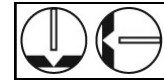


Fabshield® 7027



AWS A5.20: E70T-7

WELDING POSITIONS:



FEATURES:

- Performs best at high amperages and voltages
- Fast-freezing slag
- Lower spatter levels and easy slag removal
- Self-shielded

BENEFITS:

- Provides higher deposition and side wall fusion
- Eliminates slag interference problems
- Reduces clean-up and promotes operator appeal
- No external shielding gas required

APPLICATIONS:

- Barges
- Structural steel fabrications

SHIELDING GAS: Not required

TYPE OF CURRENT: Direct Current Electrode Negative (DCEN)

STANDARD DIAMETERS: 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 PROPERTIES* (Chem Pad):

Weld Metal Analysis %	
Carbon (C)	0.27
Manganese (Mn)	0.30
Silicon (Si)	0.06
Phosphorus (P)	0.009
Sulphur (S)	0.003
Aluminum (Al)	1.54

Note: AWS specification single values are maximums.

TYPICAL MECHANICAL PROPERTIES* (Aged 48 hrs @ 220°F):

Tensile Strength	92,000 psi (636 MPa)
Yield Strength	63,200 psi (436 MPa)
Elongation % in 2"	23%

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

*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® 7027

Diameter Inches (mm)	Weld Position	Amps	Volts	Wire Feed Speed		Deposition Rate		CTWD	
				in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
3/32" (2.4 mm)	Flat & Horizontal	240	27	90	(2.3)	6.0	(2.7)	1-1/2"	(38)
3/32" (2.4 mm)	Flat & Horizontal	330	29	150	(3.8)	10.8	(4.9)	1-1/2"	(38)
3/32" (2.4 mm)	Flat & Horizontal	470	30	260	(6.6)	20.6	(9.3)	1-1/2"	(38)
3/32" (2.4 mm)	Flat & Horizontal	560	32	300	(7.6)	25.4	(11.5)	1-1/2"	(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.**

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)	50 lb.(22.7 kg) Coil (VCL Packages)
3/32" (2.4 mm)	S222729-V14

CONFORMANCES AND APPROVALS:

- AWS A5.20, E70T-7
- ASME SFA 5.20, 70T-7
- ABS, AWS 70T-7

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.

Hobart and Fabshield are registered trademarks of Hobart Brothers LLC, Troy, Ohio.

Revision Date: 220922 (Replaces 190624)

640-M, INDEX

