



▪ *Stainless Steel & Nickel Alloy
Welding Wires*



Raajratna[®] Metal Industries Limited





Green Power

We Use
100%
GREEN POWER

HARNESSING THE POWER OF NATURE

THE ONLY COMPANY

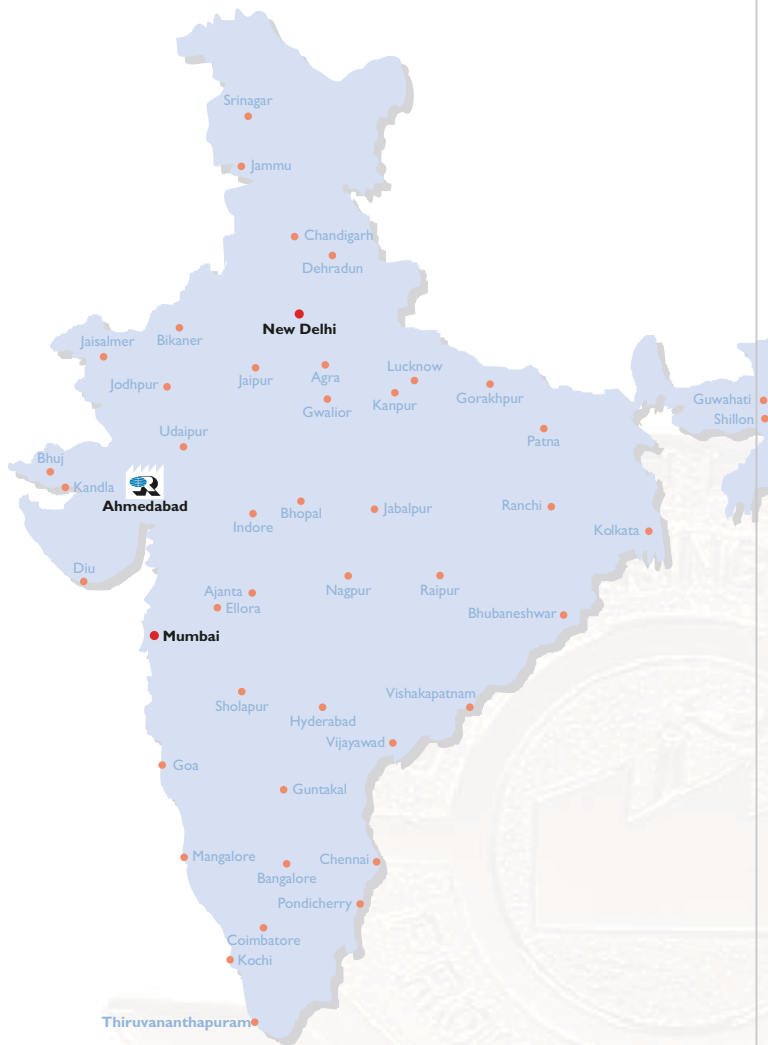
using 100% green power

for manufacturing stainless steel wires & bars





Company Profile



Raajratna Metal Industries Limited an "ISO 9001-2008" accredited company, started production of stainless steel wires in 1990 and subsequently diversified to bright bars. Since its beginning Raajratna has used state-of-the-art technology with strong emphasis on product quality and customer satisfaction.

As a result of continuous improvement in every aspect of business, within a short span, today Raajratna has become one of the most reliable source of quality product both in domestic as well as in international market with annual production capacity of 30,000 tonnes. Because of its large manufacturing capacity and continuous product innovation with regular upgradation of production process. Raajratna has achieved economy of scale and is able to serve customers having highly diversified requirements.

Raajratna exports more than 80% of its production to 50 countries across the globe. Raajratna is being awarded every year since 1991 for excellence in exports. It has been possible due to Raajratna's ability to meet exact market requirements and strict adherence to delivery schedule with an individual attention to every customer.



Product Range

STAINLESS STEEL & NICKEL ALLOY WELDING WIRES





Product Range

Stainless Steel MIG Wires

The MIG wires are supplied in bright as well as in matte finish and the wire is specially cleaned to avoid weld contamination. Stainless Steel MIG wires can be supplied in plastic spool as well as on metallic baskets. The wires have suitable cast / helix to ensure perfect "Pay-Off".



