

## VERTI-COR 3XP H4

### PRODUCT DATA SHEET



### NEXT GENERATION TECHNOLOGY FLUX CORED WIRE



### FLUX CORED ARC WELDING (FCAW) WIRES

#### VERTI-COR 3XP H4

- Next generation technology flux cored laser welded seamless wire.
- Non-Copper-Coated for smooth consistent feedability and current pick up.
- Rutile, all positional capabilities producing a flat mitre fillet bead shape.
- Ultra low splatter and no copper coating equates to very low Fume Levels.
- H4 diffusible hydrogen class with a typical weldmetal of 2.2 mls of hydrogen/100 gms.

#### CLASSIFICATIONS:

ISO AS/NZS 17632: B T 49 3 T12 1 M A U H5

AWS/ASME-SFA A5.20: E71T-12M H4

#### RECOMMENDED SHIELDING GAS:

ARGON + 18-25% CO<sub>2</sub> ISO14175: M21,M24, M21 (1)

#### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

##### USING ARGON + 18-25% CO<sub>2</sub>:

Yield Stress	510 MPa
Tensile Strength	570 MPa
Elongation	30%
CVN Impact Values	> 47 J av @ -30°C

#### TYPICAL ALL WELD METAL ANALYSIS:

##### USING ARGON + 18-25% CO<sub>2</sub>:

C:	0.05%
Mn:	1.25%
Si:	0.43%
P:	0.009%
S:	0.007%



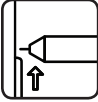
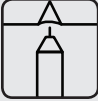
## DESCRIPTION AND APPLICATIONS:

Verti-Cor 3XP H4 is a seamless, low-hydrogen (H4) non-copper-coated flux cored wire. It features laser welded seams to combat moisture absorption in humid environments, delivering impact toughness to below -30 deg C. Being a rutile type FC wire it is designed for downhand, vertical-up and overhead fillet and butt welding applications. Verti-Cor 3XP H4 is suitable for welding a wide range of mild to medium strength steels with Argon + 18-25% CO<sub>2</sub> shielding gases (or equivalent) and is formulated to give smooth, mitre fillet welds in all positions with very low spatter levels and a self-releasing slag. The advanced non-copper coated seamless wire has unique features and benefits including:

- Improved wire feeding which eliminates 'bird nests' at the wire feeder.
- Improved current transfer at the welding torch for smooth, consistent arc starting.
- 'Very low AWS: H4 and AS: H5 diffusible hydrogen status for improved resistance to hydrogen induced cold cracking of the weld deposit.
- The elimination of moisture reabsorption in the flux core for maintenance of the 'very low hydrogen status' following exposure to the atmosphere.

## OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and 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	OPTIMUM AMPS	VOLTS	WELDING POSITION	
1.2	250-300	27-31	20-25	280	31		Flat
1.6	350-400	27-31	25-30	360	31		
1.2	230-280	26-30	20-25	260	28		HV Fillet
1.6	310-360	26-30	25-30	320	29		
1.2	170-220	24-28	15-20	200	24		Vertical Up
1.6	200-250	24-28	15-20	240	25		
1.2	160-210	24-28	15-20	200	24		Overhead
1.6	190-240	24-28	15-20	220	24		

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.

## TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

2.2 mls of hydrogen / 100gms of deposited weld metal \*.

\*For "as manufactured" product using Argon + 18-25% CO<sub>2</sub> shielding gas.

## PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	722919
1.6	Spool	15kg	722921

