

SANWALKA®

COMMITTED TO SAFE WELDING



SHAKUNT ENTERPRISES (P) LTD.

MANUFACTURER & EXPORTER OF WELDING WIRES

LUDHIANA • DHARWAD • VADODARA • MUMBAI • BANGALORE • CHENNAI

SHAKUNT ENTERPRISES (P) LTD. is India's Largest Manufacturer & Exporter of MIG welding wires & **FLUX CORED welding wires**. Incorporated in 1997 & within a short span of time we were recognized as the preferred supplier of welding wires. We are an ISO 9001 : 2008 certified company. Our products are approved by RDSO, BHEL, PDIL, ABS & Lloyd's Register.

Our company is consistently upgrading its technology and systems in an endeavour to provide the finest quality welding wires & advanced technical support.

The management team, made up of dedicated engineers and qualified technicians, guarantees smooth and efficient operations, permanently supported by sophisticated quality assurance systems.

Our Welding wire production accounts for about 20% of the total India subcontinent production and therefore our company is an important player in the Asian market. We are the largest manufacturer of welding wires in India with a production capacity of **30000 TPA**.

www.shakunt.com



The very modern manufacturing facilities of **Shakunt Enterprises (P) Ltd.** are located in:

- **LUDHIANA (Punjab)**
- **DHARWAD (Karnataka)**
- **VADODARA (Gujarat)**





QUALITY TESTING FACILITIES

Our high end, in-house welding & testing facilities for:

- All chemical & mechanical Test lab.
- Roundness of wire.
- Maintaining copper coating of wire.
- Maintaining free flow of wire.
- All weld test.
- Welding performance test.



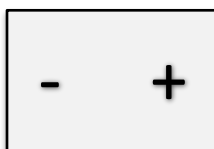
MIG WIRE



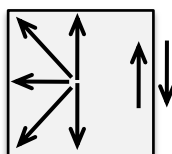
APPLICATION:

- General Steel Fabrication
- Construction,
- Automotive
- Shipping
- Mechanical Engineering,
- Thermal Power
- Pipe Work

CURRENT POLARITY



WELDING POSITION



SANWALKA "Xtra Arc" MIG WIRE

TYPE: Solid Wire for CO2 or Ar-CO2 mix

CONFORMANCES:	AWS/ASME-SFA-5.18 :	ER70S6
	IS 6419 : 1996 :	S4
	EN ISO 14341:2008 :	G3Si1

SHIELDING GAS	100 % CO2
	80% Ar, 20% CO2

CHEMICAL ANALYSIS %

PACKING	1kg, 5kgs, 12.5 kgs & 15kgs
SIZES:	0.60mm, 0.80mm, 1.00mm, 1.20mm, 1.60mm, 2.00mm

	C	Mn	Si	P	S
Wire:	0.06-0.15	1.40-1.85	0.80-1.15	<0.025	<0.035
Weld Metal:	0.05-0.12	0.80-1.40	0.2-0.6	<0.025	<0.035

MECHANICAL PROPERTIES OF WELD METAL

Condition	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Percentage Elongation [%]	Charpy V Notch (J) [-30° C]
AW & SR	>400	>480	>22	>27

AW: As Welded SR: Stress Relieved

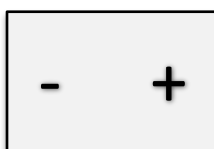
FLUX CORED WIRE



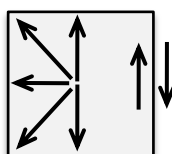
APPLICATION:

- Pre-Engineered Buildings
- Barges & Offshore Platforms
- Heavy Equipments,
- Structural Fabrication,
- General Fabrication
- Shipping
- Thermal Power Plants
- Nuclear Power Plants

CURRENT POLARITY



WELDING POSITION



SANWALKA FABCORE

TYPE: Micro-alloy rutile Flux-Cored wire with rapidly solidifying slag for CO2

CONFORMANCES:	EN :	ISO 17632-A T422PC1H5
	AWS/ASME-SFA-5.20 :	E71T-1C

SHIELDING GAS 100 % CO2

CHEMICAL ANALYSIS % (Typical Value)

