

METAL-COR 5 H4

PRODUCT DATA SHEET



SEAMLESS COPPER COATED METAL CORED WIRE



METAL-COR 5 H4

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

CLASSIFICATIONS:

AS/NZS 17632:

B T 49 4 T15 0 M A U 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*- Cert supplied

Ar+CO₂ (18-25%)

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

USING ARGON + 18-25% CO₂:

Yield Stress	460 MPa.
Tensile Strength	530 MPa.
Elongation	32%
CVN Impact Values	110J av @ -40°C

TYPICAL ALL WELD METAL ANALYSIS:

USING ARGON + 18-25% CO₂:

C:	0.07%
Mn:	0.9%
Si:	0.56%
S:	0.014%
P:	0.013%
Ni:	0.04%
Cr:	0.03%

DESCRIPTION AND APPLICATIONS:

Metal-Cor 5 H4 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 5 wire. Metal-Cor 5 H4 offers a wide range of operating parameters and is ideal for high productivity welding of mild and medium strength carbon steels. Metal-Cor 5 H4 produces low fume levels, low spatter and excellent edge wetting for outstanding operator appeal.

For optimum performance Metal-Cor 5 H4 is recommended for use on DC electrode positive (DCEP).

Metal-Cor 5 H4 is formulated for use with Argon + 18-25% CO₂ or equivalent shielding gas

*1.2mm Metal-Cor 5 H4 can be used in short arc or pulsed transfer to facilitate welding in all positions.

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

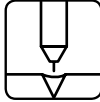
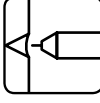
<3.5 mls of hydrogen / 100gms of deposited weld metal.

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	720552
1.6	Spool	15kg	720553

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 1.6	280-350 350-450	28-33 29-33	20-25 25-30	 Flat
1.2 1.6	250-300 300-380	27-31 27-31	20-25 25-30	 HV Fillet
1.2 1.6	250-300 300-380	27-31 27-31	20-25 25-30	 Horizontal

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: 720552



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