



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

R45 (RG45) Mild Steel Oxyfuel Torch Rod

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ALLOY DESCRIPTION AND APPLICATION:

R45 is a copper coated gas welding rod that is used for welding ordinary low carbon steel up to 1/4" thick. It is recommended where ductility and machinability are most important. R45 produces high quality welds which are ductile and free of porosity. This rod is excellent for steel sheets, plates, pipes, castings and structural shapes. No flux required. 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.	R45
Carbon	0.08 max	0.065
Manganese	0.50 max	0.25
Silicon	0.10 max	0.08
Phosphorus	0.035 max.	<0.03
Sulfur	0.040 max.	<0.03
Copper	0.30 max.	<0.15
Chromium	0.20 max.	<0.08
Nickel	0.30 max	<0.10
Molybdenum	0.20 max	<0.08
Aluminum	0.02 max	<0.01
Tensile Strength (ksi)	NA	45-60

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: TR RG45 = 2.0 MM, 1/16", 3/32", 1/8", 5/32", 3/16";; TM RG 45 FOR 1# Mini pack

SPECIFICATIONS; ANSI/AWS A5.2 R45
ASME SFA 5.2 R45



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6-2017 DC

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