



COREWELD PRIME MC3 H4 & MC4 H4 METAL CORED WIRE



COREWELD PRIME MC3 H4

Seamless metal cored wire for mild steel and 490N/mm² class high tensile strength steel. Coreweld Prime MC3 H4 is a metal cored wire that combines the high deposition rates of a rutile slag flux-cored electrode with the high efficiencies of solid wire.

CLASSIFICATIONS WELD METAL

EN ISO 17632-B	T 49 3 T15 0 M21 A U H5
SFA/AWS A5.18	E70C-6M H4
JIS Z 3313	YFW-A50DM
KS D 7104	YFW-A50DM
EN ISO 17632-A	T 42 3 M M21 3 H5

Shielding Gas	M21 (EN ISO 14175)
Polarity	DC+
Alloy Type	C Mn
Fill Type	Metal Cored
Diff Hydrogen	<4 ml/100g

TYPICAL ALL WELD METAL ANALYSIS

Chemical Composition

C: 0.12%	Si: 0.90%	Mn: 1.75%	P: 0.03%	S: 0.03%
Cr: 0.20%	Ni: 0.50%	Mo: 0.30%	V: 0.08%	Cu: 0.50%

SPECIFICATIONS

Diameter (mm)	Current Range (amps)		Voltage Range (Volts)		CTWD (mm)
	Min	Max	Min	Max	
1.2	250	350	31	35	15-20
1.6	280	390	31	35	15-20

TYPICAL MECHANICAL PROPERTIES

Using Argon +10 to 25% CO₂

Yield Stress	450 MPa
Tensile Strength	550 MPa
Elongation	30%
CVN Impact Values	60J @ -30°C

FEATURES

MC3 Metal Cored Flux Cored wire

- Seamless wire for guaranteed low hydrogen levels
- No copper coating for lower fume
- ASC coating for rust prevention and outstanding feedability
- High deposition efficiency & deposition rates
- Vacuum packed in foil for protection against moisture
- Precision layered wound
- Grade-3 with a H4 classification.
- It is designed to run on Mixed Argon+CO₂ shielding gases, ranging from 10-25% CO₂.
- Weld layer transitions in multilayer fillet welds are very smooth and even.
- Spatter levels are very low to extremely low

ORDERING INFO

Part No.	Size	Weight	Description
35MP12247V	1.2mm	15kg	Coreweld Prime MC3 H4
35MP16247V	1.6mm	15kg	Coreweld Prime MC3 H4

COREWELD PRIME MC4 H4

Seamless metal cored wire for mild steel and 490N/mm² class high tensile strength steel. Coreweld Prime MC4 H4 is a metal cored wire that combines the high deposition rates of a rutile slag flux-cored electrode with the high efficiencies of solid wire.

CLASSIFICATIONS WELD METAL

EN ISO 17632-B	T 49 4 T15 0 M A U H5
SFA/AWS A5.18	E70C-6M H4
JIS Z 3313	YFW-A50DM
KS D 7104	YFW-A50DM
EN ISO 17632-A	T 42 4 M M21 3 H5

Shielding Gas	M21 (EN ISO 14175)
Polarity	DC+
Alloy Type	C Mn
Fill Type	Metal Cored
Diff Hydrogen	<4ml/100g

TYPICAL ALL WELD METAL ANALYSIS

Chemical Composition

C: 0.12% Si: 0.90% Mn: 1.75% P: 0.03% S: 0.03%
Cr: 0.20% Ni: 0.50% Mo: 0.30% V: 0.08% Cu: 0.50%

SPECIFICATIONS

Diameter (mm)	Current Range (amps)		Voltage Range (Volts)		CTWD (mm)
	Min	Max	Min	Max	
1.2	250	350	31	35	15-20
1.6	280	390	31	35	15-20

TYPICAL MECHANICAL PROPERTIES

Using Argon +10 to 25% CO₂

Yield Stress	470 MPa
Tensile Strength	550 MPa
Elongation	26%
CVN Impact Values	60J @ -40°C

FEATURES

MC4 Metal Cored Flux Cored wire

- Seamless wire for guaranteed low hydrogen levels
- No copper coating for lower fume
- ASC coating for rust prevention and outstanding feedability
- High deposition efficiency & deposition rates
- Vacuum packed in foil for protection against moisture
- Precision layered wound
- Grade-4 with a H4 classification.
- It is designed to run on Mixed Argon+CO₂ shielding gases, ranging from 10-25% CO₂.
- Weld layer transitions in multilayer fillet welds are very smooth and even.
- Spatter levels are very low to extremely low

ORDERING INFO

Part No.	Size	Weight	Description
35MR12247V	1.2mm	15kg	Coreweld Prime MC4 H4
35MR16247V	1.6mm	15kg	Coreweld Prime MC4 H4



COREWELD PRIME MC3 H4 & MC4 H4 METAL CORED WIRE



**Seamless, Low Hydrogen, Low Fume,
High Deposition Metal Cored Wire**



CIGWELD Pty Ltd An ESAB Brand 71 Gower Street, Preston VIC 3072 Australia
Customer Care: Tel: 1300 654 674 Fax: 03 9474 7391 | Email: enquiries@cigweld.com.au
International Enquiries: Tel: +61 3 9474 7508 Fax: +61 3 9474 7488



CIGWELD.COM.AU

In the interest of continuous improvements, CIGWELD Pty Ltd
ABN 56 007 226 815 (An ESAB Brand) reserves the right to change
specifications or design on any of its products without prior notice.