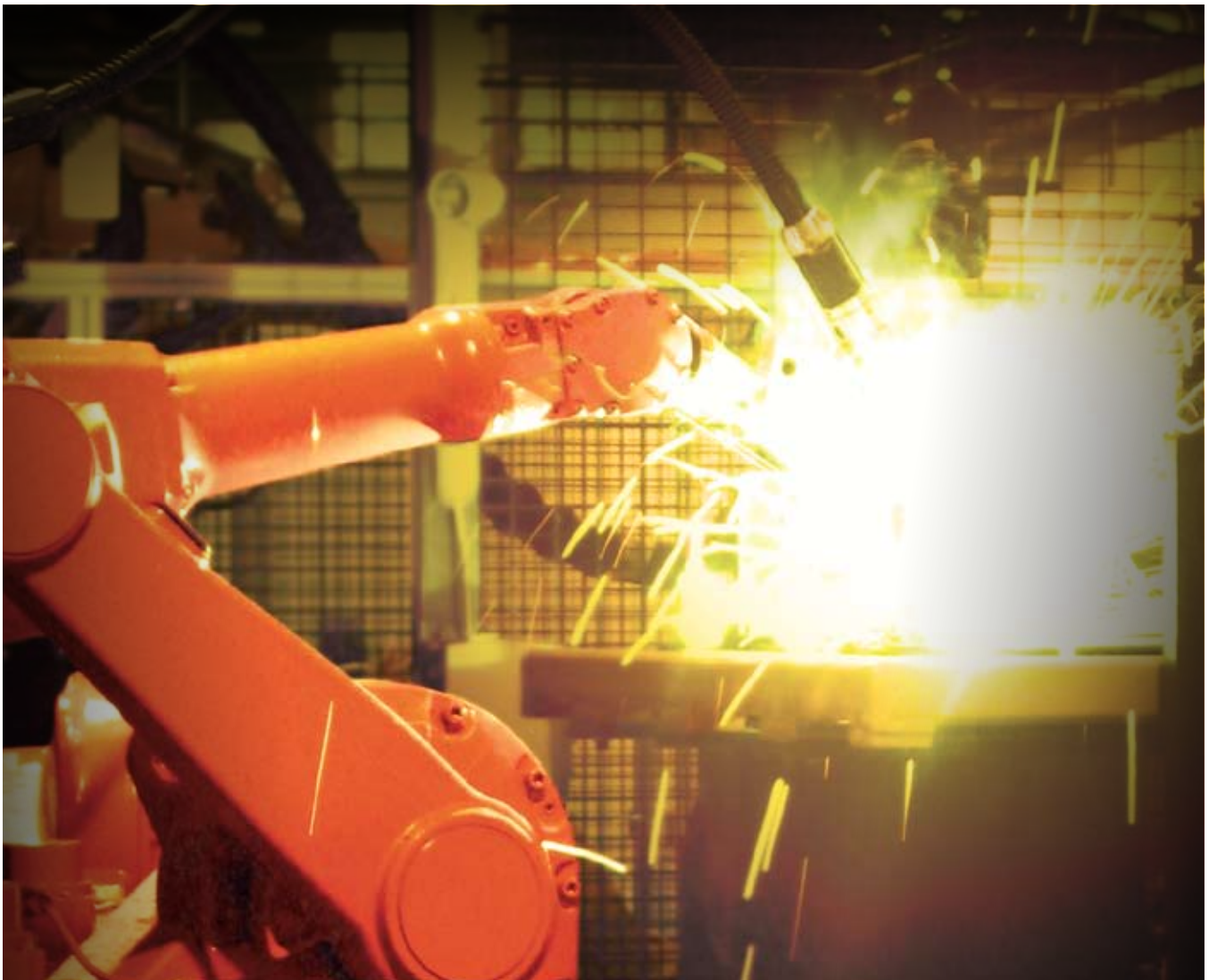




# Coreweld<sup>®</sup> metal-cored wires

For faster, cleaner, more efficient welding



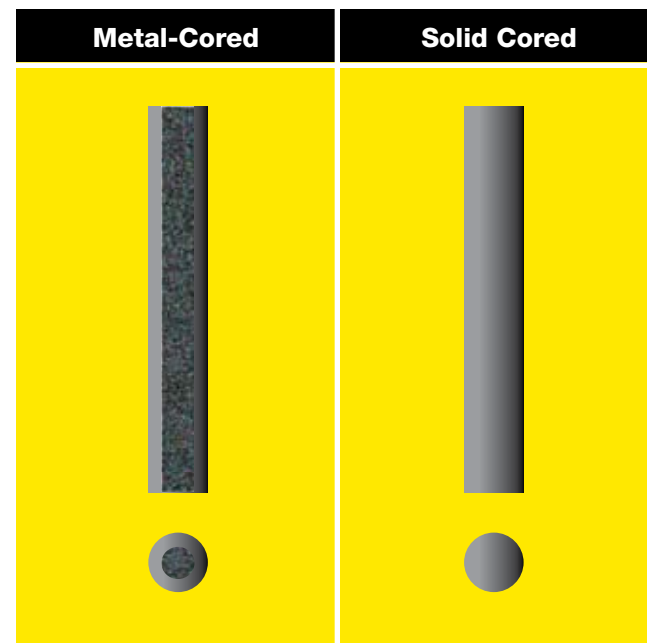
# Why use metal-cored wires?

**In today's highly competitive market, where companies are constantly searching for ways to reduce cost and increase productivity, metal-cored wires may be an answer.**

Metal-cored wires offer several advantages over their solid wire counterparts. Since metal-cored wires carry the current on the outer sheath, current densities are considerably higher than those found in solid wires where the load is carried across the entire cross-sectional area. As a result, the metal-cored arc tends to be softer and can bridge gaps easier with reduced tendency for burn-through. Metal-cored wires provide excellent arc stability and outstanding penetration and wetting, with excellent fusion at the root joint and sidewall. The result is a high-quality weld with minimal slag and spatter, and fewer residual silicon islands.

The higher current density can produce higher deposition rates and can also yield higher travel speeds than solid wires. In addition, the lower clean-up requirement and reduced need for post-weld operations can save significantly on labor costs and improve overall productivity. Although metal-cored wires cost more than solid wires, increases in efficiency and productivity, coupled with the reduction of labor costs for repairs and clean-up, typically lead to lower total costs.

Metal-cored wires can be used with equal success in both hand-held and automated welding scenarios, as well as in pulse welding. They also yield exceptional welds with high deposition rates and higher feed speeds than their solid wire counterparts.



## Features and benefits.

- + High deposition rates and travel speeds
- + No slag and almost no spatter
- + Little to no postweld clean-up or cleaning between passes
- + Excellent side-wall fusion and root penetration
- + Ability to bridge part gaps without burn-through
