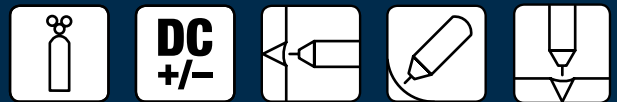


## METAL-COR 3

### PRODUCT DATA SHEET



**HIGH EFFICIENCY METAL CORED WIRE WITH EXCELLENT OPERATOR APPEAL.**



### METAL-COR 3

- Very Low Slag Formation
- Outstanding Low Temperature Impact Properties
- High Deposition Efficiency
- High Deposition Rates.
- Precision Layer Wound.

### CLASSIFICATIONS:

|                     |                         |
|---------------------|-------------------------|
| AS/NZS ISO: 17632:  | B T 49 3 T15 0 M A U H5 |
| AS/NZS ISO: 17632:  | A T 42 3 M M21 3 H5     |
| AWS/ASME-SFA A5.18: | E70C-6M H4              |

### RECOMMENDED SHIELDING GAS:

|                             |                        |
|-----------------------------|------------------------|
| AS 4882:                    | ISO 14175 / AWS A5.32: |
| SG-AC-18, or SG-AC-20       | M21                    |
| Ar+CO <sub>2</sub> (18-25%) |                        |

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

#### USING ARGON + 18-25% CO<sub>2</sub>:

|                   |                |
|-------------------|----------------|
| Yield Stress      | 485 MPa.       |
| Tensile Strength  | 553 MPa.       |
| Elongation        | 27%            |
| CVN Impact Values | 50J av @ -30°C |

### TYPICAL ALL WELD METAL ANALYSIS:

#### USING ARGON + 18-25% CO<sub>2</sub>:

|     |        |
|-----|--------|
| C:  | 0.04%  |
| Si: | 0.73%  |
| Mn: | 1.62%  |
| P:  | 0.013% |
| S:  | 0.014% |

## DESCRIPTION AND APPLICATIONS:

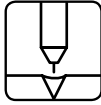

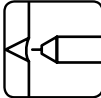
Metal-Cor 3 is a next generation metal cored wire offering the operator appeal of a metal cored wire with deposition rates similar to that of solid wire and combining impressive low temperature impact values comparable to those of a Grade 3 wire. Metal-Cor 3 offers a wide range of operating parameters and is ideal for high productivity welding of mild and medium strength carbon steels. Metal-Cor 3 produces low fume levels, low spatter and excellent edge wetting for outstanding operator appeal.

For optimum performance Metal-Cor 3 is recommended for use on DC electrode positive polarity (DCEP).

Metal-Cor 3 is formulated for use with Argon + 18-25% CO<sub>2</sub> or equivalent shielding gas

## OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive using Argon + 18-25% CO<sub>2</sub> shielding gas with a flow rate of 15-20 litres/min.

| WIRE DIAMETER (MM) | CURRENT RANGE (AMPS) | VOLTAGE RANGE (VOLTS) | CTWD  | WELDING POSITION  |            |
|--------------------|----------------------|-----------------------|-------|---|------------|
| 1.2                | 200-290              | 24-32                 | 20-25 |    | Flat       |
| 1.6                | 220-340              | 24-32                 | 25-30 |   |            |
| 1.2                | 180-270              | 23-31                 | 20-25 |   | HV Fillet  |
| 1.6                | 200-320              | 24-31                 | 25-30 |   |            |
| 1.2                | 180-270              | 23-31                 | 20-25 |  | Horizontal |
| 1.6                | 200-320              | 24-31                 | 25-30 |   |            |

These machine settings are a guide only. Actual voltage, welding current and CTWD used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc

## TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

<3.0 mls of hydrogen / 100gms of deposited weld metal.

## PACKAGING DATA:

| WIRE DIAMETER (MM) | TYPE  | PACK WEIGHT | PACK PART NO. |
|--------------------|-------|-------------|---------------|
| 1.2                | Spool | 15kg        | 722909        |
| 1.6                | Spool | 15kg        | 722910        |



P/N: 722909



P/N: 722910