PACKING	15kgs
SIZES:	0.80mm, 1.20mm, 1.60mm

	C	Mn	Si	P	S
Weld Metal:	0.05	1.30	0.5	<0.015	<0.015

MECHANICAL PROPERTIES OF WELD METAL

Condition	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Percentage Elongation [%]	Charpy V Notch (J) [-20° C]
AW & SR	>390	490-670	>22	>27

AW: As Welded & SR: Stress relieved

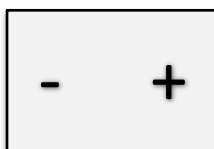
HIGH PERFORMANCE MIG WIRE



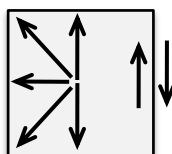
APPLICATION:

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- Construction,
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- Thermal Power
- Pipe Work

CURRENT POLARITY



WELDING POSITION



SANWALKA FABRICO

TYPE: Solid High speed Wire for CO₂ or Ar-CO₂

CONFORMANCES:	AWS/ASME-SFA-5.18 :	ER70S6
	IS 6419 : 1996 :	S4
	EN ISO 14341:2008 :	G3Si1

SHIELDING GAS	100 % CO ₂
	80% Ar, 20% CO ₂

CHEMICAL ANALYSIS %

PACKING	1kg, 5kgs, 12.5 kgs & 15kgs
SIZES:	0.60mm, 0.80mm, 1.00mm, 1.20mm, 1.60mm, 2.00mm

	C	Mn	Si	P	S
Wire:	0.06-0.15	1.40-1.85	0.80-1.15	<0.025	<0.035
Weld Metal:	0.05-0.12	0.80-1.40	0.2-0.6	<0.025	<0.035

MECHANICAL PROPERTIES OF WELD METAL

Heat Treatment	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Percentage Elongation [%]	Charpy V Notch (J) [-30° C]
AW & SR	>400	>480	>22	>27

AW: As Welded SR: Stress Relieved

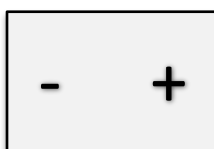
COPPER FREE MIG WIRE



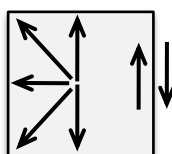
APPLICATION:

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CURRENT POLARITY



WELDING POSITION



SANWALKA ECOFAB

TYPE: Solid Copper free Wire for CO₂ or Ar-CO₂

CONFORMANCES:	AWS/ASME-SFA-5.18 :	ER70S6
	IS 6419 : 1996 :	S4
	EN ISO 14341:2008 :	G3Si1

SHIELDING GAS	100 % CO ₂
	80% Ar, 20% CO ₂

CHEMICAL ANALYSIS %

PACKING	1kg, 5kgs, 12.5 kgs & 15kgs
SIZES:	0.60mm, 0.80mm, 1.00mm, 1.20mm, 1.60mm, 2.00mm

	C	Mn	Si	P	S
Wire:	0.06-0.15	1.40-1.85	0.80-1.15	<0.025	<0.035
Weld Metal:	0.05-0.12	0.80-1.40	0.2-0.6	<0.025	<0.035

MECHANICAL PROPERTIES OF WELD METAL

Heat Treatment	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Percentage Elongation [%]	Charpy V Notch (J) [-30° C]
AW & SR	>400	>480	>22	>27

AW: As Welded SR: Stress Relieved

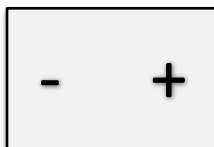
TIG WIRE (GTAW, CUT LENGTH)



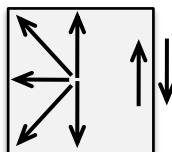
APPLICATION:

- General Steel Fabrication
- Construction,
- Automotive
- Shipping
- Mechanical Engineering,
- Thermal Power
- Pipe Work

