

AWS E70T-1C, E70T-9C

FabCO[®]RXR**DESCRIPTION:**

Designed for flat and horizontal lap, fillet and groove welding applications that require extra deoxidation, **FabCO RXR** is a high-quality, gas-shielded tubular wire that is formulated with added deoxidizers to allow you to weld through rust, mill scale and light oil without the need for pre-cleaning. Also excellent for welding clean plates, FabCO RXR offers a spray-type transfer which, combined with its high deposition rate, promotes deep penetration of the weld metal to produce a strong, low hydrogen weld deposit with slag that is easy to remove. Because it can maintain its high operator-appeal throughout a wide range of amperage settings, FabCO RXR is a very versatile wire, suitable for the single-or multi-pass welding of mild steels and some low alloy steels.

APPLICATIONS:

Steel structures, storage vessels, earthmoving equipment, heavy fabrication and railroad cars.

FEATURES:

- Outstanding welding performance
- Smooth and stable arc
- Easy slag removal
- Deep side wall fusion
- High deposition rates
- Operates extremely well within a wide range of amperage settings

BENEFITS:

- Excellent operator appeal
- Easy to control
- Reduces clean-up time
- Reduces cold lap
- Increases productivity
- Very versatile

SHIELDING GAS: 100% CO₂

TYPE OF CURRENT: DCEP

TYPICAL WELD METAL PROPERTIES*(Chem Pad):

Weld Metal Analysis	100% CO ₂
Carbon (C)	0.07
Manganese (Mn)	1.47
Phosphorus (P)	0.012
Sulphur (S)	0.009
Silicon (Si)	0.59

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

Tensile Strength	89,000 psi (614 MPa)
Yield Strength	73,000 psi (503 MPa)
Elongation % in 2"	25%

TYPICAL CHARPY V-NOTCH IMPACT VALUES*(AW):

Avg. at 0°F (-18°C)	42 ft •lbs (57 Joules)
Avg. at -20°F (-29°C)	28 ft •lbs (38 Joules)

CONFORMANCES AND APPROVALS:

- AWS A5.20, E70T-1C, E70T-9C, ASME SFA 5.20
- ABS 100% CO₂ 2SA, 2YSA H10
- CWB E492T-9 H8
- MIL-E-24403/1, Class MIL-70T-1C

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with AWS A5.20 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

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WELDING DATA:

The information listed below was determined using 100% CO₂ shielding gas with flow range between 35 to 40 cubic feet per hour. Welding was performed in the position designated below with DCEP welding current.

Diameter Inches mm	Optimum Welding Parameter	Weld Position	Amps	Volts	Wire-Feed Speed in/min	Deposition Rate lbs/hr	Stickout ±1/4"
.045 1.2	*	Flat, Horizontal	150	25.0	225	3.5	3/4"
.045 1.2		Flat, Horizontal	180	27.0	280	5.3	3/4"
.045 1.2		Flat, Horizontal	250	29.0	450	8.0	3/4"
1/16 1.6	*	Flat, Horizontal	200	25.0	138	4.7	3/4"
1/16 1.6		Flat, Horizontal	250	26.0	177	6.0	3/4"
1/16 1.6		Flat, Horizontal	300	27.0	230	8.4	3/4"
1/16 1.6		Flat, Horizontal	350	28.0	280	10.9	3/4"
1/16 1.6		Flat, Horizontal	375	29.0	311	11.6	3/4"
5/64 2.0	*	Flat, Horizontal	250	26.0	119	6.6	1"
5/64 2.0		Flat, Horizontal	300	29.0	145	8.4	1"
5/64 2.0		Flat, Horizontal	350	31.0	181	10.2	1"
5/64 2.0		Flat, Horizontal	400	33.0	226	12.1	1"
3/32 2.4	*	Flat, Horizontal	350	26.0	120	9.2	1"
3/32 2.4		Flat, Horizontal	400	29.0	142	11.5	1"
3/32 2.4		Flat, Horizontal	450	32.0	174	13.7	1"
3/32 2.4		Flat, Horizontal	500	34.0	201	15.2	1"
3/32 2.4		Flat, Horizontal	550	36.0	234	18.1	1"
7/64 2.8	*	Flat, Horizontal	500	30.0	125	13.4	1"
7/64 2.8		Flat, Horizontal	550	32.0	145	15.5	1"
7/64 2.8		Flat, Horizontal	600	34.0	176	18.5	1"
7/64 2.8		Flat, Horizontal	650	36.0	196	20.6	1"
7/64 2.8		Flat, Horizontal	700	36.0	221	23.6	1"
1/8 3.2	*	Flat, Horizontal	600	32.0	120	17.8	1"
1/8 3.2		Flat, Horizontal	650	34.0	130	19.7	1"
1/8 3.2		Flat, Horizontal	700	36.0	143	21.4	1"
1/8 3.2		Flat, Horizontal	750	38.0	155	22.0	1"
1/8 3.2		Flat, Horizontal	800	38.0	166	24.6	1"

TYPICAL APPLICATIONS: • Mild and low-alloy steels • Single and multi-pass applications • Steel structures • Storage vessels • Earthmoving equipment • Heavy fabrications • Railroad cars including center sills • Strickers • Bolsters • Side sheets and more

Caution:

Consumers should be thoroughly familiar with precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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