

CIGWELD

AN **ESAB** BRAND

**PRO
SERIES**

VERTI-COR 3XP H4

**NEW &
IMPROVED
COPPER FREE**

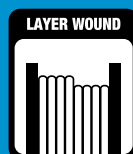
ENHANCED OPERATOR
HEALTH & SAFETY
OUTSTANDING
FEEDABILITY
LOW FUME



- ✓ Improved Seamless H4 wire to the same classifications and now copper free
- ✓ Improved deposition rates
- ✓ Improved corrosion protection due to ASC Surface coating
- ✓ Improved feedability and electrical current transfer due to ASC surface coating
- ✓ Drastically reduced Copper fume enhancing operator health and safety
- ✓ Environmentally friendly manufacturing processes i.e. no dangerous copper electroplating chemical waste
- ✓ A lower price plus all the improvements!

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VERTI-COR 3XP H4

VERTI-COR 3XP H4 is a seamless rutile type FC wire 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 + 10-25% CO₂ 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 seamless tube in tube technology gives rise to several unique features and benefits including:

- Next generation technology flux cored wire, for smooth consistent feedability and current pick up
- Rutile, all positional capabilities producing a flat mitre fillet bead shape
- Ultra low splatter and fume levels
- H4 diffusible hydrogen class with a typical weldmetal of 2.2 mls of hydrogen/100 gms
- 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 hydrogen status' following exposure to the atmosphere

CLASSIFICATIONS

AS/NZS 2203.1: (old) ETP-GMp-W503A. CM1 H5.

AS/NZS: 17632 (new) B T 49 3 T12 1 M A N2 U H5

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

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Using Argon+ 10-25% CO₂

Yield Stress.	510 MPa
Tensile Strength	570 MPa
Elongation	30%
CVN Impact Values	>105J av @ -20°C

RECOMMENDED SHIELDING GASES:

Ar +10 – 25% CO₂ or EN/ISO 14175: M21, M24, M21(1) Gases

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive using Argon +10-25% CO₂ shielding gas with a flow rate of 15–20 litres/min.

Wire Diameter (mm)	Current Range (amps)	Voltage Range (Volts)	CTWD	Welding Positions
1.2	250-300	27-31	20-25	Flat
1.6	350-400	27-31	25-30	
1.2	230-280	26-30	20-25	HV Fillet
1.6	310-360	26-30	25-30	
1.2	170-220	24-28	15-20	Vertical Up
1.6	200-250	24-28	15-20	
1.2	160-210	24-28	15-20	Horizontal
1.6	190-240	24-28	15-20	

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.

ORDERING INFO

Wire Diameter	Type	Pack Weight	Part No.
1.2	Spool	15kg	722919
1.6	Spool	15kg	722921



CIGWELD Pty Ltd An ESAB Brand 71 Gower Street, Preston VIC 3072 Australia
 Customer Care: Tel: 1300 654 674 Fax: 03 9474 7391 | Email: enquiries@cigweld.com.au
 International Enquiries: Tel: +61 3 9474 7508 Fax: +61 3 9474 7488



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WE RECOMMEND GENUINE CIGWELD PRODUCTS

