CIGWELD

AN ESAB BRAND

FCAW

VERTI-COR ULTRA

PRODUCT DATA SHEET

SMOOTH RUNNING ALL POSITIONAL FLUX CORED WIRE

FLUX CORED ARC WELDING (FCAW) WIRES

VERTI-COR ULTRA

- Rutile Type Flux Cored Wire Formulated Exclusively for CO_2 Shielding Gas.
- Versatile, All Positional Capabilities.
- Excellent Operator Appeal.
- Low spatter and fume levels.

CLASSIFICATIONS:

ISO AS/NZS: 17632	**B T 49 2 T1 1 C A H10**
AWS/ASME-SFA A5.20:	**E71T-1H8**

RECOMMENDED SHIELDING GAS:

AS 4882:	**SG-C**
ISO 14175 / AWS A5.32:	**M21*- CERT SUPPLIED**

Welding grade CO_2

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

USING WELDING GRADE CO_2:	
Yield Stress	**480 MPa**
Tensile Strength	**560 MPa**
Elongation	**28%**
CVN Impact Values	**80 J av @ 0°C**

TYPICAL ALL WELD METAL ANALYSIS:

USING CO_2 SHIELDING GAS:	
C:	**0.04%**
Mn:	**1.24%**
Si:	**0.70%**
Ti:	**0.035%**
B:	**0.005%**

CIGWELD Data Sheet **VERTI-COR ULTRA V1-2024**
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V1-2024

DESCRIPTION AND APPLICATIONS:

Verti-Cor Ultra is a smooth running all positional flux cored wire which offers improved operator appeal and lower fume and spatter levels under welding grade carbon dioxide shielding gas.

Verti-Cor Ultra offers significant welding improvements compared with conventional E71T-1 wires, in particular 50-60% less spatter and ≈ 20% less fume.

Verti-Cor Ultra is designed for the single and multi-pass welding of mild and medium strength steels in the downhand, vertical-up and overhead positions. It is recommended for general steel construction and fabrication welding where the work cannot be rotated to the downhand positions.

TYPICAL WELD METAL MECHANICAL PROPERTIES:

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

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

5.0 - 6.0 mls of hydrogen / 100gms of deposited weld metal *.

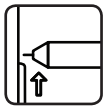
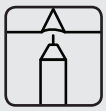
* - for "as manufactured" product using welding grade CO_2 shielding gas.

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	720900
1.6	Spool	15kg	720902

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	
1.2 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.