Fabshield[®] XLR-8[™]



AWS A5.20: E71T-8J H8 EN ISO 17632-A: T42 2 Y NO 2 H10

WELDING POSITIONS:

FEATURES:	BENEFITS:	
 Welds out of position at hi Low hydrogen weld depose Excellent slag removal No shielding gas required High impact strength at log Excellent mechanical proposition wide range of heat inputs 	 gh currents increases productivity Provides increased res Increases productivity, Suitable for welding our Resists cracking in sev Usable under AWS D1. 	istance to cracking, promotes X-ray quality welds minimizes risk of slag entrapment tdoors without sheltering ere applications .8 for use on Demand Critical welds
APPLICATIONS:Structural steel erectionHeavy equipment repair	Non-alloyed and fine grain steelsShip and barge construction	Bridge constructionAWS D1.8 demand-critical applications
SLAG SYSTEM: Fast-freezin	g, basic-type, flux-cored wire	
SHIELDING GAS: None requ	ired	
TYPE OF CURRENT! Direct C	Surrent Fleetrede Negetive (DCFN)	

YPE OF CURRENT: Direct Current Electrode Negative (DCEN) Note: Fabshield XLR-8 is intended to be used with constant-voltage (CV) power sources.

STANDARD DIAMETERS: 1/16" (1.6 mm), 0.072" (1.8 mm), 5/64" (2.0 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 (%)	Fabshield XLR-8	AWS Spec
Carbon (C)	0.19	0.30
Manganese (Mn)	0.51	1.75
Silicon (Si)	0.17	0.60
Phosphorus (P)	0.009	0.03
Sulphur (S)	0.006	0.03
Aluminum (Al)	0.51	1.80

TYPICAL DIFFUSIBLE HYDROGEN*:

Hydrogen Equipment	Fabshield XLR-8	AWS Spec
(Gas Chromatography)	<6.7ml/100g	<8.0ml/100g

Note: AWS specification single values are maximums.

TYPICAL MECHANICAL PROPERTIES* [Aged 48 Hrs. @ 200°F (93°C)]:

Mechanical Tests	Fabshield XLR-8	AWS Spec
Tensile Strength	84,000 psi (579 MPa)	70,000-95,000 psi (490-670 MPa)
Yield Strength	68,000 psi (469 MPa)	58,000 psi (400 MPa) Minimum
Elongation % in 2" (50 mm)	28%	22% Minimum

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded):

CVN Temperatures	Fabshield XLR-8	AWS Spec
Avg. at -20°F (-30°C)	40 ft • lbs (54 Joules)	20 ft • lbs (27 Joules) Minimum
Avg. at -40°F (-40°C)	31 ft • lbs (42 Joules)	20 ft • lbs (27 Joules) Minimum "J" requirement

*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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Dian Inches	neter (mm)	Weld Position	Amps	Volts	Wire Sp in/min	e-Feed beed (m/min)	Depo Ra Ibs/hr	sition ate (kg/hr)	Contact Work Di Inches	Tip to stance (mm)
1/16 1/16 1/16 1/16 1/16 1/16	(1.6) (1.6) (1.6) (1.6) (1.6) (1.6)	All Position All Position All Position All Position Flat & Horizontal Flat & Horizontal	180 210 230 255 265 275	18 21 22 23 22 23 23	145 187 210 250 275 315	$\begin{array}{c} (3.7) \\ (4.8) \\ (5.3) \\ (6.4) \\ (6.9) \\ (8.0) \end{array}$	3.3 4.7 5.5 6.3 7.3 8.1	(1.5) (2.1) (2.5) (2.8) (3.3) (3.8)	1 1 1 1 1	(25) (25) (25) (25) (25) (25)
0.072 0.072 0.072 0.072 0.072	(1.8) (1.8) (1.8) (1.8) (1.8)	All Position All Position All Position All Position Flat & Horizontal	170 230 245 265 315	18 22 22 22 22 23	100 160 170 200 280	(2.4) (4.1) (4.3) (5.1) (7.1)	3.2 5.9 6.3 7.5 10.7	(1.5) (2.7) (2.9) (3.4) (4.8)	1 1 1 1	(25) (25) (25) (25) (25)
5/64 5/64 5/64 5/64 5/64	(2.0) (2.0) (2.0) (2.0) (2.0)	All Position All Position All Position All Position Flat & Horizontal	200 230 255 280 340	18 18 22 23 24	100 125 160 200 280	(2.5) (3.2) (4.1) (5.1) (7.1)	4.0 5.1 6.5 8.2 11.2	(1.8) (2.3) (2.9) (3.7) (5.1)	1 1/4 1 1/4 1 1/4 1 1/4 1 1/4 1 1/4	(32) (32) (32) (32) (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.

• Fabshield XLR-8 is intended to be used with constant-voltage (CV) power sources.

• All positions include: Flat, Horizontal, Vertical Up, 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.

Diam Inches	eter (mm)	12-lb. (5.4kg) VCI Packaged Spool	15 Lb (6.8 Kg) VCI Packaged Spool	20-lb. (9.1kg) VCI Packaged Spool	33-lb. (15kg) VCI Packaged Spool	50-lb. (22 kg) VCI Packaged Coil
Net Palle	ət	1920-lb (871kg)	1080-lb. (495kg)	1440-lb (653kg)	2376-lb (1078kg)	1600-lb. (726 kg)
1/16	(1.6)	S225719-079	S225719-083	S225719-082	S225719-053	_
0.072	(1.8)	—	S225724-083	S225724-082	S225724-053	S225724-V14
5/64	(2.0)	—	_	S225725-082	S225725-053	—

CONFORMANCES AND APPROVALS:

- AWS A5.20, E71T-8J H8
- AWS A5.20M, E491T-8J H8
- ASME SFA 5.20, E71T-8J H8
- ABS, 3YSA H10
- CWB, E491T8-A4-CS3-H8 (E491T-8J-H8)
- DNV-GL, II Y40 MS(H10) (1/16"-5/64")
- EN ISO 17632-A: T42 2 Y NO 2 H10
- CE Marked per CPR 305/2011
- AWS D1.8/D1.8M, 1/16" (1.6 mm) 5/64" (2.0 mm) diameter electrodes

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 <u>Applications.Engineering@hobartbrothers.com</u>

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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