WA. ALLOY CO.

Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

R60 (RG60)
Mild Steel
Oxyfuel Torch Rod

American Welding Society
Sustaining Company Member

ALLOY DESCRIPTION AND APPLICATION:

RG60 is used to produce high tensile strength quality welds on low carbon and low alloy steels such as sheets, plates, pipes of grades A and B analysis and structural shapes. It is recommended for critical welds that must respond to the same annealing and heat treatment as regular grades of cast steel. The high silicon and manganese composition removes impurities from the molten metal thereby eliminating the need for flux. Clean joint and bevel heavy sections keeping torch tip at low angle to base metal. Pre-heat normally not necessary as your torch will preheat during your process. Use a neutral flame or a very slight excess of acetylene (reducing flame). AWS changed this class from "RG" to "R" in 1969

TYPICAL WIRE CHEMISTRY (%) PROPERTIES;

	AWS Spec.	R60
Carbon	0.15 max	0.09
Manganese	0.90-1.40	1.05
Silicon	0.10-0.35	0.18
Phosphorus	0.035 max.	<0.011
Sulfur	0.035 max.	<0.012
Copper	0.30 max.	<0.15
Chromium	0.20 max.	<0.07
Nickel	0.30 max	<0.13
Molybdenum	0.20 max	<0.08
Aluminum	0.02 max	<0.01
Tensile Strength (ksi)	NA	60-75
Elongation in 2" (%)	20%	24%

Melting point of about 2750°F

Procedures may vary with change in position, base metals, filler metals, equipment, flux, heat treatment and other changes.

AVAILABLE SIZES: non-copper coated: TR RG60 = 1/16", 3/32", 1/8", 5/32" Bare

TM RG 60 FOR 1# Mini pack Two Part number ending in "C" is Copper coated such as TR RG 05C = 3/32, TR RG 06C = 1/8"

SPECIFICATIONS; ANSI/AWS A5.2 R60

ASME SFA 5.2 R60

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6-2017 *DC*