Size (mm)	Size (inch)	Fraction	Wire Basket K300	Plastic Spool SD300	Plastic Spool SD200	Plastic Spool SD100
0.60	0.025"	---				
0.80	0.030"	---				
0.90	0.035"	---				
1.00	0.040"	---				
1.20	0.045"	---				
1.60	0.062"	1/16"	12.5 kgs/15 kgs 25 lbs/30 lbs	12.5 kgs/15 kgs/20 kgs 25 lbs/30 lbs/40 lbs	5 kgs 10 lbs	1 kgs 2 lbs



Stainless Steel TIG Wires

Raajratna manufactures high quality stainless steel TIG wires in 36" & 1,000 mm cutlengths, with embossing on both sides above 1.0 mm wires as per customer's requirements. TIG wires are supplied in bright and clean finish to avoid all possible contamination.

Size (mm)	Size (inch)	Fraction	Corrugated Tubes	Plastic Tubes
0.80	0.030"	---		
1.00	0.040"	---		
1.20	0.045"	---		
1.60	0.062"	1/16"		
2.00	0.078"	---		
2.40	0.094"	3/32"		
3.20	0.125"	1/8"		
4.00	0.156"	5/32"	5 kgs 10 lbs	5 kgs 10 lbs





Product Range

Stainless Steel SAW Wires

Raajratna manufactures clean & layer wound wire for submerged arc welding from 1.60 mm (0.062") to 5.00 mm (0.187") in various grades in bright as well as in matte finish. The wires tensile strength, helix and cast diameter is engineered to precise tolerance to ensure perfect "Pay-Off".



Size (mm)	Size (inch)	Fraction	Corrugated Ring	Wire Basket K415
1.60	0.062"	1/16"		
2.00	0.078"	---		
2.40	0.094"	3/32"		
3.20	0.125"	1/8"		
4.00	0.156"	5/32"		
5.00	0.187"	3/16"		
			25 kgs. 60 lbs	25 kgs. 60 lbs

Stainless Steel Core Wires

Raajratna manufactures high quality stainless steel wire for welding electrodes in sizes 2.00 mm (0.078") - 5.00 mm (0.187") in bright as well as in matte finish.

The stainless steel wire for welding electrodes are supplied in coil as well as in cut length as per AWS, DIN, BS, JIS and other equivalent international standards or as per the customer's requirement.

The commonly manufactured grades are AWS ER307, ER308, ER308L, ER309, ER309L, ER309LMo, ER310, ER312, ER316, ER316L, ER317L, ER318, ER347, ER430 with low and normal silicon contents.

Size (mm)	Size (inch)	Fraction	Coil Form	Cut Length
2.00	0.078"	---		
2.40	0.094"	3/32"		
2.50	0.098"	---		
3.15	0.124"	---		
3.20	0.125"	1/8"		
4.00	0.156"	5/32"		
5.00	0.187"	3/16"		
			As per customer's request	



Packaging

Bulk Pay-Off Systems

Raajratna manufactures stainless steel MIG wires in bulk Pay-Off systems for higher productivity and robotic applications with 100 - 300 kgs. weight.

Sizes from 0.80 mm (0.030") - 1.60 mm (0.062") in various grades in bright as well as in matte finish.



Packaging

The wires are supplied in 150 - 300 kgs. on MS / wooden reels / drums bulk reels as well as in Pay-Off drums to prevent damage.

ROBOTIC APPLICATION :

Our drum pac is completely suitable for robotic application. Our pail pac system is good enough for robot equipped facilities and can be utilized without change of expensive equipment. It can be easily attached with any wire feeding unit.

COST EFFICIENCY :

Our drum pac increases productivity by reducing down time.

UN-INTERRUPTED FEEDING :

The wires are packed in layers within the drum resulting in uninterrupted feeding.

CONTROL ON WASTAGE :

Cast and helix is adjusted in such a way in our drum pac that reduces the wastage caused by arc wandering.

PARTS LIFE :

With the optimal combination of helix and cast in the wire feeding process is accentuated resulting in increase the life of liner and tips.

