

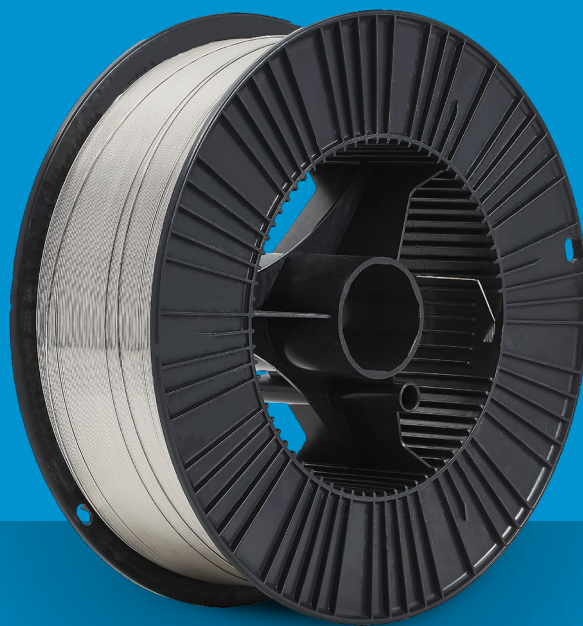
CIGWELD

AN ESAB BRAND

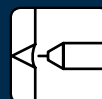
MCAW

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 ₂ (18-25%)	

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

USING ARGON + 18-25% CO₂:

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% CO₂:

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, clean mitre welds, impressive low temperature impact values and higher deposition rates than solid wires. 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 (DCEP).

Metal-Cor 3 is formulated for use with Argon + 18-25% CO₂ or equivalent shielding gas

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

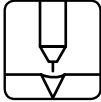
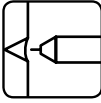
<3.0 mls of hydrogen / 100gms of deposited weld metal.

PACKAGING DATA:

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

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive using Argon + 18-25% CO₂ 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



P/N: 722909



P/N: 722910

