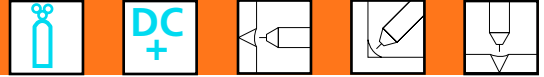


SATIN-COR XP



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Using welding grade CO ₂ :	
Yield Stress.	485 MPa
Tensile Strength	595 MPa
Elongation	27%
CVN Impact Values 84J av @ 0°C.	

TYPICAL ALL WELD METAL ANALYSIS USING CO₂ SHIELDING GAS:

C: 0.08%	Mn: 1.38%	Si: 0.55%
S: 0.011%	P: 0.016%	

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 CO₂ shielding gas.

APPROVALS*:

Lloyds Register of Shipping Grade 2YS H15.
* - with welding grade CO₂ shielding gas.

- ▲ A Rutile Type Flux Cored Wire Formulated Exclusively for CO₂ Shielding Gas.
- ▲ For High Speed, Downhand Welding Applications.
- ▲ Excellent Operator Appeal.
- ▲ Superior Fillet Shape and Slag Lift.
- ▲ Recommended for the downhand fillet welding of structural steels of 6mm thickness or heavier.

Classifications:

AS/NZS 2203.1:	ETD-GCp-W502A. CM1 H10.
AWS/ASME-SFA A5.20:	E70T-1H8.

Packaging Data:

Wire Diameter (mm)	Type	Pack Weight	Pack Part No.
1.6	Spool	15kg	720904
2.4	Coil	25kg	720906

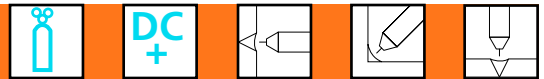
Operating Data:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO₂ shielding gas with a flow rate of 15-20 litres/min.

Wire Dia. (mm)	Current Range (amps)	Voltage Range (volts)	Electrode Stickout E.S.O. (mm)	Optimum Amps	Volts	Welding Positions
1.6	350 - 450	28 - 33	25 - 30	380	30	Flat
2.4	400 - 550	28 - 33	25 - 35	450	30	
1.6	300 - 400	26 - 30	25 - 30	330	29	HV Fillet
2.4	350 - 450	26 - 30	25 - 30	400	29	
1.6	270 - 350	25 - 29	25 - 30	300	28	Horizontal
2.4	320 - 420	25 - 29	25 - 30	360	28	

These machine settings are a guide only. Actual voltage, welding current and E.S.O. used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

SATIN-COR HD70



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Using CO ₂ :	Argon +20-25% CO ₂ :
Yield Stress 520 MPa	545 MPa
Tensile Strength 615 MPa	630 MPa
Elongation 27%	25%
CVN Impact Values 65J av @ 0°C. 53J av @ 0°C.	

APPROVALS*:

Lloyds Register of Shipping Grade 2YS H15.
* - with welding grade CO₂ & Argon +20-25% CO₂ shielding gases

TYPICAL ALL WELD METAL ANALYSIS:

Using Welding Grade CO ₂ :		
C: 0.06%	Mn: 1.55%	Si: 0.83%
S: 0.013%	P: 0.023%	
Using Argon +20-25% CO ₂ :		
C: 0.06%	Mn: 1.70%	Si: 0.88%
S: 0.014%	P: 0.022%	

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

5.0 - 8.0 mls of hydrogen / 100gms of deposited weld metal *.
* - for "as manufactured" product using an Electrode Stickout (ESO) of 25mm with 1.6mm wire.

RECOMMENDED SHIELDING GAS:

- Argon + 20 - 25% CO₂.
- Welding Grade CO₂.

- ▲ A High Efficiency, Rutile Type Flux Cored Wire.
- ▲ Recommended for Use with Argon + 20-25%CO₂ or Welding Grade CO₂ Shielding Gases.
- ▲ High Speed, Downhand Welding Applications.
- ▲ For the high speed fillet and butt welding of mild and medium strength steels in all downhand positions.

Classifications:

AS/NZS 2203.1:	ETD-GCp-W502A..CM1 H10.
	ETD-GMp-W502A..CM1 H10.
AWS A5.20:	E70T-1H8, E70T-1M H8.

Packaging Data:

Wire Diameter (mm)	Type	Pack Weight	Pack Part No.
1.6	Spool	15kg	720690

Operating Data:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO₂ or Ar + 20-25% CO₂ (or equivalent) shielding gases.

Wire Dia. (mm)	Current Range (amps)	Voltage Range (volts)	Electrode Stickout E.S.O. (mm)	Optimum Amps	Volts	Welding Positions
1.6	350 - 450	28 - 33	25 - 30	380	30	Flat
1.6	300 - 400	26 - 30	25 - 30	330	29	HV Fillet
1.6	270 - 350	25 - 29	25 - 30	300	28	Horizontal

These machine settings are a guide only. Actual voltage and welding current used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.