- + Ability to weld thin materials at high amperages without burn-through
- + Ability to use next larger electrode diameter
- + Capability to weld out-of-position with pulsed spray or short-circuit transfer

# Coreweld premium metal-cored wires

**ESAB Coreweld metal-cored wires have been developed to meet the needs of demanding applications such as structural steel construction, heavy equipment, transportation, bridges, petrochemical processing, offshore rigs, railcars, shipbuilding, pressure vessels, and general fabrication.**

**Utilizing advanced manufacturing processes and specially formulated composite fillers, Coreweld metal-cored wires combine high deposition rates, high deposition efficiencies, high travel speeds, excellent penetration, and ease of use. These qualities make Coreweld the brand of choice for operators who want to see production levels increase, costs decrease, and profits rise.**

**Coreweld 77HS** was designed for high-speed robotic and automation applications. It offers the lowest slag/spatter of any of the Coreweld products – requiring virtually no clean up. Coreweld 77HS is ideal for automated applications where painting or finishing is needed after welding.

**Coreweld C-6** offers the exceptionally high travel speeds critical for automation and produces outstanding deposition efficiencies. Our most popular metal-cored wire, Coreweld C-6 is an excellent choice for multiple applications.

**Coreweld 70** is a high-efficiency wire with excellent arc characteristics and weld metal transfer. This metal-cored product is intended for use on carbon steels, and is ideal for use in applications with light rust and mill scale.



ESAB also offers a number of low-alloy wires uniquely formulated for specific metal types, including nickel, chrome-moly, HSLA, quenched and tempered steels. These wires combine the excellent arc characteristics and cost-savings of metal-cored wires with the mechanical properties that are crucial for demanding industries such as offshore oil, shipbuilding and heavy equipment.

