

The **Fabshield XLR-8**TM from Hobart

THE NEXT GREAT GENERATION OF T-8 WIRE...FOR THE NEXT GREAT WELD

The next generation of self-shielded, flux-cored wires is here—the **Fabshield XLR-8** from Hobart. Designed specifically for the toughest applications—structural steel erection, heavy equipment repair, bridge construction, ship and barge construction—the **Fabshield XLR-8** works equally well on both single and multiple pass applications.

Consistent, stable arc

The Fabshield XLR-8 produces flat weld beads across a broad range of parameters. Produces welds with excellent mechanical properties under a wide range of heat inputs.

Unsurpassed quality

The Fabshield XLR-8 is capable of depositing X-Ray quality welds in all positions.

Check out these advantages

Among the built-in features of the Fabshield XLR-8:

FEATURES:

- Welds out of position at high currents
- Low hydrogen weld deposit
- Excellent slag removal
- No shielding gas required
- High-impact strength at low temperatures
- Meets new D-designation under AWS A5.20:2005
- X-Ray quality welds
- Moisture-proof packaging
- Larger voltage window

BENEFITS:

- Increased productivity
- Provides increased resistance to cracking
- Increases productivity
- Suitable for welding outdoors
- Resists cracking in severe applications
- Usable under AWS D1.8 for use on Demand Critical welds
- Eliminates slag entrapment
- Extended storage
- Excellent operator appeal

What's all that mean to you? It means:

- Increased productivity
- Added resistance to cracking, even in severe applications
- No slag entrapment
- High quality weld deposit

Outperforms the competition

Compare the performance of the Fabshield XLR-8 to any competitive wire and see for yourself that it offers:

- Consistently smaller droplets on the same voltage setting
- Larger voltage windows
- Higher deposition rates
- Unequaled results on X-Ray quality test requirements
- H8 diffusible hydrogen requirement
- J classification for Charpy impact values
- Certified to: ABS Grade 3SA, 3YSA H8
- Certified to: CWB E491T-8J H8



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Fabshield XLR-8 E71T-8JD H8

Typical Weld Metal Properties (Chem Pad): Weld Metal Analysis

Carbon (C)	0.19
Manganese (Mn)	0.51
Silicon (Si)	0.17
Phosphorous (P)	0.009
Sulphur (S)	0.006
Aluminum (Al)	0.51

Typical Diffusible Hydrogen (Gas Chromatography):

Less than 8 ml/100 g



Typical Mechanical Properties (Aged 48 hr @ 200° F)

Tensile Strength:	84,100 psi (580 MPa)
Yield Strength:	67,600 psi (470 MPa)
Elongation % in 2":	25%

Typical Charpy V-Notch Impact Value (AW)

Avg. at -20°F (-18°C)	40 ft•lbs (54 Joules)
Avg. at -40°F (-40°C)	31 ft•lbs (42 Joules)

Typical Properties Under the D-Designation per AWS A5.20: 2005

Typical Mechanical Properties

	Low Heat Input (Avg. 30 kJ/in) (Fast cooling rate)	High Heat Input (Avg. 80 kJ/in) (Slow cooling rate)
Tensile Strength:	87,500 psi (603 MPa)	78,800 psi (544 MPa)
Yield Strength:	68,500 psi (473 MPa)	62,800 psi (433 MPa)
Elongation % in 2":	22.5%	28%

Typical Charpy V-Notch Impact Values

Temperature	Low Heat Input (Avg. 30 kJ/in) (Fast cooling rate)	High Heat Input (Avg. 80 kJ/in) (Slow cooling rate)
Avg. at +70°F (+20°C)	77 ft•lbs (104 Joules)	73 ft•lbs (99 Joules)
Avg. at 0°F (-18°C)	60 ft•lbs (81 Joules)	50 ft•lbs (68 Joules)



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