

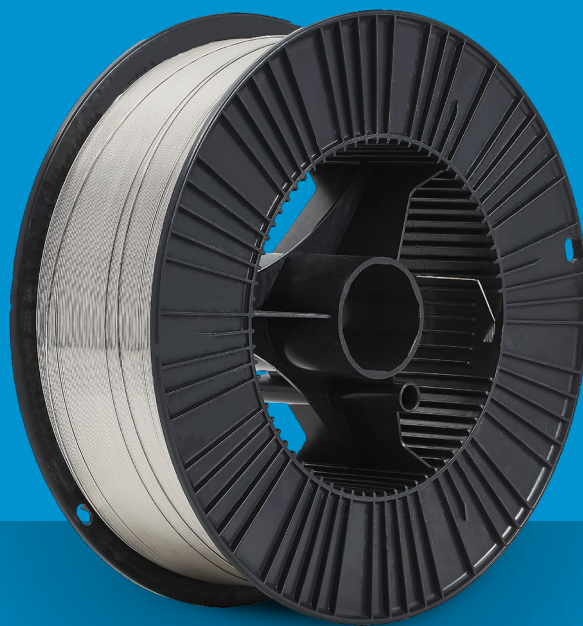
CIGWELD

AN ESAB BRAND

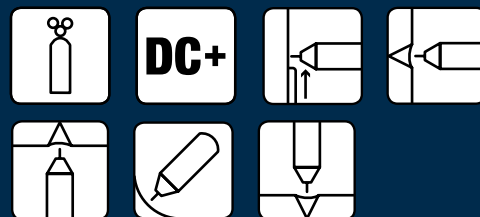
FCAW

VERTI-COR 3XP

PRODUCT DATA SHEET



MICROALLOYED, RUTILE TYPE FLUX CORED WIRE



VERTI-COR 3XP

- Versatile, All Positional Capabilities

CLASSIFICATIONS:

ISO AS/NZS: 17632: B T 49 3 T12 A C A U H10
B T 49 3 T12 M A U H10

AWS/ASME-SFA A5.20: E71T-1 H8
E71T-12M H8

RECOMMENDED SHIELDING GAS:

AS 4882: ISO 14175 / AWS A5.32:

SG-C C1

SG-AC-18, or SG-AC-20 M21*- Cert supplied

Welding grade CO₂ or Ar+CO₂ (18-25%)

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	USING ARGON + 18-25% CO ₂ :	USING CO ₂ :
Yield Stress	480 MPa	460 MPa
Tensile Strength	560 MPa	530 MPa
Elongation	28%	30%
CVN Impact Values	115J av @ -20°C. 95J av @ -30°C.	95J av @ -20°C 80J av @ -30°C

TYPICAL ALL WELD METAL ANALYSIS:

	USING ARGON + 18-25% CO ₂ :	USING CO ₂ :
C:	0.07%	0.06%
Mn:	1.16%	1.05%
Si:	0.52%	0.42%
Ti:	0.035%	0.035%
B:	0.008%	0.007%

CIGWELD Data Sheet VERTI-COR 3XP V1-2023

CIGWELD Pty Ltd An ESAB Brand.

www.cigweld.com.au

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DESCRIPTION AND APPLICATIONS:

Verti-Cor 3XP is a microalloyed rutile type flux cored wire designed for downhand, vertical-up and overhead fillet and butt welding applications.

Formulated to give smooth (low spatter) arc transfer, flat mitre fillet welds and excellent slag lift in all positions (except vertical-down), Verti-Cor 3XP is suitable for welding a wide range of mild and medium strength steels.

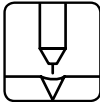
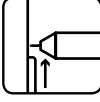
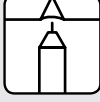
For optimum arc performance and weld deposit impact toughness Argon + 18-25% CO₂ or CO₂ shielding gases are recommended.

TYPICAL WELD METAL MECHANICAL PROPERTIES:

Actual weld metal mechanical properties achieved with Verti-Cor 3XP are influenced by many factors including, base metal analysis, welding parameters/ heat input used, shielding gas selection, number of weld passes and run placement, etc. Please consult your nearest CIGWELD distributor for welding procedure recommendations.

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	250-300 350-400	27-31 27-31	20-25 25-30		Flat
1.2 1.6	230-280 310-360	26-30 26-30	20-25 25-30		HV Fillet
1.2 1.6	170-220 200-250	24-28 24-28	15-20 15-20		Vertical up
1.2 1.6	160-210 190-240	24-28 24-28	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.



TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

5-6 mls of hydrogen / 100gms of deposited weld metal for "as manufactured" product using Argoshield 52 shielding gas.

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	720919
1.6	Spool	15kg	720921

P/N: 720919



P/N: 720921