Like all ESAB products, our metal-cored wires are backed by our technical support team, and satisfaction is 100% guaranteed. If you are currently using solid or flux-cored wire, a switch to metal-cored wire may be advantageous to you. Your ESAB sales representative would be happy to review your application to determine potential cost savings and aid in selecting the right filler metal for your needs.



### Typical Mechanical Properties

#### As Welded

Shielding Gas 75% Ar / 25% CO <sub>2</sub>	ksi	MPa
Yield Strength	61	420
Tensile Strength	75	515
Reduction in Area	60%	
Elongation % in 2"	32%	

Shielding Gas 90% Ar / 10% CO <sub>2</sub>	ksi	MPa
Yield Strength	62	425
Tensile Strength	74	510
Reduction in Area	58%	
Elongation % in 2"	33%	

### Typical Charpy V-Notch Impact Properties

Testing Temperature	Condition	Ft.-lbs.	J
-20°F (-29°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	38	52
-20°F (-29°C)	As Welded, 90% Ar / 10% CO <sub>2</sub>	63	85
-40°F (-40°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	28	38
-40°F (-40°C)	As Welded, 90% Ar / 10% CO <sub>2</sub>	40	54

### Typical Undiluted Weld Metal Analysis

#### Shielding Gas 75% Ar / 25% CO<sub>2</sub>

C	Mn	Si	P	S	Ni
0.04%	0.9%	0.7%	0.01%	0.015%	0.4%

#### Shielding Gas 90% Ar / 10% CO<sub>2</sub>

C	Mn	Si	P	S	Ni
0.04%	1.0%	0.7%	0.01%	0.015%	0.4%



## High-speed automation on clean steel.

**Coreweld 77HS** is a metal-cored wire designed to run at fast travel speeds – ideal for robotic applications. This leads to high deposition rates and very few silica islands, facilitating faster cycle time when material finishing and painting are required.

Optimal performance is achieved with 90% Argon/10% CO<sub>2</sub> shielding gas. Coreweld 77HS is best used for single-pass automated applications on clean steel, but it is also capable of multi-pass, handheld semi-automatic applications as well. Not well-suited for service above 300° F.

### Applications

- + Mobile machinery
- + Automatic and robotic applications
- + Automotive
- + General fabrication
- + Rail car

### Classification and Approvals

- + AWS A5.18: E70C-6M H4
- + ASME SFA 5.18
- + Certified by CWB - CSA W48
- + DNV-III YMS

### Welding Position

All-position when using short arc transfer or pulsed equipment

### Recommended Shielding Gas

75%-92% Ar/25%-8% CO<sub>2</sub>



## Excellent all-purpose wire.

**Coreweld C-6** was developed for handheld, automatic, and robotic welding. It offers the exceptionally high travel speeds critical for automation, with enhanced productivity that makes it more cost-effective than solid wires. Special lubricants and surface treatment improve feedability and arc stability. This wire is ideal for flat or horizontal fillet welds, particularly in automated welding.

**Coreweld C-6** performs well with Argon/CO<sub>2</sub> shielding gas mixes from 75%-92% Argon. It handles rust and mill scale with good sidewall tie-in and wetting, and offers broad operating parameters with excellent restart characteristics, very few silicon islands, and low spatter levels.

### Applications

- + Mobile machinery
- + Shipbuilding
- + Automotive
- + Bridge construction
- + Civil construction
- + General fabrication
- + Rail car

### Classification and Approvals

- + AWS A5.18: E70C-6M H4
- + AWS A5.20: Seismic
- + ASME SFA 5.18
- + A.B.S. - 3SA, 4YSA
- + Certified by CWB - CSA W48

### Welding Position

All-position when using short arc transfer or pulsed equipment

### Recommended Shielding Gas

75%-92% Ar/25%-8% CO<sub>2</sub>

### Typical Mechanical Properties

#### As Welded

Shielding Gas 75% Ar / 25% CO <sub>2</sub>	ksi	MPa
Yield Strength	74	505
Tensile Strength	86	595
Reduction in Area	64%	
Elongation % in 2"	27%	

Shielding Gas 92% Ar / 8% CO <sub>2</sub>	ksi	MPa
Yield Strength	79	545
Tensile Strength	86	595
Reduction in Area	63%	
Elongation % in 2"	25%	