DRUM MATERIAL :

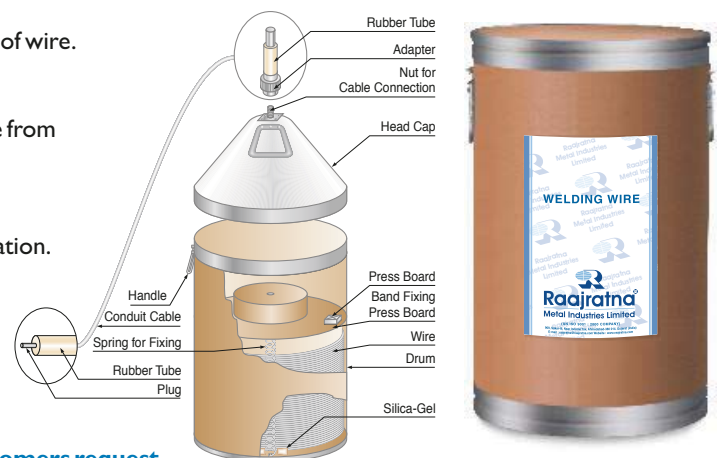
Drum is made from anti rust material, which helps to avoid rusting of wire.

DUST FREE PACKAGING :

During the usage wire will remain inside the drum so it remain free from shop floor dirt and rust.

SAFETY TRANSPORTATION :

Drum is fixed on wooden pallet with M.S.Strip for safer transportation.



CUSTOMIZED PACKING

We can provide customized packing and labelling as per customers request.



Welding Filler Metals

Welding Alloys

Stainless Steel TIG, MIG and SAW

Grade	Nearest to EN 12072:2000 14343:2007	British BS 2901 PTS	USA AWS A5.9	German DIN 8556
ER 307	18 8 Mn	307S94	ER 307	WK. 1.4370
ER 307Si	18 8 Mn	307S98	ER 307Si	WK. 1.4370
ER 308	19 9	308S96	ER 308	WK. 1.4302
ER 308H	---	---	ER 308H	WK. 1.4302
ER 308L	19 9 L	308S92	ER 308L	WK. 1.4316
ER 308LSi	19 9 LSi	308S93	ER 308LSi	WK. 1.4316
ER 309H	22 12 H	309S94	ER 309	WK. 1.4829
ER 309L	23 12 L	309S92	ER 309L	WK. 1.4332
ER 309Nb	---	---	ER 309Nb	---
ER 309LNb	---	---	ER 309LNb	---
ER 309LSi	23 12 LSi	309S93	ER 309LSi	WK. 1.4332
ER 309LMo	23 12 2L	~309S95	ER 309LMo	WK. 1.4459
ER 310	25 20	310S94	ER 310	WK. 1.4842
ER 312	29 9	312S94	ER 312	WK. 1.4337
ER 316	19 12 3	---	ER 316	WK. 1.4403
ER 316L	19 12 3 L	316S92	ER 316L	WK. 1.4430
ER 316LSi	19 12 3 LSi	316S93	ER 316LSi	WK. 1.4430
ER 317L	19 13 4 L	317S92	ER 317L	WK. 1.4438
ER 318	19 12 3 Nb	318S97	ER 318	WK. 1.4576
ER 320LR	---	---	ER 320LR	---
ER 330	---	---	ER 330	---
ER 330Nb	---	---	ER 330Nb	---
ER 347	19 9 Nb	347S96	ER 347	WK. 1.4551
ER 347Si	19 9 Nb Si	347S97	ER 347Si	WK. 1.4551
ER 385 [904L]	---	---	ER 385 [904L]	---
ER 409Nb	---	---	ER 409Nb	---
ER 410	---	---	ER 410	---
ER 410NiMo	---	---	ER 410NiMo	---
ER 430	17	---	ER 430	WK. 1.4015
ER 430Nb	---	---	ER 430Nb	---
ER 430LNb	---	---	ER 430LNb	---
ER 630 [17-4PH]	---	---	ER 630 [17-4PH]	---
ER 2209	---	---	ER 2209	---



