CLASSIFICATIONS

- SFA/AWS A5.9: ER309L
- EN ISO 14343-A:G 23 12 L

TYPICAL WIRE COMPOSITION %

C	Mn	Si	S	P	Ni	Cr	Mo	N	Cu
0.020	1.70	0.40	0.010	0.020	12.50	23.50	0.10	0.050	0.24

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	420 MPa	600 MPa	37

WELDING CURRENT

Size (mm)	Current (Amp)	Voltage (V)	Wire Feed Speed
0.80	50 – 180	16 – 22	4.0 – 17.0 m/min.
1.00	80 – 280	19 – 28	4.0 – 16.0 m/min.
1.20	100 – 380	19 – 33	3.0 – 14.0 m/min.

Polarity : DC+

Shielding Gases : Ar/O_2 or Ar/CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI
WELDING WIRES

WT – 312

MIG / MAG WIRES (GMAW) STAINLESS STEEL WIRE

DESCRIPTION

A continuous solid corrosion resisting chromium-nickel wire for welding of the 29%Cr – 9%Ni types. WT – 312 has a good oxidation resistance at high temperatures due to its high content of Cr. The alloy is widely used for joining dissimilar steels, especially if one of the components is fully austenitic and steels that are difficult to weld i.e., machine components, tools and austenitic-manganese steels.

CLASSIFICATIONS

- SFA/AWS A5.9: ER312
- EN ISO 14343-A:G 29 9

TYPICAL WIRE COMPOSITION %

C	Mn	Si	S	P	Ni	Cr	Mo	N	Cu
0.10	1.60	0.4	0.010	0.020	8.80	30.0	0.20	0.04	0.15

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	610 MPa	770 MPa	20

WELDING CURRENT

Size (mm)	Current (Amp)	Voltage (V)	Wire Feed Speed
0.80	50 – 140	16 – 22	3.0 – 11.0 m/min.
1.00	80 – 190	16 – 24	2.9 – 8.4 m/min.
1.20	180 – 280	20 – 28	4.9 – 8.5 m/min.

Polarity : DC+

Shielding Gases : Ar/O_2 or Ar/CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI
WELDING WIRES

WT – 316L

MIG / MAG WIRES (GMAW) STAINLESS STEEL WIRE

DESCRIPTION

A continuous solid corrosion resisting chromium-nickel-molybdenum wire for welding of austenitic stainless alloys of 18%Cr – 8%Ni and 18%Cr – 10%Ni – 3%Mo. WT – 308L has a good general corrosion resistance particular against corrosion in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries as well as in ship building and various types of architectural structures.

CLASSIFICATIONS

- SFA/AWS A5.9: ER316L
- EN ISO 14343-A:G 19 12 3 L

TYPICAL WIRE COMPOSITION %

C	Mn	Si	S	P	Ni	Cr	Mo	N	Cu
0.010	1.70	0.40	0.010	0.020	12.0	18.20	2.60	0.04	0.20

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	440 MPa	620 MPa	37

WELDING CURRENT

Size (mm)	Current (Amp)	Voltage (V)	Wire Feed Speed
0.80	50 – 180	15 – 24	4.0 – 17.0 m/min.
1.00	80 – 240	15 – 28	4.0 – 16.0 m/min.
1.20	100 – 300	15 – 30	3.0 – 14.0 m/min.

Polarity : DC+

Shielding Gases : Ar/O_2 or Ar/CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI
WELDING WIRES

WT – 316L Si

MIG / MAG WIRES (GMAW) STAINLESS STEEL WIRE

DESCRIPTION

A continuous solid corrosion resisting chromium-nickel-molybdenum wire for welding of austenitic stainless alloys of 18%Cr – 8%Ni and 18%Cr – 10%Ni – 3%Mo. WT – 308LSi has a good general corrosion resistance in particular, the alloy has very good resistance in acid and chlorinated environments. The alloy has a low carbon content which makes it particularly recommended where there is a risk of intergranular corrosion. The higher silicon content improves the welding properties such as wetting. The alloy is widely used in the chemical and food-processing industries as well as in ship building and various types of architectural structures.