### Typical Charpy V-Notch Impact Properties

Testing Temperature	Condition	Ft.-lbs.	J
0°F (-18°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	55	75
-20°F (-29°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	38	52
-20°F (-29°C)	As Welded, 92% Ar / 8% CO <sub>2</sub>	56	76

### Typical Undiluted Weld Metal Analysis

#### Shielding Gas 75% Ar / 25% CO<sub>2</sub>

C	Mn	Si	P	S
0.04%	1.6%	0.7%	0.012%	0.016%

#### Shielding Gas 92% Ar / 8% CO<sub>2</sub>

C	Mn	Si	P	S
0.04%	1.6%	0.8%	0.015%	0.017%



### Typical Mechanical Properties

#### As Welded

Shielding Gas 75% Ar / 25% CO <sub>2</sub>	ksi	MPa
Yield Strength	68	460
Tensile Strength	80	550
Reduction in Area	67%	
Elongation % in 2"	28%	

Shielding Gas 92% Ar / 8% CO <sub>2</sub>	ksi	MPa
Yield Strength	79	545
Tensile Strength	85	585
Reduction in Area	65%	
Elongation % in 2"	26%	

### Typical Charpy V-Notch Impact Properties

Testing Temperature	Condition	Ft.-lbs.	J
0°F (-18°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	50	68
0°F (-18°C)	As Welded, 92% Ar / 8% CO <sub>2</sub>	60	81
-20°F (-29°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	40	54
-20°F (-29°C)	As Welded, 92% Ar / 8% CO <sub>2</sub>	50	68
-40°F (-40°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	30	41
-40°F (-40°C)	As Welded, 92% Ar / 8% CO <sub>2</sub>	35	47

### Typical Undiluted Weld Metal Analysis

#### Shielding Gas 75% Ar / 25% CO<sub>2</sub>

C	Mn	Si	P	S
0.06%	1.4%	0.6%	0.010%	0.019%

#### Shielding Gas 92% Ar / 8% CO<sub>2</sub>

C	Mn	Si	P	S
0.06%	1.5%	0.6%	0.009%	0.019%

## Robust wire designed for rust and mill scale.

**Coreweld 70** is a tubular wire primarily comprised of metal powder along with additional arc stabilizers and alloying elements. Outstanding welds can be made on steel with light rust and mill scale. When used with an Argon mixture up to 92%, spatter levels are low and silica islands are minimal. Due to the high level of iron powder and low slag components, the only slag formed by this wire consists of small islands of silica.

**Coreweld 70** was designed for multi-pass welding in robotic applications where slag removal between passes is difficult. This metal-cored product is intended for use on carbon steels having tensile strengths up to 70 ksi (485 MPa). Coreweld 70 wires from 0.045" up to 1/16" are capable of being welded out-of-position when using pulsed arc equipment.

### Applications

- + Power generation
- + Mobile machinery
- + Shipbuilding
- + Automotive
- + Bridge construction
- + Civil construction
- + Pipeline
- + General fabrication
- + Rail car

### Classification and Approvals

- + AWS A5.18: E70C-6M
- + ASME SFA 5.18
- + ABS-AWS A5.18: E70C-6M
- + Certified by CWB-CSA W48
- + DNV-III YMS (H10)
- + BV-SA 3YM (HH)
- + Deutsche Bahn
- + Controlas
- + LR-3S, 3YS (H10)
- + TUV
- + GL-3YH10S

### Welding Position\*

Flat/horizontal for 5/64" and larger  
 \*All-position for .045-.062 when using short arc transfer or pulsed equipment

### Recommended Shielding Gas

75%-92% Ar/25%-8% CO<sub>2</sub>



**Coreweld 80-B2** is a metal-cored electrode designed for single- and multi-pass welding of steels such as 0.5% Cr/0.5% Mo, 1% Cr/0.5% Mo, and 1.25% Cr/0.5% Mo. This electrode has a high percentage of iron powder resulting in a high-efficiency wire with only small islands of slag on the weld deposit.