Welding Filler Metals

Nickel Alloy Filler Metals

Nickel TIG, MIG and SAW

Stainless Steel Core Wires for Electrodes

Grade	Nearest to EN 12072:2000 14343:2007	British BS 2901 PTS	USA AWS A5.9	German DIN 8556
ER 308H	---	---	ER 308H	WK. 1.4302
ER 308L	19 9 L	308S92	ER 308L	WK. 1.4316
ER 309H	22 12 H	309S94	ER 309	WK. 1.4829
ER 309L	23 12 L	309S92	ER 309L	WK. 1.4332
ER 309LMo	23 12 2 L	309S95	ER 309LMo	WK. 1.4459
ER 310	25 20	310S94	ER 310	WK. 1.4842
ER 312	29 9	312S94	ER 312	WK. 1.4337
ER 316L	19 12 3 L	316S92	ER 316L	WK. 1.4430
ER 317L	18 15 3 L	317S92	ER 317L	WK. 1.4438
ER 320LR	---	---	ER 320LR	---
ER 330	---	---	ER 330	---
ER 347	19 9 Nb	347S96	ER 347	WK. 1.4551
ER 385 [904L]	---	---	ER 385 [904L]	---
ER 410	---	---	ER 410	---
ER 410NiMo	---	---	ER 410NiMo	---
ER 630 [17-4PH]	---	---	ER 630 [17-4PH]	---
ER 2209	---	---	ER 2209	---

Nickel Core Wires for Electrodes

Grade	Designations
	AWS A5.14
Alloy A	ENiCrFe-2
Nickel 55	ENiFe-C1
Alloy C-276	ENiCrMo-4
Alloy X	ENiCrMo-2
Alloy 59	ENiCrMo-13
Alloy 112	ENiCrMo-3
Alloy 117	ENiCrCoMo-1
Alloy 122	ENiCrMo-10
Alloy 141	ENi-1
Nickel 99	ENi-C1
Alloy 187	ECuNi
Alloy 190	ENiCu-7
Alloy 182	ENiCrFe-3

Grade	Designations	
	EN ISO 18274	AWS A5.14
Alloy 60	Ni 4060 NiCu30Mn3Ti	ERNiCu-7
Alloy 67	---	ERCuNi
Alloy 82	Ni 6082 NiCr20Mn3Nb	ERNiCr-3
---	Ni 6072 NiCr44Ti	ERNiCr-4
---	Ni 6076 NiCr20	ERNiCr-6
Alloy 601	Ni 6601 NiCr23Fe15Al	ERNiCrFe-11
Alloy 718	Ni 7718 NiCr19Fe19Nb5Mo3	ERNiFeCr-2
Alloy X	---	ERNiCrMo-2
Alloy 59	---	ERNiCrMo-13
Alloy C-276	Ni 6276 NiCr15Mo16Fe6W4	ERNiCrMo-4
Alloy 622	Ni 6022 NiCr21Mo13Fe6W4	ERNiCrMo-10
Alloy 625	Ni 6625 NiCr22Mo9Nb	ERNiCrMo-3
---	Ni 6686 NiCr21Mo16W4	ERNiCrMo-14
Alloy 617	Ni 6617 NiCr22Co12Mo9	ERNiCrCoMo-1
Alloy W	---	ERNiMo-3
Alloy 61	---	ERNi-1
Nickel 55	---	N.A.
Nickel 99	---	ERNi-C1

- ▶ Special chemical composition for pressure vessel applications on request.
- ▶ Special chemical composition with controlled ferrite nos. as per request.



Quality Assurance System

Quality Policy

We at Raajratna are committed to satisfy the needs and expectation of the customers by manufacturing and supplying stainless steel wires, stainless steel bright bars and heat resistance wires of stated quality, timely delivery and reliable services at all times.

This is achieved by Encouraging participation of employees. Supplying reliable product assured by complying requirements and continuously improving the effectiveness of quality management system.



The company has modern production facilities manned by experienced and committed personnel to produce wires and bright bars conforming to various international standards.

The quality is built into the product as a result of inspection and testing at various stages of production starting from raw material stage to finish product. We have also installed spectrometer for chemical analysis of incoming raw material.



Chemical Lab



Mechanical Lab



Metallurgical Lab / Conoptica



Spectrometer



Raajratna's Global Presence

Raajratna exports its 80% of production to more than 50 countries across the globe



Enquiries & Orders

Please provide following information while forwarding your enquires and orders :

- ▶ Size
- ▶ Grade (as per international standards) with any change from standard composition.
- ▶ Finish condition, tensile strength and surface finish
- ▶ End application
- ▶ Quantity for each size and each grade
- ▶ Delivery Schedule
- ▶ Packaging requirements - coil, spool etc. with specific dimensions
- ▶ Port of shipment / Destination

For more information please visit our [website : www.raajratna.com](http://www.raajratna.com)

"Raajratna" Quality so outstanding...
...we are proud it's Indian



Raajratna[®] Metal Industries Limited

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