

## VERTI-COR ULTRA



DC+



- ▲ Rutile Type Flux Cored Wire Formulated Exclusively for CO<sub>2</sub> Shielding Gas.
- ▲ Versatile, All Positional Capabilities.
- ▲ Excellent Operator Appeal.
- ▲ Low spatter and fume levels.

### Classifications:

AS 2203.1: (old)	ETP-GCp-W502A. CM1 H10
AS/NZS: 17632 (new)	B T 49 2 T1 1 C A H10
AWS/ASME-SFA A5.20:	E71T-1H8

### Description and Applications:

Verti-Cor Ultra is a smooth running all positional flux cored wire which offers improved operator appeal and lower fume and spatter levels under welding grade carbon dioxide shielding gas.

Verti-Cor Ultra offers significant welding improvements compared with conventional E71T-1 wires, in particular 50-60% less spatter and ~ 20% less fume.

Verti-Cor Ultra is designed for the single and multi-pass welding of mild and medium strength steels in the downhand, vertical-up and overhead positions. It is recommended for general steel construction and fabrication welding where the work cannot be rotated to the downhand positions.

### Typical Weld Metal Mechanical Properties:

Actual weld metal mechanical properties achieved with Verti-Cor Ultra are influenced by many factors including, base metal analysis, welding parameters / heat input used, number of weld passes and run placement etc. Please consult your nearest CIGWELD branch for welding procedure recommendations.

### APPROVALS\*:

Lloyds Register of Shipping	Grade 2YS H10.
American Bureau of Shipping	Grade 2YSA H10.
* - with welding grade CO <sub>2</sub> shielding gas.	

### TYPICAL ALL WELD METAL ANALYSIS:

Using CO<sub>2</sub> shielding gas

C: 0.04%	Mn: 1.24%	Si: 0.70%
Ti: 0.035%	B: 0.005%.	

### 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 CO<sub>2</sub> shielding gas

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Using welding grade CO<sub>2</sub>:

Yield Stress	480 MPa
Tensile Strength	560 MPa
Elongation	28%
CVN Impact Values	80 J av @ 0°C.

### RECOMMENDED\* SHIELDING GAS:

AS 4882:	ISO 14175 / AWS A5.32:
SG-C	C1* - Cert supplied
Welding grade CO <sub>2</sub>	









### Packaging Data:

Wire Diameter (mm)	Type	Pack Weight	Pack Part No.
1.2	Spool	15kg	720900
1.6	Spool	15kg	720902



## Operating Data:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO<sub>2</sub> shielding gas with a flow rate of 10-15 litres/min.

Wire Diameter mm	Current Range (amps)	Voltage Range (volts)	CTWD	Welding Position	
1.2	250-300	27-31	20-25		Flat
1.6	350-400	27-31	25-30		
1.2	230-280	26-30	20-25		HV Fillet
1.6	310-360	26-30	25-30		
1.2	170-220	24-28	15-20		Vertical up
1.6	200-250	24-28	15-20		
1.2	160-210	24-28	15-20		Overhead
1.6	190-240	24-28	15-20		

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.