

## VERTI-COR ULTRA



- ▲ 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: ETP-GCp-W502A. CM1 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.
Det Norske Veritas	IYMS H.

\* - 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:

- Welding Grade CO<sub>2</sub> ISO14175: C1

### Packaging Data:

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