CURRENT POLARITY



WELDING POSITION



SANWALKA FABTIG

TYPE: Solid Wire for Argon

CONFORMANCES:	AWS/ASME-SFA-5.18 :	ER70-S6/ S2
	IS 6419 : 1996 :	S4
	EN ISO 14341:2008 :	G3Si1

SHIELDING GAS 100 % Argon

PACKING	5kgs, 10kgs
SIZES:	1.60mm, 2.40mm, 3.20mm

CHEMICAL ANALYSIS %

	C	Mn	Si	P	S
Wire:	0.06-0.15	1.40-1.85	0.80-1.15	<0.025	<0.035
Weld Metal:	0.05-0.12	0.80-1.40	0.2-0.6	<0.025	<0.035

MECHANICAL PROPERTIES OF WELD METAL

Condition	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Percentage Elongation [%]	Charpy V Notch (J) [-30° C]
AW & SR	>400	>480	>22	>27

AW: As Welded SR: Stress Relieved

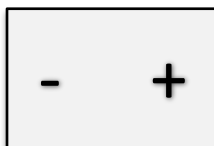
MIG WIRE JUMBO PACK



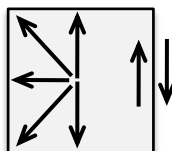
APPLICATION:

- General Steel Fabrication
- Construction,
- Automotive
- Shipping
- Mechanical Engineering,
- Thermal Power
- Pipe Work

CURRENT POLARITY



WELDING POSITION



SANWALKA MARATHON PACK

TYPE: Solid Copper free Wire for CO₂ or Ar-CO₂

CONFORMANCES:	AWS/ASME-SFA-5.18 :	ER70S6
	IS 6419 : 1996 :	S4
	EN ISO 14341:2008 :	G3Si1

SHIELDING GAS 100 % CO₂
80% Ar, 20% CO₂

PACKING	100kgs, 250kgs
SIZES:	0.80mm, 1.00mm, 1.20mm

CHEMICAL ANALYSIS %

	C	Mn	Si	P	S
Wire:	0.06-0.15	1.40-1.85	0.80-1.15	<0.025	<0.035
Weld Metal:	0.05-0.12	0.80-1.40	0.2-0.6	<0.025	<0.035

MECHANICAL PROPERTIES OF WELD METAL

Condition	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Percentage Elongation [%]	Charpy V Notch (J) [-30° C]
AW & SR	>400	>480	>22	>27

AW: As Welded SR: Stress Relieved

FABRICO SG3

SG3 wire for MIG/MAG Welding

Conformances:

- | | |
|-----------------------|----------|
| • AWS/ASME-SFA-5.18 | :ER70SG3 |
| • IS 6419 : 1996 | :S4 |
| • EN ISO 14341 : 2008 | :G4Si1 |

Applications:

- Building & Construction
- Shipping
- Earth moving equipments
- Thermal Power

Chemical Analysis %

C %	Si %	Mn %	P %	S %
0.06-0.14	0.80-1.20	1.60-1.90	0.025	0.035

Mechanical Properties of Weld Metal

	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Elongation [%]	Charpy V-Notch (J) @ 30°C
AW & SR	460	560	25	110

AW: As Welded SR: Stress Relieved



Shielding Gas:

- 100 % CO₂
- 80 % Ar + 20 % CO₂

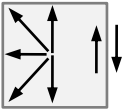
Packing:

1 Kgs, 5 Kgs & 15 Kgs

Sizes:

- 0.80 mm
- 1.00 mm
- 1.20 mm
- 1.60 mm

Welding Position:



FABRICO 70S-G

Solid Copper coated ER70S-G wire

Conformances:

- | | |
|--------------------|--------------|
| • AWS A5.18/A5.18M | :ER70S-G |
| • ASME SFA-A5.18 | :ER70S-G |
| • EN ISO 14341-B | :G49A Z C SZ |

Applications:

- Root pass welding
- Hot, fill and cap pass welding for x70 grade pipe

Chemical Analysis %

C %	Si %	Mn %	P %	S %	Cr%	Ni%	Cu%	Ti%
0.05-0.10	0.80-1.00	1.40-1.60	≤0.025	≤0.025	≤0.15	≤0.15	≤0.20	≥0.18