### Applications

- + Power generation
- + Pipeline
- + Petrochemical

### Classification and Approvals

- + AWS A5.28: E80C-B2 H4
- + ASME SFA 5.28

### Welding Position

Flat/horizontal

### Recommended Shielding Gas

75%-92% Ar/25%-8% CO<sub>2</sub>, 98% Ar/2% O<sub>2</sub>

### Typical Mechanical Properties

#### As Welded

Shielding Gas 98% Ar / 2% O <sub>2</sub>	ksi	MPa
Yield Strength	86	595
Tensile Strength	99	685
Elongation % in 2"	25%	

Stress Relieved 1 hr. @1150°F (620°C) 98% Ar / 2% O <sub>2</sub>	ksi	MPa
Yield Strength	87	605
Tensile Strength	96	660
Elongation % in 2"	26%	

### Typical Undiluted Weld Metal Analysis

#### Shielding Gas 98% Ar / 2% O<sub>2</sub>

C	Mn	Si	P	S	Cr	Mo
0.030%	0.96%	0.5%	0.01%	0.013%	1.14%	0.5%





### Typical Mechanical Properties

#### As Welded

Shielding Gas 85% Ar / 15% CO <sub>2</sub>	ksi	MPa
Yield Strength	70	485
Tensile Strength	82	565
Reduction in Area	66%	
Elongation % in 2"	27%	

### Typical Charpy V-Notch Impact Properties

Testing Temperature	Condition	Ft.-lbs.	J
0°F (-18°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	55	75
-50°F (-46°C)	As Welded, 85% Ar / 15% CO <sub>2</sub>	45	61

### Typical Undiluted Weld Metal Analysis

#### Shielding Gas 85% Ar / 15% CO<sub>2</sub>

C	Mn	Si	P	S	Ni
0.04%	1.5%	0.3%	0.01%	0.02%	0.9%



**Coreweld 80C-Ni1** is a metal-cored wire for application where low temperature impact toughness or weathering characteristics are required. Operating over a broad range of parameters, Coreweld 80C-Ni1 produces a smooth spray transfer with minimal fume and spatter, and is tolerant of light rust and mill scale. The recommended shielding gas used is Ar 75-92%/25-8% CO<sub>2</sub>. Coreweld 80C-Ni1 is alloyed with 1% Ni to provide good low temperature impact toughness. It also meets the requirements in AWS D1.1 and D1.5 for use on unpainted weathering steels. It is suitable for making single- or multi-pass welds in the flat or horizontal position using conventional (DCEP or DCEN) or pulsed power.

#### Applications

- + Mobile machinery
- + Bridge construction
- + General fabrication
- + Process

#### Classification and Approvals

- + AWS A5.28: E80C-Ni1 H4
- + ASME SFA 5.28

#### Welding Position

All-position when using short arc transfer or pulsed equipment

#### Recommended Shielding Gas

75%-92% Ar/25%-8% CO<sub>2</sub>



**Coreweld 80-D2** is a metal-cored wire equivalent to ER80S-D2 solid wire. Coreweld 80-D2 produces higher deposition rates and better wetting action, with an absence of copper coating on the wire. Coreweld 80-D2 was developed for HSLA steels, and is capable of single- or multiple-pass welding.

#### Applications

- + Mobile machinery
- + Automotive
- + General fabrication
- + Process

#### Classification and Approvals

- + AWS A5.28: E80C-G H4
- + ASME SFA 5.28

#### Welding Position

All-position when using short arc transfer or pulsed equipment

#### Recommended Shielding Gas

75%-92% Ar/25%-8% CO<sub>2</sub>

### Typical Mechanical Properties

#### As Welded

Shielding Gas 75% Ar / 25% CO <sub>2</sub>	ksi	MPa
Yield Strength	77	530
Tensile Strength	90	620
Reduction in Area	62%	
Elongation % in 2"	26%	

Stress Relieved 8 hrs. @1175°F (635°C) 75% Ar / 25% CO <sub>2</sub>	ksi	MPa
Yield Strength	77	530
Tensile Strength	90	620
Reduction in Area	68%	
Elongation % in 2"	26%	

### Typical Charpy V-Notch Impact Properties

Testing Temperature	Condition	Ft.-lbs.	J
-20°F (-29°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	34	46
-20°F (-29°C)	Stress Relieved 8 hrs. @1175°F (635°C) 75% Ar / 25% CO <sub>2</sub>	25	34
-40°F (-40°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	23	31

### Typical Undiluted Weld Metal Analysis

#### Shielding Gas 75% Ar / 25% CO<sub>2</sub>

C	Mn	Si	P	S	Mo
0.09%	1.6%	0.5%	0.01%	0.012%	0.5%





### Typical Mechanical Properties

#### As Welded

Shielding Gas 92% Ar / 8% CO <sub>2</sub>	ksi	MPa
Yield Strength	113	770
Tensile Strength	121	835
Elongation % in 2"	20%	

