



AUTOCRAFT LW1



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Welding Grade CO ₂ :	Argon 10-25% CO ₂ :
Yield Stress 420 MPa	390 MPa
Tensile Strength 520 MPa	500 MPa
Elongation 30%	31%
CVN Impact Val. 110 J @ -20°C	100 J @ -20°C

TYPICAL WIRE ANALYSIS:

C: 0.08%	Mn: 1.16%	Si: 0.70%
S: 0.010%	P: 0.015%	

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

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

APPROVALS:

CO ₂ & Argon 10-25% CO ₂ :	
L.R.S.	Grade 3S
A.B.S.	Grade 3SA
D.N.V.	Grade IIIYMS

RECOMMENDED SHIELDING GAS:

- Argon + 10-15% CO₂
- Argon + 10-25% CO₂
- Welding Grade CO₂

COMPARABLE CIGWELD PRODUCTS:

Comweld LW1 TIG rod
Comweld LW1-6 TIG rod
Verti-Cor 3XP FCAW
Supre-Cor 5 FCAW

- ▲ A Premium Quality Low Carbon Steel Wire for GMA Welding.
- ▲ Suitable for the all positional multi-pass Gas Metal Arc welding of mild, low alloy and medium strength steels, as used in general fabrication, pressure vessels and structural work.

Classifications:

AS/NZS 2717.1:	ES4-GC/M-W503AH.
AWS/ASME-SFA A5.18:	ER70S-4.

Packaging and Operating Data:

Wire Dia mm	Voltage Range (volts)	Wire Feed Speed (metres/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
0.9	15 – 26	3.5 – 15	70 – 230	Spool	15kg	720115
1.2	18 – 32	2.5 – 15	120 – 350	Spool	15kg	720116

* Spool (ø300mm);

AUTOCRAFT SUPER STEEL



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Welding Grade CO ₂ :	Argon 20-25% CO ₂ :
Yield Stress 425 MPa	
Tensile Strength 520 MPa	
Elongation 34%	
CVN Impact Values 75 J av @ -20°C	

TYPICAL WIRE ANALYSIS:

C: 0.05%	Mn: 1.10%	Si: 0.55%
Ti: 0.10%	Zr: 0.06%	Al: 0.08%
S: 0.007%	P: 0.008%	Fe: Balance

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

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

RECOMMENDED SHIELDING GAS:

- Argon + 10-25% CO₂
- Argon + 1-3% O₂
- Welding Grade CO₂

COMPARABLE CIGWELD PRODUCTS:

Comweld Super Steel TIG rod

- ▲ A Low Carbon, Triple Deoxidised Steel Wire for GMA Welding.
- ▲ For use with Welding Grade CO₂ or Argon Based Shielding Gases.
- ▲ Triple Deoxidised for Superior Weld Deposit Quality and Resistance to Porosity.
- ▲ The ideal choice for the welding of rusty or mill scaled plates and pipes and the root pass welding of pipes, tanks, and heavy walled joints.

Classifications:

AS/NZS 2717.1:	ES2-GC/M-W503AH.
AWS/ASME-SFA A5.18:	ER70S-2.

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	720054

* Spool (ø300mm).

AUTOCRAFT Mn-Mo



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Welding Grade CO ₂ :	Argon 20-25% CO ₂ :
Yield Stress 580 MPa	
Tensile Strength 680 MPa	
Elongation 24%	
CVN Impact Values 80 J av @ +20°C	

TYPICAL WIRE ANALYSIS:

C: 0.08%	Mn: 1.73%	Si: 0.65%
Mo: 0.45%	S: 0.011%	P: 0.017%

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

- ▲ A Manganese Molybdenum Steel Wire for the GMA Welding of Higher Strength steels.

- ▲ For Use with Welding Grade CO₂ or Argon Based Shielding Gases.
- ▲ 550 MPa Tensile Class Weld Deposits.
- ▲ Suitable for the all positional fillet and butt welding of a wide range of higher strength steels, particularly those used in the fabrication of pressure vessels, boilers and pipelines.

Classifications:

AS/NZS 2717.1:	ESD2-GC/M-W559AH.
AWS/ASME-SFA A5.28:	ER80S-D2.

Packaging and Operating Data:

Wire Dia mm	Voltage Range (volts)	Wire Feed Speed (metres/min)	Current Range (amps)	Pack Type*	Pack Weight	Part No
0.9	16 – 28	3.5 – 15	70 – 230	Spool	15kg	720049
1.2	18 – 32	3.5 – 15	120 – 350	Spool	15kg	720052

* Spool (ø300mm).