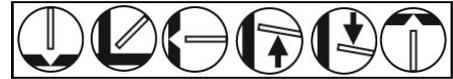


Fabshield® 23



AWS A5.20: E71T-14

WELDING POSITIONS:



FEATURES:

- No external shielding gas required
- High deoxidizer content
- Smooth arc transfer and good puddle fluidity
- Low spatter and excellent bead appearance

BENEFITS:

- Can be used outdoors, reduces equipment requirements
- Suitable for welding rusty, painted, and coated/galvanized steels
- Excellent operator appeal, ease of use by novice welders
- Reduces clean-up time, improves productivity

APPLICATIONS:

- Single-pass welding ONLY
- Sheet metal [thickness <1/4" (6.4mm)]
- Light-duty fabrication and repair
- Transportation & automotive industries
- Galvanized and coated steels
- Ornamental iron/steel

SLAG SYSTEM: Fast freezing, basic-type, flux-cored wire

SHIELDING GAS: Not required

TYPE OF CURRENT: Direct Current Electrode Negative (DCEN)

STANDARD DIAMETERS: 0.045" (1.2 mm), 1/16" (1.6 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 %	Fabshield 23	AWS Spec
Carbon (C)	0.18	Not specified
Manganese (Mn)	0.65	Not specified
Phosphorus (P)	0.01	Not specified
Sulphur (S)	0.01	Not specified
Silicon (Si)	0.40	Not specified
Aluminum (Al)	1.30	Not specified

Note: AWS specification single values are maximums.

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests	Fabshield 23	AWS Spec
Transverse Tensile Strength	77,000 psi (531 MPa) (Base Metal Failure)	70,000 psi (483 MPa) Minimum
Longitudinal Bend Test Result	Conforms; no discontinuities	180° Bend w/0.75" (19mm) radius. Surface discontinuities must be <1/8" (3.2mm)

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded): Not required

*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 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® 23

Diameter Inches (mm)		Weld Position	Amps	Volts	Wire-Feed Speed in/min (m/min)		Deposition Rate lbs/hr (kg/hr)		Contact Tip to Work Distance Inches (mm)	
0.045	(1.2)	All Position	125	15	105	(2.7)	1.8	(0.8)	1/2	(13)
0.045	(1.2)	All Position	150	17	170	(4.3)	2.8	(1.3)	1/2	(13)
1/16	(1.6)	All Position	150	18	70	(1.8)	2.4	(1.1)	3/4	(19)
1/16	(1.6)	All Position	250	20	145	(3.7)	5.9	(2.7)	3/4	(19)

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**
- **All positions include:** Flat, Horizontal, Vertical Up, Vertical Down, and Overhead.

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 Inches (mm)		600-lb. (272.2kg) X-Pak
Net Pallet Weight		2400-lb. (1089kg)
0.045	(1.2)	S222312-056
1/16	(1.6)	S222319-056

CONFORMANCES AND APPROVALS:

- **AWS A5.20**, E71T-14
- **AWS A5.20M**, E491T-14
- **ASME SFA 5.20**, E71T-14
- **CWB**, E491TGS (E491T-GS) [1.2 mm diameter electrode]

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

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: 210122 (Replaces 191120)
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