

FabCO® **HORNET**

HOBART

**A HIGH PERFORMING WELDING WIRE FOR:
GENERAL FABRICATION, STRUCTURAL STEEL,
HEAVY EQUIPMENT MANUFACTURING OR REPAIR, LOW-ALLOY OR MILD STEEL**

FabCO Hornet gas-shielded flux-cored welding wire is designed for all-position applications and is usable with either 100% CO₂ or a 75% Argon/25% CO₂ shielding gas mixture. It is recommended for single- and multi-pass applications.

FEATURES:

- Superior penetration profiles
- Easy slag removal, and low spatter levels
- Good impact strength
- Low fume generation rate

BENEFITS:

- Easier to produce sound welds
- Reduced cleanup time
- Increased toughness at low temperatures
- Increased welder appeal, improved working environment

Applications:

- Mild and fine grain low alloy steel
- Structural steel
- General fabrication
- Heavy equipment

Conformances and approvals

- AWS A5.20, E71T-1C H8, E71T-1M H8, E71T-9C H8, E71T-9M H8, ASME SFA 5.20, E71T-1C/M
- ABS 100% CO₂ 3SA, 3YSA H10, 75%/Ar/25%CO₂ 3SA, 3YSA H10
- CWB 100% CO₂ E491T-9 H8, 80%/Ar/20%CO₂ E491T-9M H8



FabCo Hornet, gas-shielded flux-cored wire designed for all-position applications with 100% CO₂ or a 75% Argon/25% CO₂ mix.

TYPICAL WELD METAL PROPERTIES* (Chem Pad)

Weld Metal Analysis	100% CO ₂	75% Ar/25% CO ₂
Carbon (C)	0.030	0.035
Manganese (Mn)	1.45	1.65
Silicon (Si)	0.30	0.40
Sulphur (S)	0.011	0.010
Phosphorus (P)	0.008	0.008

TYPICAL DIFFUSIBLE HYDROGEN:

	100% CO ₂	75% Ar/25% CO ₂
(Gas Chromatography)	5.0 ml/100g	7.0 ml/100g

TYPICAL MECHANICAL PROPERTIES* (Aged 48 hrs @220°F)

	100% CO ₂	75% Ar/25% CO ₂
Tensile Strength	82,500 psi (569 MPa)	90,000 psi (621 MPa)
Yield Strength	79,000 psi (545 MPa)	79,500 psi (548 MPa)
Elongation % in 2"	27%	26%

TYPICAL CHARPY V-NOTCH IMPACT VALUES*(AW)

	100% CO ₂	75% Ar/25% CO ₂
Avg. at 0°F (-18°C)	90 ft-lbs (122 Joules)	80 ft-lbs (108 Joules)
Avg. at -20°F (-29°C)	60 ft-lbs (81 Joules)	75 ft-lbs (102 Joules)

PART NUMBERS

FabCO Hornet (E71T-1C, RE71T-1M, E71T-9C, E71T-9M)

Diameter	Package	Part Number
.045" (1.2mm)	33-lb (15kg) Spool	S246212-029
.045" (1.2mm)	44-lb (20kg) Spool	S246212-044
.052" (1.4mm)	33-lb (15kg) Spool	S246215-029
1/16" (1.6mm)	60-lb (27kg) Coil	S246219-002
1/16" (1.6mm)	33-lb (15kg) Spool	S246219-029

HOBART
HOBART BROTHERS

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