

FabCO[®] 73



AWS A5.20: E70T-2C

WELDING POSITIONS:



FEATURES:

- Much higher deoxidizer level than E70T-1 flux-cored wires
- Excellent arc stability, even at lower currents
- Low spatter and good slag removal
- Slow freezing slag
- Large diameter wire

BENEFITS:

- Greatly improves weldability and tolerance to poor base metal surface conditions when performing single-pass welds
- Improves operator appeal and assists producing welds of uniform appearance and quality
- Reduces clean-up time to improve productivity
- Provides good, uniform bead appearance in the flat and horizontal position
- Allows use of high currents to increase deposition rate, travel speed, and productivity

APPLICATIONS:

- Single pass welding only
- Rimmed steels
- General fabrication
- Base material w/heavy mill scale
- Rusty and painted base material

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

SHIELDING GAS: 100% Carbon Dioxide (CO₂), 35-50 cfh (17-24 l/min)

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS: 7/64" (2.8 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): Not required

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests	100% CO ₂	AWS Spec
Traverse Tensile Strength	76,000 psi (524 MPa) (Base Metal Fracture)	70,000 psi (480 MPa) Minimum
Longitudinal Bend Test	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 the 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 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)	
7/64	(2.8)	Flat & Horizontal	400	28	95	(2.4)	10.0	(4.5)	1	(25)
7/64	(2.8)	Flat & Horizontal	500	32	150	(3.8)	16.2	(7.4)	1-1/4	(32)
7/64	(2.8)	Flat & Horizontal	650	38	195	(5.0)	21.3	(9.7)	1-1/4	(32)

- **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 100% CO₂ shielding gas with a flow rate between 35-50 cfh (17-24 l/min).

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)	60-lb. (27.2kg) Coil
Net Pallet Weight	1920-lb. (871 kg)
7/64 (2.8)	S248239-002

CONFORMANCES AND APPROVALS:

- **AWS A5.20**, E70T-2C
- **AWS A5.20M**, E490T-2C
- **ASME SFA 5.20**, E70T-2C

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 36 St, # 130, Doral, FL 33166-6672 (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

Material Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

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