

CIGWELD

AN **ESAB** BRAND

**PRO
SERIES**

METAL-COR 5XP



METAL-COR 5XP is an impressive Grade 4 impact, full iron powder cored wire recommended for a wide range of high speed fillet and butt welding applications in all downhand positions.

Combining the high deposition rates of a flux cored wire and the high efficiency of a solid wire, METAL-COR 5XP is ideal for the high productivity fillet and butt welding of mild and medium strength carbon steels requiring high impact strength.

METAL-COR 5XP produces low fume levels.

The smooth "spray arc transfer" gives low spatter levels and good weld metal edge wetting for exceptional operator appeal.



CLASSIFICATIONS

AS/NZS ISO 17632 B: T494T15-OMA-UH5

AWS/ASME-SFA A5.18: E70C-6M H4

AWS/ASME-SFA A5.36: E70T15-M21A4-CS1

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

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

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Using Argon+ 10-25% CO₂

Yield Stress. 460 MPa

Tensile Strength 560 MPa

Elongation 28%

CVN Impact Values >47J av @ -40°C

RECOMMENDED SHIELDING GASES:

Ar + 10 to 25% CO₂ or Equivalent EN439:M21

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive using Argon +10-25% CO₂ shielding gas with a flow rate of 15–20 litres/min.

Wire Diameter (mm)	Current Range (amps)	Voltage Range (Volts)	CTWD	Welding Positions
1.2	280-350	28-33	20-25	Flat
1.6	350-450	29-33	25-30	
1.2	250-300	25-31	20-25	HV Fillet
1.6	300-380	27-31	25-30	
1.2	250-300	27-31	20-25	Horizontal
1.6	300-380	27-31	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.

FEATURES

Metal Cored Flux Cored wire

- High deposition efficiency & deposition rates
- Vacuum packed in foil for protection against moisture
- Product label including Batch Number, P/N and Description, Size & Weight on the foil
- Spool wrapped in VPI paper and a Silica Gel satchel to prevent any moisture build up or rusting
- Precision layered wound
- Low level of remaining manufacturing lubricant
- Product labels on both sides of the spool
- Metal-Cor 5XP is Grade-4 with a H4 classification.
- It is designed to run on Mixed Argon+CO₂ shielding gases, ranging from 10-25% CO₂.
- For use with lower CO₂ concentrations ~10% use a closer stick out to achieve spray arc (same as MIG Welding).
- Weld layer transitions in multilayer fillet welds are very smooth and even.
- Spatter levels on Metal-Cor 5XP are very low to extremely low

ORDERING INFO

Wire Diameter	Type	Pack Weight	Part No.
1.2	Spool	15kg	721552
1.6	Spool	15kg	721553



CIGWELD Pty Ltd An ESAB Brand 71 Gower Street, Preston VIC 3072 Australia
Customer Care: Tel: 1300 654 674 Fax: 03 9474 7391 | Email: enquiries@cigweld.com.au
International Enquiries: Tel: +61 3 9474 7508 Fax: +61 3 9474 7488



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