### Typical Charpy V-Notch Impact Properties

Testing Temperature	Condition	Ft.-lbs.	J
0°F (-18°C)	As Welded, 92% Ar / 8% CO <sub>2</sub>	35	47
-60°F (-51°C)	As Welded, 92% Ar / 8% CO <sub>2</sub>	30	41

### Typical Undiluted Weld Metal Analysis

#### Shielding Gas 92% Ar / 8% CO<sub>2</sub>

C	Mn	Si	P	S	Ni	Mo
0.05%	1.5%	0.3%	0.01%	0.01%	2.5%	0.6%

**Coreweld 110** is a metal-cored electrode designed for single- and multi-pass welding of high-strength low alloy steels, such as T-1, HY-80, and HY-100. The arc is smooth with virtually no spatter. Coreweld 110 is recommended for welding quenched and tempered high-strength steels. Because of the metallic core, the wire offers both the high deposition rates of a flux-cored electrode and the high efficiencies of a solid wire.

#### Applications

- + Shipbuilding
- + Bridge construction

#### Classification and Approvals

- + AWS A5.28: E110C-G H4
- + ASME SFA 5.28

#### Welding Position\*

Flat/horizontal

\*All-position when using short arc transfer or pulsed equipment

#### Recommended Shielding Gas

75%-92% Ar/25%-8% CO<sub>2</sub>



**Coreweld W** is a metal-cored wire designed for single- or multi-pass welding on weathering grade steels. Coreweld W was designed specifically to meet the demand for weld deposits that color match the low alloy, high-strength weathering grade steels, such as A588, A242, U.S.S. Cor-Ten<sup>®</sup>, and Mayari R<sup>®</sup>.

#### Applications

- + Mobile machinery
- + Shipbuilding
- + Bridge construction
- + Civil construction
- + General fabrication
- + Rail car

#### Classification and Approvals

- + AWS A5.28: E80C-G H4
- + ASME SFA 5.28
- + Deutsche Bahn

#### Welding Position\*

Flat/horizontal

\*All-position when using short arc transfer or pulsed equipment

#### Recommended Shielding Gas

75%-92% Ar/25%-8% CO<sub>2</sub>

### Typical Mechanical Properties

#### As Welded

Shielding Gas 75% Ar / 25% CO <sub>2</sub>	ksi	MPa
Yield Strength	81	560
Tensile Strength	90	620
Elongation % in 2"	26%	

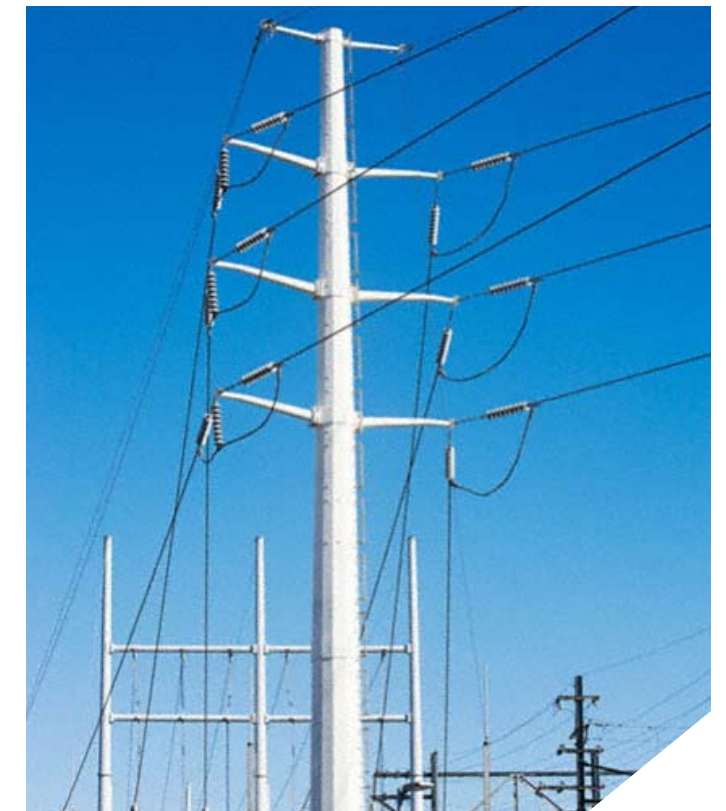
### Typical Charpy V-Notch Impact Properties

