



XTR RG60

AWS A5.2 R60

Description:

RG60 is a moly alloyed, general purpose, non-copper coated steel alloy for oxyfuel gas welding. This product is used for welding most low carbon and low alloy sheet steels. You do not need a flux when brazing with this product, but "puddling" of the molten metal will bring any scale or impurities to the surface.

While RG45 & RG60 seem like similar alloys, they were originally developed for oxyfuel welding, however they can be used for TIG welding in some applications. These alloys do not carry enough de-oxidizers typically needed with the GTAW process; therefore, it is not recommended.

Typical Applications:

XTR RG60 is used in applications where a high tensile strength is needed as well as pipes of grades A and B analysis and structural shapes. RG60 is the recommended oxyfuel for critical welds that must respond to a similar annealing and heat treatment process as regular grades of cast steel. The high silicon and manganese content in the product eliminates the need for flux when welding.

Chemistry:

	Typical	AWS Spec. Single values are max.
Carbon (C)	0.095	0.150
Manganese (Mn)	1.050	0.90-1.40
Silicon (Si)	0.18	0.10-0.35
Phosphorus (P)	0.010	0.0350
Sulfur (S)	0.007	0.0350
Copper (Cu)	0.060	0.300
Chromium (Cr)	0.036	0.200
Nickel (Ni)	0.027	0.300
Molybdenum (Mo)	0.005	0.200
Aluminum (Al)	0.010	0.020



Mechanical Properties: (As Welded)

	Typical	AWS Spec. Single values are min.
Tensile Strength	52,500	60,000 psi
Elongation in 1" (%)	24	20
Melting Point	2,800°F	-

Welding Positions:

H, V

Recommended Procedures:

1. Be sure to clean all areas to be joined or built-up thoroughly. Bevel cracks or heavy sections
2. Joint clearances should not exceed 0.13mm
3. Using a slightly neutral flame, Pre-heat normally not necessary as your torch will preheat during your process.
4. Flux is not necessary, but "puddling" of the molten metal will bring any scale or impurities to the surface.
5. Allow the part to cool slowly before removing any slag, then use a wire brush to clear
6. Repeat as necessary to fill your joint



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