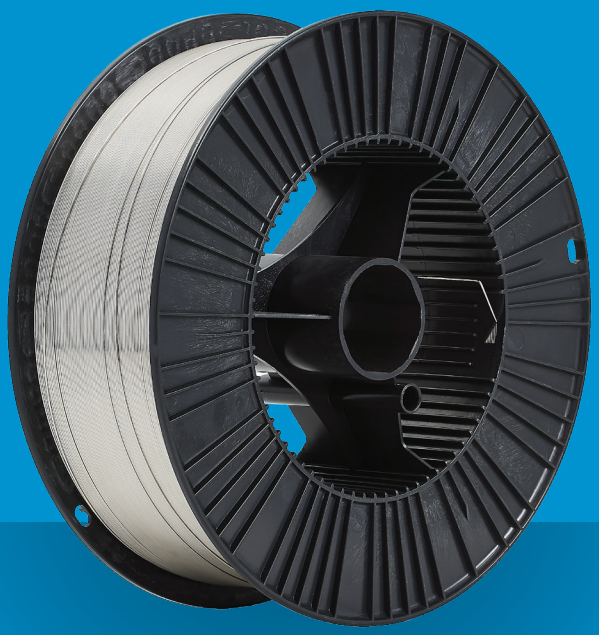
CIGWELD

AN ESAB BRAND

FCAW



SATIN-COR XP

PRODUCT DATA SHEET

SMOOTH RUNNING RUTILE TYPE FLUX CORED WIRE

FLUX CORED ARC WELDING (FCAW) WIRES

SATIN-COR XP

- Rutile Type Flux Cored Wire Formulated for Use with CO_2 Shielding Gas.
- 1.6mm can be used with Argon + 18-25% CO_2 or CO_2.
- High Speed, Downhand Welding Applications.
- Excellent Operator Appeal.
- Superior Fillet Shape and Slag Lift.
- Precision Layer Wound.

CLASSIFICATIONS:

ISO AS/NZS: 17632	**B T 49 2 T1 0 C A H10**
AWS/ASME-SFA A5.20:	**E70T-1H8**
1.6MM ONLY	
AS 2203.1:	**ETD-GC/Mp-W502A. CM1 H10**
ISO AS/NZS: 17632	**B T 49 2 T1 0 M A H10**
AWS/ASME-SFA A5.20:	**E70T-1H8, E70T-1M H8**

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

5-6mls of hydrogen / 100gms of deposited weld metal.

For welded product using welding grade CO_2 shielding gas.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	CO_2:	Argon + 18-25% CO_2:
Yield Stress	**430 MPa**	**465 MPa (1.6mm)**
Tensile Strength	**560 MPa**	**550 MPa**
Elongation	**25%**	**26%**
CVN Impact Values	**84 J av @ 0°C**	**70 J av @ 0°C**

DESCRIPTION AND APPLICATIONS:

Satin-Cor XP is a smooth running rutile type flux cored wire recommended for the high speed fillet and butt welding of mild and medium strength steels using welding grade carbon dioxide shielding gas. The 1.6mm size is formulated for use with either CO_2 or Argon + 18-25% CO_2.

The fluid, full covering slag system of Satin-Cor XP gives superior fillet shapes in all downhand (flat, horizontal and horizontal-vertical) welding positions. The smooth arc transfer using CO_2 shielding gas produces low spatter levels and the full covering slag is easy to control and self-releasing in many joint preparations. Satin-Cor XP is designed for the high productivity, single and multi-pass welding of mild and medium strength steels in the flat, horizontal and horizontal-vertical positions. It is particularly recommended for the downhand fillet welding of structural steels of 6mm thickness or heavier.

TYPICAL ALL WELD METAL ANALYSIS:

	CO_2:	Argon + 18-25% CO_2 (1.6mm ONLY):
C:	**0.04%**	**0.05%**
Mn:	**1.4%**	**1.65%**
Si:	**0.41%**	**0.61%**

RECOMMENDED SHIELDING GAS:

AS 4882:	**SG-C** **SG-AC-18, OR SG-AC-20**
ISO 14175 / AWS A5.32:	**C1*- CERT SUPPLIED** **M21**

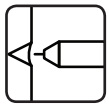
Welding grade CO_2 or Ar+CO_2 (18-25%)

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.6	Spool	15kg	720904

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO_2 shielding gas with a flow rate of 10-15 litres/min.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING POSITION	
1.6	350-450	28-33 2	5-30		Flat
1.6	300-400	26-30	25-30		HV Fillet
1.6	270-350	25-29	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.