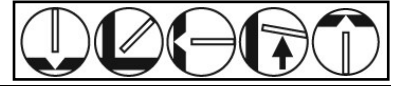


Fabshield® XLR-8™



AWS A5.20: E71T-8J H8
EN ISO 17632-A: T42 2 Y NO 2 H10

WELDING POSITIONS:



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
- Excellent mechanical properties within a wide range of heat inputs

BENEFITS:

- Increases productivity
- Provides increased resistance to cracking, promotes X-ray quality welds
- Increases productivity, minimizes risk of slag entrapment
- Suitable for welding outdoors without sheltering
- Resists cracking in severe applications
- Usable under AWS D1.8 for use on Demand Critical welds

APPLICATIONS:

- Structural steel erection
- Heavy equipment repair
- Non-alloyed and fine grain steels
- Ship and barge construction
- Bridge construction
- AWS D1.8 demand-critical applications

WIRE TYPE: Fast-freezing, basic-type, flux-cored wire

SHIELDING GAS: None required

TYPE OF CURRENT: Direct Current Electrode Negative (DCEN)

Note: Fabshield XLR-8 is intended to be used with constant-voltage (CV) power sources.

RE-DRYING: Not recommended

STORAGE: Product should be stored in a dry, enclosed environment and in its original intact packaging

TYPICAL WELD METAL CHEMISTRY* (Chem Pad):

| Weld Metal Analysis (%) | Fabshield® XLR-8 | AWS Spec |
|-------------------------|------------------|----------|
| Carbon (C) | 0.19 | 0.30 |
| Manganese (Mn) | 0.51 | 1.75 |
| Silicon (Si) | 0.17 | 0.60 |
| Phosphorus (P) | 0.009 | 0.03 |
| Sulphur (S) | 0.006 | 0.03 |
| Aluminum (Al) | 0.51 | 1.80 |

Note: AWS specification single values are maximums.

TYPICAL MECHANICAL PROPERTIES* (As Welded):

| Mechanical Tests | Fabshield® XLR-8 | AWS Spec |
|----------------------------|----------------------|---------------------------------|
| Tensile Strength | 84,000 psi (579 MPa) | 70,000-95,000 psi (490-670 MPa) |
| Yield Strength | 68,000 psi (469 MPa) | 58,000 psi (400 MPa) Min. |
| Elongation % in 2" (50 mm) | 28% | 22% Min. |

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded):

| CVN Temperatures | Fabshield® XLR-8 | AWS Spec |
|-----------------------|------------------------|-----------------------------|
| Avg. at -20°F (-30°C) | 40 ft •lbs (54 Joules) | 20 ft •lbs (27 Joules) Min. |
| Avg. at -40°F (-40°C) | 31 ft •lbs (42 Joules) | 20 ft •lbs (27 Joules) Min. |

TYPICAL DIFFUSIBLE HYDROGEN*:

| Hydrogen Equipment | Fabshield® XLR-8 | AWS Spec |
|--------------------|------------------|------------------|
| Gas Chromatography | 6.7 ml/100g | 8.0 ml/100g Max. |

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the 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 LLC.