Testing Temperature	Condition	Ft.-lbs.	J
-20°F (-29°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	38	52
-60°F (-51°C)	As Welded, 75% Ar / 25% CO <sub>2</sub>	24	33

### Typical Undiluted Weld Metal Analysis

#### Shielding Gas 75% Ar / 25% CO<sub>2</sub>

C	Mn	Si	P	S	Cr	Ni	Cu
0.04%	1.3%	0.7%	0.008%	0.012%	0.6%	0.7%	0.6%





# WELDING PARAMETERS



# WELDING PARAMETERS

Coreweld 77-HS, Coreweld C-6, Coreweld 80-B2, Coreweld 80C-Ni1, Coreweld 80-D2, Coreweld 110 and Coreweld W

### 75%Ar / 25%CO<sub>2</sub> Gas

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate	Efficiency
0.045" 1.2mm 5/8" Electrical Stick Out	200	27	250 (640)	6.5 (3.0)	95%
	260	28	350 (890)	9.1 (4.1)	97%
	<b>290</b>	<b>29</b>	<b>400 (1020)</b>	<b>10.2 (4.6)</b>	<b>98%</b>
	330	32	500 (1270)	12.7 (5.8)	99%
	360	33	550 (1400)	13.9 (6.3)	99%
0.052" 1.4mm 5/8" Electrical Stick Out	190	26	180 (440)	5.5 (2.5)	94%
	240	27	250 (640)	7.7 (3.5)	95%
	<b>280</b>	<b>28</b>	<b>300 (760)</b>	<b>9.2 (4.2)</b>	<b>97%</b>
	340	31	400 (1020)	11.2 (5.1)	99%
	410	36	530 (1330)	15.7 (7.1)	99%
1/16" 1.6mm 3/4" Electrical Stick Out	230	26	150 (380)	6.2 (2.8)	91%
	290	27	200 (510)	8.8 (4.0)	95%
	<b>340</b>	<b>29</b>	<b>250 (640)</b>	<b>12.3 (5.6)</b>	<b>98%</b>
	430	32	350 (890)	15.9 (7.2)	99%
	510	36	480 (1210)	20.7 (9.4)	99%

### 90%Ar / 10%CO<sub>2</sub> Gas

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate	Efficiency
0.045" 1.2mm 5/8" Electrical Stick Out	170	24	200 (510)	5.2 (2.4)	94%
	230	25	300 (760)	7.7 (3.5)	96%
	<b>290</b>	<b>27</b>	<b>400 (1020)</b>	<b>10.2 (4.6)</b>	<b>98%</b>
	330	29	500 (1270)	12.7 (5.8)	99%
	390	32	650 (1650)	16.5 (7.5)	99%
0.052" 1.4mm 5/8" Electrical Stick Out	190	24	180 (440)	5.5 (2.5)	94%
	240	25	250 (640)	7.7 (3.5)	95%
	<b>310</b>	<b>27</b>	<b>350 (890)</b>	<b>10.7 (4.9)</b>	<b>98%</b>
	370	30	450 (1140)	13.6 (6.2)	99%
	420	32	550 (1400)	16.6 (7.5)	99%
1/16" 1.6mm 3/4" Electrical Stick Out	230	24	150 (380)	6.2 (2.8)	91%
	290	26	200 (510)	8.8 (4.0)	95%
	<b>370</b>	<b>28</b>	<b>280 (700)</b>	<b>12.5 (5.7)</b>	<b>98%</b>
	430	29	350 (890)	15.9 (7.2)	99%
	510	33	480 (1210)	20.7 (9.4)	99%

