

# Autocraft Copper Coated Solid Steel Welding Wires

## Autocraft NiCrMo



- A low alloy steel wire for the GMA welding of high strength steels
- For use with welding grade CO<sub>2</sub> or Argon based shielding gases
- 760MPa tensile class weld deposits
- Suitable for all positional fillt 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);

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Argon 1-3% CO <sub>2</sub> :		Argon 10-25% CO <sub>2</sub> :	
Yield Stress	730 MPa	390 MPa	
Tensile Strength	790 MPa	500 MPa	
Elongation	17%	31%	
CVN Impact Val.	130 J @ -29°C	72 J @ -29°C	
CVN Impact Val.	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 + 10-25% CO<sub>2</sub>
- Argon + 1-3% O<sub>2</sub>
- Welding Grade CO<sub>2</sub>

### COMPARABLE CIGWELD PRODUCTS:

Verti-Cor 113 K3 H4 FCAW  
Tensi-Cor 110T XP FCAW

## Autocraft CrMo1



- 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);

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Argon 1-3% CO <sub>2</sub> :	
0.2% Proof Stress	500 MPa
Tensile Strength	600 MPa
Elongation	20%
CVN Impact Values	60J 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% CO<sub>2</sub>
- Argon + 1-3% O<sub>2</sub>

### COMPARABLE CIGWELD PRODUCTS:

Alloycraft 80-B2 electrode  
Comweld CrMo1 TIG rod