Fabshield® XLR-8™

| Diameter Inches (mm) | | Welding Position | Amperage | Voltage | Wire Feed Speed in/min (m/min) | | Deposition Rate lbs/hr (kg/hr) | | Contact Tip to Work Distance Inches (mm) | |
|-------------------------|-------|-------------------|----------|---------|-----------------------------------|-------|-----------------------------------|-------|--|------|
| 1/16 | (1.6) | All Position | 180 | 18 | 145 | (3.7) | 3.3 | (1.5) | 1 | (25) |
| 1/16 | (1.6) | All Position | 210 | 21 | 187 | (4.8) | 4.7 | (2.1) | 1 | (25) |
| 1/16 | (1.6) | All Position | 230 | 22 | 210 | (5.3) | 5.5 | (2.5) | 1 | (25) |
| 1/16 | (1.6) | All Position | 255 | 23 | 250 | (6.4) | 6.3 | (2.8) | 1 | (25) |
| 1/16 | (1.6) | Flat & Horizontal | 265 | 22 | 275 | (6.9) | 7.3 | (3.3) | 1 | (25) |
| 1/16 | (1.6) | Flat & Horizontal | 275 | 23 | 315 | (8.0) | 8.1 | (3.8) | 1 | (25) |
| 0.072 | (1.8) | All Position | 170 | 18 | 100 | (2.4) | 3.2 | (1.5) | 1 | (25) |
| 0.072 | (1.8) | All Position | 230 | 22 | 160 | (4.1) | 5.9 | (2.7) | 1 | (25) |
| 0.072 | (1.8) | All Position | 245 | 22 | 170 | (4.3) | 6.3 | (2.9) | 1 | (25) |
| 0.072 | (1.8) | All Position | 265 | 22 | 200 | (5.1) | 7.5 | (3.4) | 1 | (25) |
| 0.072 | (1.8) | Flat & Horizontal | 315 | 23 | 280 | (7.1) | 10.7 | (4.8) | 1 | (25) |
| 5/64 | (2.0) | All Position | 200 | 18 | 100 | (2.5) | 4.0 | (1.8) | 1 1/4 | (32) |
| 5/64 | (2.0) | All Position | 230 | 18 | 125 | (3.2) | 5.1 | (2.3) | 1 1/4 | (32) |
| 5/64 | (2.0) | All Position | 255 | 22 | 160 | (4.1) | 6.5 | (2.9) | 1 1/4 | (32) |
| 5/64 | (2.0) | All Position | 280 | 23 | 200 | (5.1) | 8.2 | (3.7) | 1 1/4 | (32) |
| 5/64 | (2.0) | Flat & Horizontal | 340 | 24 | 280 | (7.1) | 11.2 | (5.1) | 1 1/4 | (32) |

Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.

Note: Fabshield XLR-8 is intended to be used with constant-voltage (CV) power sources.

All positions include: Flat, Horizontal, Vertical Up, and Overhead

AVAILABLE DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543 or (937) 332-5188 for International Customer Service.

| Diameter Inches (mm) | 12-lb. (5.4kg) VCI Packaged Spool | 15-lb. (6.8kg) VCI Packaged Spool | 20-lb. (9.1kg) VCI Packaged Spool | 33-lb. (15kg) VCI Packaged Spool | 50-lb. (22 kg) VCI Packaged Coil |
|--------------------------|---|---|---|--|--|
| Net Pallet Weight | 1920-lb. (871kg) | 1080-lb. (495kg) | 1440-lb (653kg) | 2376-lb (1078kg) | 1600-lb. (726 kg) |
| 1/16 (1.6) | S225719-079 | S225719-083 | S225719-082 | S225719-043 | — |
| 0.072 (1.8) | — | S225724-083 | S225724-082 | S225724-043 | S225724-V14 |
| 5/64 (2.0) | — | — | S225725-082 | S225725-043 | — |

CONFORMANCES AND APPROVALS:

- **AWS A5.20**, E71T-8J H8
- **AWS A5.20M**, E491T-8J H8
- **ASME SFA 5.20**, E71T-8J H8
- **ABS**, 3YSA H10
- **CWB**, E491T8-A4-CS3-H8 (E491T-8J-H8)
- **DNV-GL**, II Y40 MS(H10) (1/16"-5/64")
- **EN ISO 17632-A**: T42 2 Y NO 2 H10
- **CE Marked** per CPR 305/2011
- **AWS D1.8/D1.8M**, 1/16" (1.6 mm) - 5/64" (2.0 mm) diameter electrodes

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION: Consumers should be thoroughly familiar with the safety 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, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); 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 LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

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

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Revision Date: 260428 (Replaces 260424)