Mechanical Properties of Weld Metal

	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Elongation [%]	Charpy V-Notch (J) @ 30°C
Requirements: AWS ER70S-G	400 min	485 min	22 min	Not Specified
Typical Results	496	576	32	83

AW: As Welded SR: Stress Relieved



Shielding Gas:

- 100 % CO₂
- 80 % Ar + 20 % CO₂

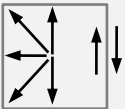
Packing:

1 Kgs, 5 Kgs & 15 Kgs

Sizes:

- 0.80 mm
- 1.00 mm
- 1.20 mm
- 1.60 mm

Welding Position:



FABRICO 80S-G

Solid Copper coated ER80S-G wire

Conformances:

- AWS A5.28/A5.28M:2005
 - ASME SFA-A5.28
 - EN ISO 16834-B
- :ER80S-G
 - :ER80S-G
 - :G59A 3 M 4M31

Applications:

- Welding Cor-ten type weathering steels
- Welding Seawater Injection lines
- Marine Industries

Chemical Analysis %

C %	Si %	Mn %	P %	S %	Cu%
0.05-0.15	0.40-0.70	1.40-1.60	≤0.02	≤0.02	≤0.02

Mechanical Properties of Weld Metal

	Yield Strength [N/mm2]	Tensile Strength [N/mm2]	Elongation [%]	Charpy V-Notch (J) @ 30°C
Requirements: AWS ER80S-G	Not Specified	550 (80) min	Not Specified	Not Specified
Typical Results	585-620	620-690	22-24	27-54

AW: As Welded SR: Stress Relieved



Shielding Gas:

- 100 % CO2
- 80 % Ar + 20 % CO2

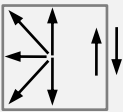
Packing:

1 Kgs, 5 Kgs & 15 Kgs

Sizes:

- 0.80 mm
- 1.00 mm
- 1.20 mm
- 1.60 mm

Welding Position:



FABRICO 90S-G

Solid Copper coated ER90S-G wire

Conformances:

- AWS A 5.28
 - BS EN ISO 21952-A
- :ER90S-G
 - :CrMo2Si

Applications:

- Steam Generating Power Plant
- Coal Liquefaction Plant
- Pressure Vessels
- Piping

Deposit Chemical Analysis %

C %	Si %	Mn %	P %	S %
0.06-0.12	0.50-0.80	0.80-1.20	0.020 max	0.020 max

Mechanical Properties of Weld Metal

	Yield Strength [N/mm2]	Tensile Strength [N/mm2]	Elongation [%]	Charpy V-Notch (J) @ 30°C
Requirements: AWS ER90S-G	540 min	620 min	17 min	-
Typical Results	560	655	25	110-120

AW: As Welded SR: Stress Relieved



Shielding Gas:

- 100 % CO2
- 80 % Ar + 20 % CO2

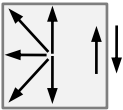
Packing:

1 Kgs, 5 Kgs & 15 Kgs

Sizes:

- 0.80 mm
- 1.00 mm
- 1.20 mm
- 1.60 mm

Welding Position:



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SHAKUNT ENTERPRISES (P) LTD.

Ludhiana Plant: B-XXIX-595/5, Campa Cola Road, Industrial Area –C, Dhandari Kalan, Ludhiana – 141010 (PUNJAB)

Dharwad Plant: # 577 C & D, Belur Industrial Area, Dharwad – 580011 (KARNATAKA)

Vadodara Plant: # 67 A, G.I.D.C. Manjusar, Savli, Vadodara – 391121 (GUJARAT)

CONTACT US: 0161-2512691, 9216515713

EMAIL US: info@shakunt.com

FABSAW EL-8

Copper Coated SAW welding wire

Conformances:

- AWS A5.17/A5.17M:2010 :EL-8

Applications:

