



Pinnacle Alloys are products of SOWESCO

RG45 DATA SHEET

Pinnacle Alloys RG45

AWS CLASS R45

CODE AND SPECIFICATION DATA:

AWS A5.2 ASME SFA 5.2

DESCRIPTION:

Pinnacle Alloys RG45 is a special copper-coated steel rod designed for oxy-acetylene (autogenous) welding of iron and carbon or carbon-manganese steels of medium mechanical properties. It is suitable for pipes, tanks, and structural works.

BASE MATERIALS TO BE WELDED:

- A131 Gr A, B, D
- API 5LX

DIAMETERS: 1/16", 3/32", 1/8", 5/32"

WELDING POSITIONS: All positions

WELDING GUIDELINES: Preheat and PWHT are not required.

TYPICAL DEPOSIT COMPOSITION (Wt %):

Carbon (C)	0.07
Copper (Cu)	0.15
Manganese (Mn)	0.50
Phosphorous (P)	0.012
Silicon (Si)	0.07
Sulfur (S)	0.012

TYPICAL MECHANICAL PROPERTIES (as welded):

Ultimate Tensile Strength (psi) 72,520 psi (500 MPa)

TYPICAL WELDING PARAMETERS:

	Diameter	Amperage	Volts	Shielding Gas
GTAW	1/16"	100-125	12-15	100% Ar
	3/32"	125-175	15-20	
	1/8"	175-250	15-20	
	5/32"	175-250	15-20	

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys MSDS sheet may be obtained at www.pinnaclealloys.com.