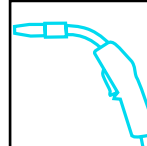


WELDING CONSUMABLES

GAS METAL ARC WELDING (MIG) WIRES



SECTION THREE

AUTOCRAFT NiCrMo



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	Argon 1-3% CO ₂ :	Argon 20-25% CO ₂ :
Yield Stress	730 MPa	707 MPa
Tensile Strength	790 MPa	770 MPa
Elongation	17%	21%
CVN Impact Val.	130 J @ -29°C	72 J @ -29°C
	80 J @ -51°C	50 J @ -51°C

TYPICAL WIRE ANALYSIS:

C: 0.08%	Mn: 1.40%	Si: 0.60%
Ni: 1.40%	Cr: 0.40%	Mo: 0.25%
V: 0.10%		

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

1.0 - 2.0 mls of hydrogen / 100gms of deposited weld metal.

RECOMMENDED SHIELDING GAS:

- Argon + 20-25% CO₂
- Argon + 1-3% O₂
- Welding Grade CO₂

COMPARABLE CIGWELD PRODUCTS:

Verti-cor 111 K3 FCAW
Tensi-Cor 110T XP FCAW

The actual weld metal mechanical properties achieved with Autocraft Ni Cr Mo are influenced by many factors including, base metal analysis, welding parameters, shielding gas selection and number of passes etc. Please consult your nearest CIGWELD branch for welding procedure recommendations.

- ▲ A Low Alloy Steel Wire for the GMA Welding of High Strength steels.
- ▲ For Use with Welding Grade CO₂ or Argon Based Shielding Gases.
- ▲ 760 MPa Tensile Class Weld Deposits.
- ▲ Suitable for the all positional fillet and butt welding of a wide range of high strength steels, particularly quenched and tempered types such as Bisalloy 80, USS-T1 types and Welten 80C etc.

Classifications:

AS/NZS 2717.1: ESMG-GC/M-W769AH.

AWS/ASME-SFA A5.28: ER110S-G.

Packaging and Operating Data:

Wire Dia mm	Voltage Range (volts)	Wire Feed Speed (metres/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
1.2	18 – 32	3.5 – 15	120 – 350	Spool	15kg	720053

* Spool (ø300mm).

AUTOCRAFT CrMo1



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	Argon 1-3% CO ₂ :
0.2% Proof Stress	500 MPa
Tensile Strength	600 MPa
Elongation	20%
CVN Impact Values	60 J av @ +20°C
Post weld heat treated at 620°C as required by AWS A5.28.	

TYPICAL WIRE ANALYSIS:

C: 0.09%	Mn: 0.60%	Si: 0.60%
Cr: 1.30%	Mo: 0.50%	P: 0.015%
S: 0.010%	Fe: Balance	

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

1.0 - 2.0 mls of hydrogen / 100gms of deposited weld metal.

RECOMMENDED SHIELDING GAS:

- Argon + 20-25% CO₂
- Argon + 1-3% O₂

COMPARABLE CIGWELD PRODUCTS:

Alloycraft 80-B2 electrode
Comweld CrMo1 TIG rod
Verti-cor 80Ni 1 FCAW

- ▲ A Low Alloy Steel Wire for the GMA welding of Matching Cr-Mo-Steels.
- ▲ Recommended for the GMA welding of 1/2Cr-1/2Mo, 1Cr-1/2Mo and 1 1/4Cr-1/2Mo steel pipes, plates and castings.

Classifications:

AS/NZS 2717.1: ESB2-GM-W559AH.

AWS/ASME-SFA A5.28: ER80S-B2.

Packaging and Operating Data:

Wire Dia mm	Voltage Range (volts)	Wire Feed Speed (metres/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
1.2	18 – 32	3.5 – 15	120 – 350	Spool	15kg	720029

* Spool (ø300mm).

AUTOCRAFT 308LSi



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	Argon 1-3% CO ₂ :
0.2% Proof Stress	450 MPa
Tensile Strength	620 MPa
Elongation	36%
CVN Impact Values	90 J av @ -60°C

TYPICAL WIRE ANALYSIS:

C: 0.02%	Mn: 2.05%	Si: 0.80%
Cr: 19.95%	Ni: 10.25%	P: 0.020%
S: 0.005%	Fe: Balance	

FERRITE NUMBER:

5 – 10 FN

RECOMMENDED SHIELDING GAS:

- Argon+ 1-3% O₂
- Argon + 2-5% CO₂

COMPARABLE CIGWELD PRODUCTS:

Satinchrome 308L-17 electrode
Comweld 308L TIG rod
Shieldchrome 308LT FCAW wire

- ▲ A Steel Wire for the GMA Welding of 304 and 304L Type Stainless Steels.
- ▲ Recommended for the general welding of 201, 302, 321, 347, 409 and 444 type stainless steels.

Classifications:

AS/NZS 2717.3: ES308LSi.

AWS/ASME-SFA A5.9: ER308LSi.

Packaging and Operating Data:

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.

Wire Dia mm	Voltage Range (volts)	Wire Feed Speed (metres/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
0.9	16 – 24	4.5 – 15.0	70 – 200	Spool	15kg	721271
1.2	20 – 28	3.0 – 10.0	150 – 280	Spool	15kg	721272

* Spool (ø300mm).