CLASSIFICATIONS

- SFA/AWS A5.9: ER316LSi
- EN ISO 14343-A:G 19 12 3 L Si

TYPICAL WIRE COMPOSITION %

C	Mn	Si	S	P	Ni	Cr	Mo	N	Cu
0.010	1.80	0.90	0.010	0.020	12.20	18.40	2.60	0.04	0.20

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	400 MPa	560 MPa	37

WELDING CURRENT

Size (mm)	Current (Amp)	Voltage (V)	Wire Feed Speed
0.80	50 – 180	15 – 24	4.0 – 17.0 m/min.
1.00	80 – 240	15 – 28	4.0 – 16.0 m/min.
1.20	100 – 300	15 – 30	3.0 – 14.0 m/min.

Polarity : DC+

Shielding Gases : Ar/O_2 or Ar/CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI
WELDING WIRES

WT – 430L NB

SOLID WIRE, HIGH ALLOY

FEATURES

A continuous ferritic stainless solid wire with low Carbon content, 18 % Cr and stabilised with Nb for welding similar and matching steel. WT-430LNB is developed and designed for the Automotive industry used for production of exhaust system. The wire should be used when there is a need for good resistance to corrosion and thermal fatigue.

APPLICATIONS

- Resistance scaling up to +900°C
- Outstanding sliding and feeding characteristics.
- Very good welding and flow behaviour.

CLASSIFICATIONS

- EN ISO 14343-A : G 18 L Nb

TYPICAL WIRE COMPOSITION %

C	Mn	Si	Ni	Cr	Mo	Cu	Nb
0.010	0.50	0.50	0.20	18.50	0.060	0.10	0.45

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	275 MPa	420 MPa	26

Hardness : 150 BHN (As Welded) 130 BHN (Annealed)

DEPOSITION DATA

Diameter (mm)	Current (A)	Voltage (V)	Wire Feed Speed
0.80	50 – 140	16 – 22	3.4 – 11.0 m/min.
1.00	80 – 190	16 – 24	2.9 – 8.4 m/min.
1.20	180 – 280	15 – 30	4.9 – 8.5 m/min.

Polarity : DC+

Shielding Gases : Argon + 8-10% CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI
WELDING WIRES

WT – 430L

SOLID WIRE, HIGH ALLOY

FEATURES

A continuous solid corrosion resisting 17% Cr wire for welding of stainless alloys of 13 – 18% Cr. WT – 430L is used for cladding on un-alloyed steels. Suitable for catalytic converters and silencers, exhaust mufflers, pipe junctions and intake manifolds made of same-type or similar-type materials

APPLICATIONS

- Resistance scaling up to +900°C
- Outstanding sliding and feeding characteristics.
- Very good welding and flow behaviour.

CLASSIFICATIONS

- EN ISO 14343-A : G 18 L

TYPICAL WIRE COMPOSITION %

C	Mn	Si	Ni	Cr	Mo	Cu
0.020	0.50	0.50	0.20	16.80	0.060	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL-WELD METAL

Condition	Yield Strength	Tensile Strength	Elongation %
As Welded	275 MPa	420 MPa	26

Hardness : 150 BHN (As Welded) 130 BHN (Annealed)

DEPOSITION DATA

Diameter (mm)	Current (A)	Voltage (V)	Wire Feed Speed
0.80	50 – 140	16 – 22	3.4 – 11.0 m/min.
1.00	80 – 190	16 – 24	2.9 – 8.4 m/min.
1.20	180 – 280	20 – 28	4.9 – 8.5 m/min.

Polarity : DC+

Shielding Gases : Argon + 8-10% CO_2

PACKING

The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5 kg.

MARUTI

STAINLESS STEEL TIG & MIG WIRES

Welding of Stainless Steel using the GMAW process is commonly called MIG WELDING. The process is currently used for thin sheets and where robotics is used. A very popular process in automobile industry.

With bright finish we provide Stainless Steel MIG WIRES in sizes 0.80 mm to 1.60 mm. Our modern machines ensure a contamination free surface thus giving excellent welding every time.

The wires are available in 12.5 kg layer wound spools and 100 / 250 kg drums. The wires are available as per composition and AWS GRADES as per chart below.