- Suitable for single or multiple pass welding on high tensile strength steel structure like machinery, bridges & general structures

Chemical Analysis %

C %	Si %	Mn %	P %	S %	Cu%
0.05-0.15	0.10-0.36	0.80-1.25	0.030	0.030	0.350

Mechanical Properties of Weld Metal

	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Elongation [%]	Charpy V-Notch (J) @ 30°C
Typical Results	435	489	36	42



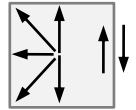
Packing:

- 25 Kgs in coil
- 250 Kgs in M-PACK

Sizes:

- 1.60 mm
- 2.00 mm
- 2.40 mm
- 3.20 mm
- 4.00 mm

Welding Position:



FABSAW EM-12K

Copper Coated SAW welding wire

Conformances:

- AWS A5.17/A5.17M:2010 :EM12K

Applications:

- Suitable for single or multiple pass welding on high tensile strength steel structure like: shipbuilding, general structure, bridges & machineries.

Chemical Analysis %

C %	Si %	Mn %	P %	S %	Cu%
0.05-0.15	0.10-0.36	0.80-1.25	0.030	0.030	0.350

Mechanical Properties of Weld Metal

	Yield Strength [N/mm ²]	Tensile Strength [N/mm ²]	Elongation [%]	Charpy V-Notch (J) @ 30°C
Typical Results	501	580	32	55



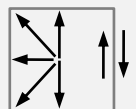
Packing:

- 25 Kgs in coil
- 250 Kgs in M-PACK

Sizes:

- 1.60 mm
- 2.00 mm
- 2.40 mm
- 3.20 mm
- 4.00 mm

Welding Position:



FABSTEEL 409

MIG/ MAG Stainless steel welding wire

Introduction:

Grade 409 stainless steel is a Ferrite steel that offers good mechanical properties and high temperature corrosion resistance. It is commonly considered as a chromium stainless steel, with applications in exhaust systems of automobiles and applications that demand weld ability.

The stability of this grade is provided by the presence of niobium, titanium, or both, in the composition of steels.

Conformances:

- AWS A5.9 :EC-409

Applications:

- Automotive exhaust tubing
- Mufflers
- Catalytic converter systems

Chemical Analysis %

	C %	Si %	Mn %	P %	S %	Cr%	Ni%	Ti%
Min.	-	-	-	-	-	10.5	-	6x C
Max.	0.080	1.000	1.000	0.045	0.045	11.750	0.500	0.750

Mechanical Properties of Weld Metal

	Yield Strength 0.2% Proof [N/mm2]	Tensile Strength [N/mm2]	Elongation [% in 50 mm]	Hardness	
				Rockwell B (HR B) max	Brinell (HB) max
Requirements:	240	450	25	75	131
Typical Results	295	510	35	70	120



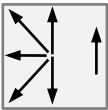
Packing:

- 15 Kgs in spool

Sizes:

- 0.80 mm
- 0.90 mm
- 1.00 mm
- 1.20 mm
- 1.60 mm

Welding Position:



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SHAKUNT ENTERPRISES (P) LTD.

