

# FabTuf® 960



## WELDING POSITIONS:



### FEATURES:

- Martensitic deposit
- Good for metal-to-metal applications

### APPLICATIONS:

- Coupling Boxes
- Dragline Chain
- Kiln Trunnions
- Mill Guides
- Spindles
- Ore Drag Lines

### BENEFITS:

- Low fume
- Virtually no silica deposits
- Excellent in all positions
- Dredge Parts
- Muller Tires
- Extruder Worms
- Conveyor Bucket Lips Coal Conveyors
- Wobbler Ends

**WIRE TYPE:** Gas shielded, metal powder, metal-cored wire

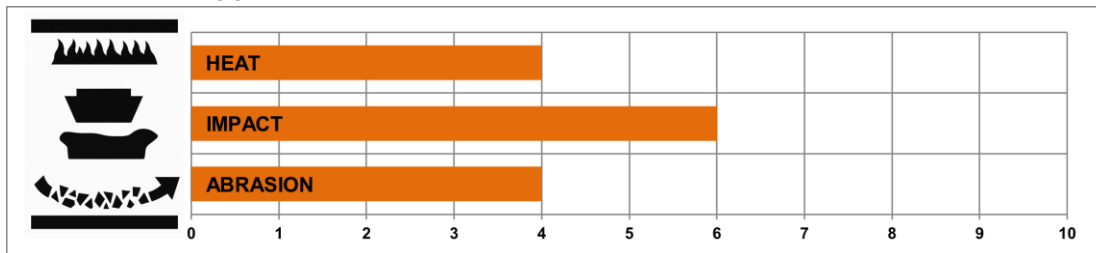
**SHIELDING GAS:** 100% Carbon Dioxide (CO<sub>2</sub>) 75% Argon (Ar)/25% Carbon Dioxide (CO<sub>2</sub>), 35-50 cfh (19-24 l/min)

**TYPE OF CURRENT:** Direct Current Electrode Positive (DCEP)

**RE-DRYING:** Not recommended

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

### RELATIVE WEAR RESISTANCE:



### TYPICAL WELD METAL CHEMISTRY\* (Chem Pad):

Weld Metal Analysis (%)	
Carbon (C)	0.70
Manganese (Mn)	2.00
Silicon (Si)	1.00
Chromium (Cr)	8.00
Iron (Fe)	Bal.

### TYPICAL DEPOSIT HARDNESS\* (As Welded):

Layers	1020 Steel
1 - Unlimited	52 – 55 HRC

Note: This information was determined by welding using 100% CO<sub>2</sub> shielding gas

### TYPICAL PHYSICAL PROPERTIES:

Machineability	Flame Cutting	Magnetic
Grind Only	No	Yes

\*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 A5.18 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.

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Diameter Inches (mm)	Welding Position	Amperage	Voltage	Wire Feed Speed		Deposition Rate		Contact Tip to Work Distance	
				in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
0.045 (1.2)	All Position	120-160	19-23	160	(4.1)	4.0	(1.8)	1/2 – 1	(13-25)
0.045 (1.2)	All Position	160-190	24-25	280	(7.1)	7.0	(3.1)	1/2 – 1	(13-25)
0.045 (1.2)	All Position	190-230	26-27	400	(10.2)	10.0	(4.5)	1/2 – 1	(13-25)
1/16 (1.6)	All Position	225-275	23-25	130	(3.3)	6.0	(2.7)	1 – 1 1/2	(25-38)
1/16 (1.6)	All Position	275-350	24-27	215	(5.5)	10.0	(4.5)	1 – 1 1/2	(25-38)
1/16 (1.6)	All Position	350-400	26-29	300	(7.6)	14.0	(6.3)	1 – 1 1/2	(25-38)

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

**See Above:** This information was determined by welding using 75% Ar/25% CO<sub>2</sub> shielding gas with a flow rate between 35-50 cfm (17-24 l/min). When welding using 100% CO<sub>2</sub> shielding gas, increase voltage by 1-3 volts.

**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)	33 lb. (15kg) Fiber Spool	750 lb. (340kg) Octagonal Drum
<b>Net Pallet Weight</b>	<b>2376 lb. (1077kg)</b>	<b>750 lb. (340kg)</b>
0.045 (1.2)	S234212-029	—
1/16 (1.6)	S234219-029	S234219-076

**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](mailto: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](http://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](http://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: 260409** (Replaces 230509)