Coreweld 70

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate	Efficiency
0.035" .9mm 1/2" Electrical Stick Out	150	25	320 ipm, 813 cm/min	4.4 lbs/hr., 1.2 kg/hr.	92%
	200	27	472 ipm, 1199 cm/min	6.5 lbs/hr., 2.95 kg/hr.	92%
	250	29	680 ipm, 1727 cm/min	9.4 lbs/hr., 4.26 kg/hr.	92%
0.045" 1.2mm 5/8" Electrical Stick Out	250	28	330 ipm, 838 cm/min	8.0 lbs/hr., 3.63 kg/hr.	90%
	275	30	430 ipm, 1092 cm/min	11.1 lbs/hr., 5.03 kg/hr.	94%
	300	32	464 ipm, 1179 cm/min	11.6 lbs/hr., 5.26 kg/hr.	94%
	350	32	512 ipm, 1300 cm/min	12.7 lbs/hr., 5.76 kg/hr.	96%
	0.052" 1.4mm 5/8" Electrical Stick Out	275	29	262 ipm, 665 cm/min	8.0 lbs/hr., 3.63 kg/hr.
300		29	312 ipm, 792 cm/min	9.6 lbs/hr., 4.35 kg/hr.	93%
325		30	328 ipm, 833 cm/min	10.1 lbs/hr., 4.58 kg/hr.	93%
1/16" 1.6mm 3/4" Electrical Stick Out	300	30	181 ipm, 460 cm/min	8.6 lbs/hr., 3.90 kg/hr.	89%
	350	30	241 ipm, 612 cm/min	11.9 lbs/hr., 5.40 kg/hr.	94%
	400	32	293 ipm, 744 cm/min	14.6 lbs/hr., 6.62 kg/hr.	94%
	450	34	333 ipm, 846 cm/min	16.2 lbs/hr., 7.35 kg/hr.	94%
5/64" 2.0mm 1" Electrical Stick Out	350	27	160 ipm, 406 cm/min	11.6 lbs/hr., 5.26 kg/hr.	94%
	400	28	185 ipm, 470 cm/min	13.2 lbs/hr., 5.99 kg/hr.	95%
	450	28	210 ipm, 533 cm/min	15.8 lbs/hr., 7.17 kg/hr.	97%
	500	29	280 ipm, 711 cm/min	20.4 lbs/hr., 9.25 kg/hr.	97%
3/32" 2.4mm 1" Electrical Stick Out	400	31	115 ipm, 292 cm/min	11.5 lbs/hr., 5.22 kg/hr.	95%
	450	31	138 ipm, 350 cm/min	14.5 lbs/hr., 6.58 kg/hr.	97%
	500	32	155 ipm, 394 cm/min	16.5 lbs/hr., 7.48 kg/hr.	97%
	550	32	197 ipm, 500 cm/min	21.0 lbs/hr., 9.53 kg/hr.	98%

Data reflects use of 75% Argon/25% CO<sub>2</sub> gas shielding. Deposition rates and efficiencies will increase approximately 1% with use of 92% Argon/8% CO<sub>2</sub> shielding.



NOTES



NOTES



# ESAB Filler Metals — Proudly Made in the USA

Utilizing years of experience and some of the industry's most advanced technologies, ESAB has proudly supported the growth and development of the welding industry throughout the world. Our facilities in Central Pennsylvania have been producing many of the welding filler metal brands you have come to know and trust since 1940.

With a dedicated staff of world-class research engineers and scientists, ESAB proudly continues its tradition of pioneering new processes and developing new products. Continuous interaction with customers has led us to invent solutions for an array of welding applications in nearly every industrial sector.

Once in production, every item that leaves our 400,000 sq. ft. manufacturing facility is assured to meet the quality you deserve – guaranteed! Whatever your filler metal requirements, ESAB has the products you need and the quality you can trust.

## **Be safe when welding or cutting.**

Please read and understand the safety labels, instruction manuals, and/or safety data sheet for your welding or cutting product before you weld or cut. Always follow safe practices and use adequate ventilation when welding or cutting. More information on welding health and safety can be found at [www.esabna.com](http://www.esabna.com).

## **Ask for Coreweld by name.**

Contact your local distributor or call the ESAB Customer Service Center at 1-800-ESAB-123 for more information.

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Global solutions for local customers – everywhere.

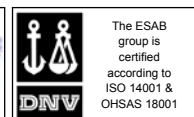
Find out more at [www.esabna.com](http://www.esabna.com)

Call 1-800-ESAB-123 or 1-800-933-7070 (Filler Metal Headquarters)

**US:** 411 South Ebenezer Road, Florence, SC 29501-0504

**Canada:** 6010 Tomken Road, Mississauga, Ontario L5T 1X9

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The ESAB  
group is  
certified  
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ISO 14001 &  
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