

AUTOCRAFT LW1


- ▲ For GMAW Welding of Mild & Low Alloy Steels.
- ▲ Increased Resistance to Copper Flaking at High Current Settings.
- ▲ Designed Primarily for Use with Argon Based Shielding Gases.
- ▲ Suitable for use with Short-arc, Spray & Pulsed arc Transfer Modes.

Classifications:

AS/NZS 2717.1: (old)	ES4-GC/M-W503AH.
AS/NZS 14341: (new)	B G 49A 3U C1/M21/M24 S4
AWS/ASME-SFA A5.18:	ER70S-4.

Description and Applications:

Autocraft LW1 is a high quality copper coated welding wire manufactured using the latest wire drawing technology. This state-of-the-art technology ensures; the highest quality copper coating - for improved wire feeding, electrical conductivity and lower contact tip wear. Improved copper coating gives increased resistance to copper flaking especially under high current welding conditions. Autocraft LW1 is suitable for the all positional multi-pass Gas Metal Arc welding of mild, low alloy and medium strength steels, as used in general fabrication, pressure vessels and structural work. Autocraft LW1 exhibits excellent operator appeal and very low spatter levels important for welding light to medium gauge sheet, pipe and tubular steel sections. Fillet welds exhibit a mitre to slightly concave profile with an even and smooth contour.

Storage Recommendations:

When held under the recommended storage conditions unopened packs of Autocraft LW1 are expected to remain in 'factory fresh' condition for at least 12 months. For storage over 12 months or under adverse (damp or high humidity) climatic conditions the use of heated weather proof store rooms/ cupboards/containers maintained at 10-15°C above ambient temperature (with a maximum of 40°C) and at a maximum humidity of 60% R.H. is recommended. Product should be stacked on racks or pallets clear of the floor and walls.

TYPICAL WIRE ANALYSIS:

C: 0.08%	Mn: 1.16%	Si: 0.70%
S: 0.010%	P: 0.015%	

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

1.0 - 2.0 mls of hydrogen / 100gms of deposited weld metal.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

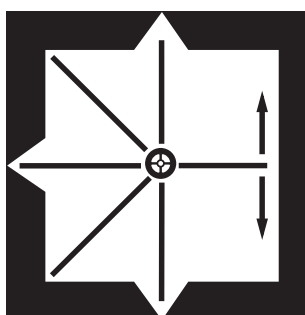
Argon + 10-15%CO ₂ :		
Welding Grade CO ₂ :		
Yield Stress	450 MPa	410 MPa
Tensile Strength	550 MPa	525 MPa
Elongation ²	9%	32%
CVN Impact Val.	120 J @ -20°C	110 J @ -20°C

RECOMMENDED* SHIELDING GAS:

AS 4882:	ISO 14175 / AWS A5.32:
SG-AC-8, or SG-AC-10	M20
SG-AC-18, or SG-AC-20	M21*- Cert supplied
SG-ACO-5/2	M23
SG-C	C1
Ar+CO ₂ (8-25%) or Ar+CO ₂ +O ₂ or Welding Grade CO ₂	

COMPARABLE CIGWELD PRODUCTS:

Comweld LW1 TIG rod:
AWS/ASME-SFA A5.18: ER70S-4



All positional welding applications

Packaging and Operating Data:

Wire Diameter mm	Voltage Range (volts)	Wire Feed Speed (meters/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
0.9	15-26	3.5-15	70-230	Spool	15kg	720115
1.2	18-32	2.5-15	120-350	Spool	15kg	720116

* Spool (ø300mm);