

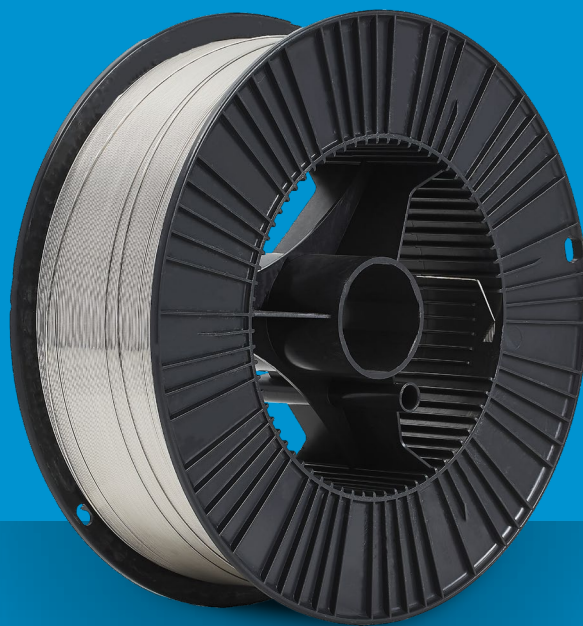
CIGWELD

AN ESAB BRAND

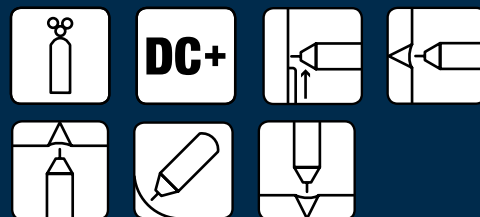
FCAW

VERTI-COR XP

PRODUCT DATA SHEET



**VERSATILE, SMOOTH RUNNING,
GENERAL PURPOSE, RUTILE
TYPE FLUX CORED WIRE**



VERTI-COR XP

- Excellent Operator Appeal
- All positional capabilities
- Vacuum Packed

CLASSIFICATIONS:

AS/NZS: 17632:	BT 49 3 T1 C A U H10 BT 49 3 T1 M A U H10
AWS/ASME-SFA A5.20:	E71T-1M H8 E71T-1C 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	469 MPa	460 MPa
Tensile Strength	565 MPa	555 MPa
Elongation	28%	28%
CVN Impact Values	75J av @ -30°C.	70J av @ -30°C

TYPICAL ALL WELD METAL ANALYSIS:

	USING ARGON + 18-25% CO ₂ :	USING CO ₂ :
C:	0.06%	0.05%
Mn:	1.24%	1.15%
Si:	0.33%	0.22%
S:	0.01%	0.01%
P:	0.01%	0.01%

DESCRIPTION AND APPLICATIONS:

Verti-Cor XP is a versatile rutile type flux cored wire designed for all positional fillet and butt welding applications using Argon + 18-25% CO₂ and CO₂ shielding gases. Verti-Cor XP is characterised by its smooth transfer arc characteristic and all positional capabilities while offering smooth genuine mitre fillets in all positions.



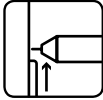
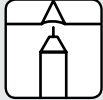
Reliable impact properties down to -30 deg C on both mixed gas and CO₂ are other attributes of Verti-Cor XP.

TYPICAL WELD METAL MECHANICAL PROPERTIES:

Actual weld metal mechanical properties achieved with Verti-Cor XP 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 10-15 litres/min.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING POSITION	
1.2 1.6	150-250 280-400	23-28 28-34	15-20 25-30		Flat
1.2 1.6	150-200 250-350	23-28 28-34	15-20 25-30		HV Fillet
1.2 1.6	120-180 200-250	22-27 23-27	15-20 20-25		Vertical up
1.2 1.6	140-180 190-250	22-27 23-27	15-20 20-25		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 Argon + 18-25% CO₂.

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	720915
1.6	Spool	15kg	720917

P/N: 720915



P/N: 720917

