



HOBART BROTHERS

FLUX-COR 7

AWS A5.20: E70T-1C, E70T-9C

WELDING POSITIONS:



FEATURES:

- Outstanding welding performance
- Smooth and stable arc
- Easy slag removal
- Deep side wall fusion
- High deposition rates
- Very flexible amperage range

BENEFITS:

- Excellent operator appeal
- Easy to control
- Reduces clean-up time
- Minimizes cold lap
- Increases productivity
- Promotes versatility

APPLICATIONS:

- Steel structures
- Storage vessels
- Earthmoving equipment
- Heavy fabrication
- Rail cars
- Single or multi-pass welding
- Non-alloyed and fine grain steels

SLAG SYSTEM: Slow freezing, rutile type, flux-cored wire

SHIELDING GAS: 100% Carbon Dioxide (CO₂), 35-50 cfh (14-24 l/min)

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS: 1/16" (1.6 mm), 5/64" (2.0 mm), 3/32" (2.4 mm)

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	100% CO ₂	AWS Spec
Carbon (C)	0.03	0.12
Manganese (Mn)	1.60	1.75
Silicon (Si)	0.68	0.90
Phosphorus (P)	0.007	0.03
Sulphur (S)	0.012	0.03

Note: AWS specification single values are maximums.

TYPICAL MECHANICAL PROPERTIES* [Aged 48 hrs @ 200°F (93°C)]:

Mechanical Tests	100% CO ₂	AWS Spec
Tensile Strength	86,000 psi (592 MPa)	70,000-95,000 psi (490-670 MPa)
Yield Strength	75,000 psi (518 MPa)	58,000 psi (390 MPa) Minimum
Elongation % in 2" (50 mm)	24%	22% Minimum

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (AS WELDED):

CVN Temperatures	100% CO ₂	AWS Spec
Avg. at 0°F (-20°C)	28 ft•lbs (38 Joules)	20 ft•lbs (27 Joules)
Avg. at -20°F (-30°C)	29 ft•lbs (40 Joules)	20 ft•lbs (27 Joules)

*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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Diameter		Weld Position	Amps	Volts	Wire Feed Speed		Deposition Rate		Contact Tip to Work Distance	
Inches	(mm)				in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
1/16	(1.6)	Flat & Horizontal	200	25	138	(3.5)	4.7	(2.1)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	300	27	230	(5.8)	8.4	(3.8)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	375	29	311	(7.9)	11.6	(5.3)	3/4	(19)
5/64	(2.0)	Flat & Horizontal	250	26	119	(3.0)	6.6	(3.0)	1	(25)
5/64	(2.0)	Flat & Horizontal	300	29	145	(3.7)	8.4	(3.8)	1	(25)
5/64	(2.0)	Flat & Horizontal	350	31	181	(4.6)	10.2	(4.6)	1	(25)
5/64	(2.0)	Flat & Horizontal	400	33	226	(5.7)	12.1	(5.5)	1	(25)
3/32	(2.4)	Flat & Horizontal	350	26	120	(3.1)	9.2	(4.2)	1	(25)
3/32	(2.4)	Flat & Horizontal	400	29	142	(3.6)	11.5	(5.2)	1	(25)
3/32	(2.4)	Flat & Horizontal	450	32	174	(4.4)	13.7	(6.2)	1	(25)
3/32	(2.4)	Flat & Horizontal	550	36	234	(5.9)	18.1	(8.2)	1	(25)

- 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		60-lb. (27 kg) Coil	600-lb. (272.2 kg) Drum
Inches	(mm)		
1/16	(1.6)	S246519-X02	—
5/64	(2.0)	—	S246525-X08
3/32	(2.4)	S246529-X02	S246529-X08

CONFORMANCES AND APPROVALS:

- AWS A5.20, E70T-1C, E70T-9C
- AWS A5.20M, E490T-1C, E490T-9C
- ASME SFA 5.20, E70T-1C, E70T-9C
- ABS, 100%Co2, 2YSA H10
- CWB, E492T-9-H8

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.

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