



DEPOSITION DATA

CIGWELD Electrodes, Deposition Rates, Electrode Efficiencies, and Electrode Weld Metal Recovery Rates

The following Table lists some popular CIGWELD consumables and their Deposition Rates, Electrode Efficiencies and Weld Metal Recovery Rates:

CIGWELD Product	Size (mm)	Amps	Deposition Rate kg/hr	Electrode Efficiency	Weld Metal Recovery
Ferrocrafft 12XP	3.2	110	0.90	109%	66%
Ferrocrafft 12XP	4.0	150	1.20	111%	69%
Satincrafft 13	3.2	115	0.92	91%	56%
Satincrafft 13	4.0	160	1.30	92%	58%
Ferrocrafft 11	3.2	110	1.00	90%	64%
Ferrocrafft 11	4.0	145	1.30	90%	66%
Ferrocrafft 21	3.2	120	1.20	113%	63%
Ferrocrafft 21	4.0	170	1.70	112%	62%
Ferrocrafft 22	3.2	150	2.00	155%	59%
Ferrocrafft 22	4.0	210	2.80	157%	61%
Ferrocrafft 16TXP	3.2	120	1.20	95%	58%
Ferrocrafft 16TXP	4.0	165	1.60	90%	56%
Ferrocrafft 7016	3.2	120	1.10	101%	63%
Ferrocrafft 7016	4.0	170	1.50	97%	60%
Ferrocrafft 61	3.2	125	1.30	110%	57%
Ferrocrafft 61 H4	3.2	125	1.30	110%	57%
Ferrocrafft 61	4.0	180	1.80	113%	59%
Alloycraft 90	3.2	125	1.30	111%	60%
Alloycraft 90	4.0	180	1.80	114%	62%
Satincrome 316L-17	3.2	95	0.90	105%	55%
Satincrome 316L-17	4.0	130	1.10	108%	54%
Castcraft 55	3.2	100	0.95	116%	69%
Castcraft 55	4.0	125	1.15	115%	70%
Cobalarc 750	3.2	115	1.00	109%	62%
Cobalarc 750	4.0	145	1.30	112%	64%
Cobalarc CR70	3.2	115	1.20	191%	69%
Cobalarc CR70	4.0	165	1.70	206%	71%
Cobalarc 9	8.0	180	1.30	85%	77%

The information provided in this table is a guide only, actual on the job figures may vary. Results are influenced by many factors including, welding parameters, arc length, travel speed and machine characteristics.

CIGWELD Solid and Flux Cored Wires, Deposition and Weld Metal Recovery Rates

The following Table lists some popular CIGWELD consumables and their Deposition and Weld Metal Recovery Rates:

CIGWELD Product	Size (mm)	Volts	Amps	WFS m/min	Deposition Rate kg/hr	Weld Metal Recovery
Autocraft LW1-6	0.8	20	150	12.0	2.5	96%
Autocraft LW1-6	0.9	26	180	12.0	3.1	96%
Autocraft LW1-6	1.0	28	240	13.5	4.8	95%
Autocraft LW1-6	1.2	32	300	10.8	5.6	97%
Autocraft Silicon Bronze	0.9	24	180	13.2	3.2	95%
Autocraft 316LSi	0.9	22	180	10.0	2.8	97%
Autocraft 316LSi	1.2	26	250	8.5	4.4	98%
Autocraft AL5356	1.0	22	180	16.3	1.5	90%
Autocraft AL5356	1.2	24	220	14.0	2.5	92%
Satin-Cor XP	1.6	28	300	5.5	4.3	86%
Satin-Cor XP	1.6	29	350	6.5	5.4	87%
Satin-Cor XP	1.6	30	400	7.0	6.0	89%
Satin-Cor XP	2.4	30	400	4.2	5.7	85%
Satin-Cor XP	2.4	31	450	5.0	6.8	86%
Satin-Cor XP	2.4	32	500	6.0	8.2	90%
Verti-Cor 3XP	1.2	25	200	6.7	2.7	86%
Verti-Cor 3XP	1.2	26	250	9.9	3.8	84%
Verti-Cor 3XP	1.2	28	320	15.0	5.9	88%
Verti-Cor 3XP	1.6	27	300	6.2	4.1	86%
Verti-Cor 3XP	1.6	28	350	9.5	6.4	81%
Verti-Cor 3XP	1.6	29	400	12.0	8.1	88%
Metal-Cor XP	1.2	26	250	10.0	5.0	92%
Metal-Cor XP	1.6	28	350	6.6	5.6	94%
Supre-Cor 5	1.2	22	170	7.8	2.3	86%
Supre-Cor 5	1.6	26	320	5.9	3.3	89%
Tensi-Cor 110TXP	1.6	28	280	5.0	3.0	88%
Tensi-Cor 110TXP	2.4	29	400	3.8	5.8	90%
Shieldcrome 309LT	1.2	26	190	11.4	3.7	84%
Shield-Cor 4XP	2.4	29	375	5.4	7.0	84%
Shield-Cor 4XP	3.0	30	500	2.9	6.7	86%
Shield-Cor 15	0.9	17	120	3.9	0.7	75%
Shield-Cor 11	1.2	17	150	3.0	1.0	80%

The information provided in this table is based on welding with constant voltage (C.V.) GMA Welding machines. Results may vary and are influenced on the job by shielding gases used, machine settings, stick out, spatter losses, wire sniped off before starts etc.