

# Fabshield<sup>®</sup> 4



AWS A5.20: E70T-4

WELDING POSITIONS:



**FEATURES:**

- Ease of operation
- No shielding gas required
- High deposition rates
- Easy slag removal

**BENEFITS:**

- Reduces welder training time
- Can be used outdoors
- Allows faster travel speeds
- Reduces clean-up

**APPLICATIONS:**

- Machine fabrication
- Certain ship equipment
- Industrial and heavy equipment repair

**SHIELDING GAS:** Not required

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

**STANDARD DIAMETERS:** 5/64" (2.0 mm), 3/32" (2.4 mm), 0.120" (3.0 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		AWS Spec
Carbon (C)	0.27	0.30
Manganese (Mn)	0.73	1.75
Phosphorus (P)	0.011	0.03
Sulphur (S)	0.005	0.03
Silicon (Si)	0.30	0.60
Aluminum (Al)	1.42	1.80

**TYPICAL MECHANICAL PROPERTIES\* [Aged 48 Hrs. @ 220°F (93°C)]:**

Mechanical Tests	
Tensile Strength	94,600 psi (652 MPa)
Yield Strength	62,600 psi (432 MPa)
Elongation % in 2" (50 mm)	24%

**TYPICAL CHARPY V-NOTCH IMPACT VALUES\*:** 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.

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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)		
5/64	(2.0)	Flat, Horizontal	290	29	200	(5.1)	11	(4.9)	2	(51)
5/64	(2.0)	Flat, Horizontal	330	30	250	(6.4)	13	(5.9)	2	(51)
5/64	(2.0)	Flat, Horizontal	370	31	300	(7.6)	16	(7.3)	2	(51)
3/32	(2.4)	Flat, Horizontal	250	28	125	(3.2)	9	(4.1)	2-1/2	(64)
3/32	(2.4)	Flat, Horizontal	320	29	150	(3.8)	12	(5.4)	2-1/2	(64)
3/32	(2.4)	Flat, Horizontal	400	31	230	(5.8)	18	(8.2)	2-1/2	(64)
3/32	(2.4)	Flat, Horizontal	450	32	275	(7.0)	22	(10.0)	2-1/2	(64)
3/32	(2.4)	Flat, Horizontal	500	34	375	(9.5)	28	(12.7)	2-1/2	(64)
0.120	(3.0)	Flat, Horizontal	450	28	160	(4.8)	19	(8.6)	2-3/4	(70)
0.120	(3.0)	Flat, Horizontal	500	31	200	(5.1)	23	(10.4)	2-3/4	(70)
0.120	(3.0)	Flat, Horizontal	560	33	225	(5.7)	26	(11.8)	2-3/4	(70)
0.120	(3.0)	Flat, Horizontal	560	35	210	(5.3)	26	(11.8)	2-3/4	(70)
0.120	(3.0)	Flat, Horizontal	680	37	300	(7.6)	42	(19.1)	2-3/4	(70)

- 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		20-lb. (9.1kg)	33-lb. (15kg)	50-lb. (22.7kg)	600-lb. (272.2kg)
Inches	(mm)	Spool	Spool	Coil	Drum
5/64	(2.0)	S224525-082	S224525-029	S224525-014	S224525-008
3/32	(2.4)	—	—	S224529-V14	S224529-008
0.120	(3.0)	—	—	S224541-014	S224541-008

#### CONFORMANCES AND APPROVALS:

- AWS A5.20, E70T-4
- AWS A5.20M, E490T-4
- ASME SFA 5.20, E70T-4

**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

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: 191119 (Replaces 131115)  
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