BRAND	AWS	CHEMICAL COMPOSITION (TYPICAL)						DEPOSITED METAL (TYPICAL VALUES)	
		C	Mn	Si	Cr	Ni	Mo	Tensile Strength MPa	Elongation (%)
WT 304L	ER 304L	0.030	1.27	0.51	18.30	8.40	-	597	43
WT 308L	ER 308L	0.024	1.65	0.42	20.10	9.33	-	612	42
WT 309L	ER 309L	0.023	1.98	0.39	24.18	13.10	-	588	43
WT 310	ER 310	0.089	2.01	0.40	27.40	21.80	-	607	41
WT 316L	ER 316L	0.025	1.91	0.42	19.10	12.58	2.57	578	40
WT 410	ER 410	0.09	0.47	0.54	12.18	-	-	510	24
WT 430	ER 430	0.038	0.46	0.39	16.37	-	-	535	26
WT 307Si	ER 307	0.09	6.80	0.80	19.00	8.50	-	460	40

MARUTI
ALLOY STEEL TIG WIRE

Gas Tungsten arc welding (GTAW) also known as Tungsten Inert Gas (TIG) welding is an arc welding processthat uses a non-consumables tungsten electrode to produce a weld from the filler metal.GTAW is most commonly used to weld thin sections of stainless steel and alloy steels. This process grantsThe operator greater control over the weld as compared to welding electrodes.

BRAND	AWS	CHEMICAL COMPOSITION									DEPOSITED METAL (TYPICAL VALUES)		
		C	Mn	Si	S	P	Zr	Ti	Cr	Mo	Tensile Strength N/mm^2	Yield	Elongation (%)
WT-72	ER70S-2	0.07 Max	0.90-1.40	0.40-0.70	0.030 Max	0.03	0.02-0.70	0.05-0.10	—	—	480	400 Min.	24
WT-80	ER80S-B2	0.12	0.40-0.70	0.70	0.025	0.025	—	—	1.20-1.50	0.40-0.60	635	520 Min.	25
WT-76	ER70S-6	0.07	1.40-1.85	0.80-1.15	0.35	0.025	—	—	—	—	480 Min.	420 Min.	22

Certificate of Compliance

CE

Manufacturer
Name : Certificate No.: CB-0100
Address : 160 A, RIICO INDUSTRIAL AREA, KHAIRAMI, BHIWADI, ALWAR, RAJASTHAN, 301019-INDIA
Products : MIG WIRE, SAW WIRE, TIG WIRE & SAW FLUX MADE FROM BASE METAL AND FLUX MANUFACTURED BY OUR OWN PRODUCTS DETAILS AS PER APPENDIX-I

This certificate is issued under the following conditions:

Validity of this certificate can be verified at www.ukcertification.org/directory

Date of Certification : 10th June 2022
1st Surveillance Audit Due : 09th June 2023
2nd Surveillance Audit Due : 07th June 2024
Certificate Expiry : 09th June 2025

Authorised Signatory

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Certificate of Compliance

CE

Manufacturer
Name :
Address :
Products :

Product -

S.NO	DESCRIPTION	SIZE (MM)	ISO CLASSIFICATION
1	MIG WIRES	0.8/1.0/1.2/1.6/2.0/2.4/3.2/4.0	ISO 14341-A/B: 2010 / ISO 14341-A/B: 2020
2	SAW WIRES	1.6/2.0/2.5/3.2/4.0/4.8/5.0/6.0	ISO 14171-A/B: 2010 / ISO 14171-A/B: 2020
3	TIG WIRES	1.6/2.0/2.5/3.2/4.0	ISO 636-A/B/C: 2015
4	SAW FLUX	AWS A5.17/A5.17M	ISO 14174: 2019

Authorised Signatory

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NSIC-CRISIL Performance and Credit Rating

MW Wiretec Private Limited, Rajasthan

CRISIL MSE - 2

Bharat Heavy Electricals Limited

High Pressure Boiler Plant, Tiruchirappalli

SUPPLIER DEVPT. CELL / MATLS. MANAGEMENT (PM)

CERTIFICATE

The Certification Body of TÜV SÜD South Asia Private Limited

certifies that

MW WIRETEC PVT. LTD.

Sh-128A, Kathoral Industrial Area, Bhiwadi, Rajasthan - 301 019, INDIA

has implemented a Quality Management System

which complies with ISO 9001:2015

For Scope of:

MANUFACTURING AND SUPPLY OF MIG WIRES, SAW WIRES, TIG WIRES AND SAW FLUX

This certificate is valid from 2020-03-26 until 2023-03-25

Certificate Registration No. 99 105 13788

Date of initial certification : 2011-09-21

CERTIFICAT • CERTIFICATE • 認証証書 • CERTIFICADO • CERTIFICAT

MARUTI
WELDING WIRES

MW WIRETEC PVT. LTD.

RUDRA CREATIONS 09891045992

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