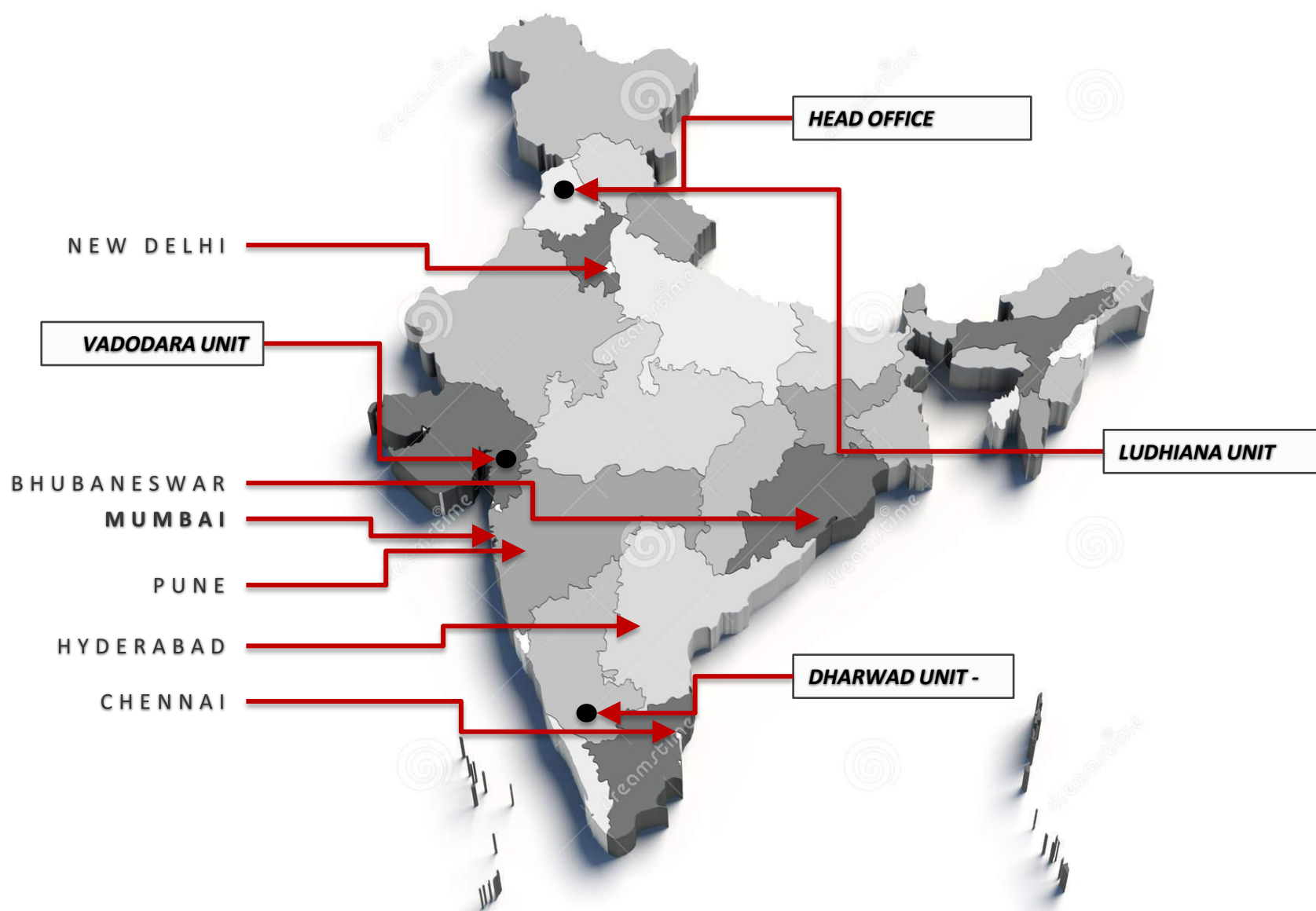
Ludhiana Plant: B-XXIX-595/5, Campa Cola Road, Industrial Area –C, Dhandari Kalan, Ludhiana – 141010 (PUNJAB)

Dharwad Plant: # 577 C & D, Belur Industrial Area, Dharwad – 580011 (KARNATAKA)

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CONTACT US: 0161-2512691, 9216515713

EMAIL US: info@shakunt.com



OUR CLIENTS WHO PUT THEIR FAITH ON US:



& our list goes on...



SHAKUNT ENTERPRISES (P) LTD.

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2538924, 5025973, 2541662

Email: info@shakunt.com
Website: www.shakunt.com

Authorized Dealer Stamp

OUR MANUFACTURING UNITS:

Ludhiana Unit: BXXIX-595/5, Campa Cola Road, Dhandari Kalan, Ludhiana - 141010 (PUNJAB)

Dharwad Unit: 577/C & D, Belur Industrial Area, Dharwad - 580011 (KARNATAKA)

Vadodara Unit: 57-A, G.I.D.C. Manjusar, Savli, Vadodara - 391775 (GUJARAT)