



# **SUPRE-COR 5** PRODUCT DATA SHEET

## SECOND GENERATION, FULLY BASIC FLUX CORED WIRE



### FLUX CORED ARC WELDING (FCAW) WIRES

#### **SUPRE-COR 5**

- Second Generation, Fully Basic Flux Cored Wire.
- Improved Low Temperature Impact Toughness to -50°C.

#### Improved Positional Capabilities of 1.2mm and 1.6mm sizes.

• Precision Layer Wound.

### **CLASSIFICATIONS:**

ISO AS/NZS 17632: AWS/ASME-SFA A5.20: B T 49 5 T5 1 M A U H5 E71T-5 H4, E71T-5MJ H4

#### TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

<2.5 mls of hydrogen / 100gms of deposited weld metal.

#### **TYPICAL ALL WELD METAL ANALYSIS:**

USING ARGON + 18-25% CO <sub>2</sub> :	
C:	0.07%
Mn:	1.38%
Si:	0.74%

# TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

USING ARGON + 18-25% CO <sub>2</sub> :	
Yield Stress	490 MPa
Tensile Strength	550 MPa
Elongation	28%
CVN Impact	90 J av @ -51°C Values





#### **DESCRIPTION AND APPLICATIONS:**

Supre-Cor 5 is a second generation, fully basic flux cored wire producing outstanding low temperature impact properties using CO2, Argon or equivalent shielding gases.

For all welding applications with Supre-Cor 5 electrode negative is the preferred polarity.

The premium quality weld metal and 'very low' hydrogen class of Supre-Cor 5 make it suitable for a wide range of critical applications including the fillet and butt welding of pressure vessels, offshore oil and gas platform structures and heavy earth moving equipment. Excellent weld deposit properties are achieved in both the 'as welded' and 'stress relieved' conditions.

#### **RECOMMENDED\*** SHIELDING GAS:

AS 4882:	SG-C SG-AC-18, or SG-AC-20
ISO 14175 / AWS A5.32:	C1 M21*- Cert Supplied

Welding grade  $CO_2$  or Ar+CO<sub>2</sub> (18-25%)

### PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	720982
1.6	Spool	15kg	720983

#### **OPERATING DATA:**

All welding conditions recommended below are for use with semi-automatic operation and DC electrode negative 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 1.6	250-300 330-380	26-30 26-30	20-25 25-30		Flat
1.2 1.6	230-280 310-360	25-29 25-29	20-25 25-30		HV Fillet
1.2 1.6	160-210 180-230	23-27 23-27	15-20 15-20		Vertical Up
1.2 1.6	160-210 180-230	23-27 23-27	15-20 15-20		Overhead

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.





