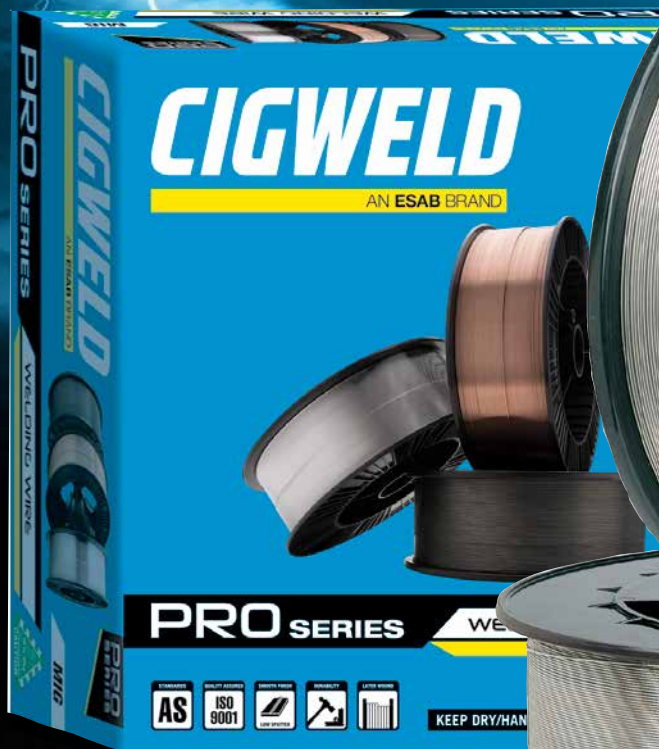


CIGWELD

PRO
SERIES

AN ESAB BRAND

METAL-COR XP



METAL-COR XP is a full iron powder cored wire recommended for a wide range of high speed fillet and butt welding applications in all downhand positions.

Combining the high deposition rates of a flux cored wire and the high efficiency of a solid wire, METAL-COR XP is ideal for the high productivity fillet and butt welding of mild and medium strength carbon steels.

METAL-COR XP produces low fume levels. The smooth “spray arc transfer” gives low spatter levels and good weld metal edge wetting for exceptional operator appeal.



CLASSIFICATIONS

AS/NZS ISO 17632 B: T493T15-OMA-UH5

AWS/ASME-SFA A5.18: E70C-6M H4

AWS/ASME-SFA A5.36: E70T15-M21A3-CS1

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

<3.5 mls of hydrogen / 100gms of deposited weld metal

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Using Argon+ 10-25% CO₂

Yield Stress. 460 MPa

Tensile Strength 560 MPa

Elongation 28%

CVN Impact Values >47J av @ -30°C

RECOMMENDED SHIELDING GASES:

Ar + 10 to 25% CO₂ or Equivalent EN439:M21

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	280-350	28-33	20-25	Flat
1.6	350-450	29-33	25-30	
1.2	250-300	25-31	20-25	HV Fillet
1.6	300-380	27-31	25-30	
1.2	250-300	27-31	20-25	Horizontal
1.6	300-380	27-31	25-30	

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.

FEATURES

Metal Cored Flux Cored wire

- High deposition efficiency & deposition rates
- Vacuum packed in foil for protection against moisture
- Product label including Batch Number, P/N and Description, Size & Weight on the foil
- Spool wrapped in VPI paper and a Silica Gel satchel to prevent any moisture build up or rusting
- Precision layered wound
- Low level of remaining manufacturing lubricant
- Product labels on both sides of the spool
- Easy bend and snap of the wire for restarts
- Metal-Cor XP is Grade-3 with a H4 classification.
- It is designed to run on Mixed Argon+CO₂ shielding gases, ranging from 10-25% CO₂.
- For use with lower CO₂ concentrations ~10% use a closer stick out to achieve spray arc (same as MIG Welding).
- Weld layer transitions in multilayer fillet welds are very smooth and even.
- Spatter levels on Metal-Cor XP are very low to extremely low

ORDERING INFO

Wire Diameter	Type	Pack Weight	Part No.
1.2	Spool	15kg	720912
1.6	Spool	15kg	720913

