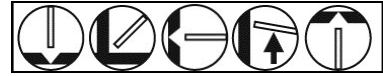


# Hobart® 447C



AWS E6013 (E4313\*)

WELDING POSITIONS:



**FEATURES:**

- Excellent arc stability
- Fast-freeze
- All-position
- Slag removes easily
- Softer arc than Hobart 447A

**BENEFITS:**

- Welding accuracy and efficiency
- Excellent for poor fit-up
- Welds in flat, horizontal, vertical, and overhead position
- Quick clean-up
- Easier to control, less spatter

**APPLICATIONS:**

- General purpose fabrication
- Metal buildings and structures
- Machine parts
- Shaft build-up

**TYPE OF CURRENT:** AC, Direct Current Electrode Negative (DCEN), or Direct Current Electrode Positive (DCEP)

**RECOMMENDED WELDING TECHNIQUES:**

- GENERAL:** AC; Electrode negative, work positive (DCEN); or electrode positive, work negative (DCEP)
- ARC LENGTH:** Average length (1/8" to 1/4")
- FLAT:** Angle electrodes 10-15° from 90° with higher heat than E6011 electrodes
- VERTICAL-UP:** Reduce amperage from flat position
- VERTICAL-DOWN:** Use higher amperage and faster travel staying ahead of puddle
- OVERHEAD:** Use slight whipping motion; multi-pass for build-up

**STORAGE:** 60°F to 100°F, (20° to 40°C) and below 50% relative humidity or holding oven @ 100° to 120°F (38° to 49°C)

**RECONDITIONING:** 250°F to 300°F (121° to 149°C) for one hour @ temperature

**TYPICAL WELD METAL PROPERTIES\* (Chem Pad):**

Weld Metal Analysis (%)		AWS Spec (max)
Carbon (C)	0.08	Not required
Manganese (Mn)	0.40	Not required
Phosphorus (P)	0.019	Not required
Sulphur (S)	0.022	Not required
Silicon (Si)	0.25	Not required
Chromium (Cr)	0.03	Not required
Vanadium (V)	0.02	Not required
Nickel (Ni)	0.02	Not required
Molybdenum (Mo)	<0.01	Not required

**TYPICAL MECHANICAL PROPERTIES\* (As Welded):**

		AWS Spec (min)
Tensile Strength	74,000 psi (507 MPa)	60,000 psi
Yield Strength	65,000 psi (450 MPa)	48,000 psi
Elongation % in 2"	28%	17%

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

Not applicable

\*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 the AWS A5.1 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.

# Hobart® 447C

Diameter		Type of Power	Minimum Amps	Optimum* Amps	Maximum Amps
Inches	mm				
3/32	2.4	AC, DCEN or DCEP	40	70	80
1/8	3.2	AC, DCEN or DCEP	70	100	120
5/32	4.0	AC, DCEN or DCEP	130	150	160

\*For out of position welding, reduce amperages shown by 15%.

## TYPICAL DEPOSITION DATA (at optimum):

Diameter		Type of Power	Amps	Volts	Deposition Rate lbs/hr	Deposition Efficiency*%
Inches	mm					
3/32	2.4	AC	70	19-26.5	1.35	63.7
1/8	3.2	AC	100	18.5-22.5	1.85	66.1
5/32	4.0	AC	150	20-24	2.67	61.6

\*Allowance made for 2" stub loss included.

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

**STANDARD 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		Length		50-lb Can
Inches	mm	Inches	mm	
3/32	2.4	14	355	S117132-031
1/8	3.2	14	355	S117144-031
5/32	4.0	14	355	S117151-031

## CONFORMANCES AND APPROVALS:

- **AWS A5.1**, E6013, ASME SFA 5.1, F-2, A-1
- **ABS** E6013
- **CWB** E4313

## 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, 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 or at [www.hobartbrothers.com](http://www.hobartbrothers.com).

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

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Revision Date: 131001 (Replaces 070828)

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