



Flux-Cored Wires

FOR THE
WORKSHOP
OR ON-SITE



Trusted by the best





Flux-Cored Wires

When a Quality Result Matters, Hobart Delivers!



Hobart flux-cored wires offer high quality, repeatable performance for every job. The Hobart range includes high performance wires for both the workshop and on-site environments.

Every product meets the stringent ISO 9001 certification standards for quality and consistency, as well as the strict mechanical property requirements of AS/NZ and AWS standards.



Trusted by the best

**WIA IS A PART OF THE GLOBAL ITW
WELDING GROUP, A GLOBAL LEADER IN THE
DEVELOPMENT OF WELDING TECHNOLOGY
& DELIVERY OF CUSTOMER SOLUTIONS.**

Our brands are selected by welding professionals and companies who demand the most cost-effective welding outcomes, innovative and reliable products and superior technical knowledge and support. This is why we are trusted by the best.





The Hobart Advantage

GET MORE WITH HOBART.



Hobart Benefits

1. FORMULATED TO OFFER QUALITY RESULTS

Every Hobart wire has been carefully formulated to offer the highest quality results for both on-site and workshop applications.

2. REDUCED COSTS & INCREASED PRODUCTIVITY

We work collaboratively with customers to develop and deliver successful and innovative solutions that contribute to reduced costs and increased productivity.

3. LEADING MANUFACTURER

Hobart have been manufacturing flux-cored wires for over 90 years, giving them the experience to develop products that deliver.

4. QUALITY ASSURED

To ensure product quality and reliability, every Hobart product is tested and certified, and complies with the stringent ISO 9001 certification standards, and the strict mechanical requirements of AS/NZ and AWS guidelines.

5. USED BY THE BEST

Like all WIA brands, Hobart products are preferred and relied on by welding professionals and companies who demand the most cost effective and high performing solutions.

6. GLOBAL PARTNERSHIPS

Hobart offers an impressive track record of success, recognised right across the globe on major projects and various industry sectors.



The Workshop

**FLUX-CORED WIRES DESIGNED
FOR WORKSHOP APPLICATIONS.**

FabCO Excel-Arc 71

A RUTILE FLUX-CORED WIRE WITH GOOD IMPACT TOUGHNESS, FAST FREEZING SLAG, LOW FUMES & SPATTER.

CLASSIFICATIONS

- > AWS A5.20: E71T-1C H8 > E71T-1M H8
- > E71T-9C H8 > E71T-9M H8
- > EN17632-B-T493T1/9-1 A C/M UH10

TYPICAL APPLICATIONS

Suitable for structural fabrication, heavy equipment, general fabrication and non-alloyed and fine grain steels.

BENEFITS

- > Excellent out of position capability
- > Resists cracking in severe applications

IDEAL FOR SINGLE & MULTI-PASS APPLICATIONS

The FabCO Excel-Arc 71 provides easy slag removal, good impact toughness, fast freezing slag, low fumes and spatter.

The FabCO Excel-Arc 71 is also able to bridge poor fit-up without burn-through.

PRODUCTIVITY GAIN

- > Reduces part re-work / rejection
- > Reduces clean up time
- > Minimises risk of inclusions
- > Increases welder appeal

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

SHIELDING GAS	C	Mn	Si	S	P
100% CO ₂	0.021	1.30	0.69	0.011	0.015
75% Ar/ 25% CO ₂	0.022	1.60	0.82	0.010	0.014

TYPICAL DIFFUSIBLE HYDROGEN

Hydrogen Equipment	100% CO ₂	75% Ar/25% CO ₂
Gas Chromatography	3.8ml/100g	4.8ml/100g

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	100% CO ₂	75% Ar/25% CO ₂
Yield Stress	531 MPa	571 MPa
Tensile Strength	579 MPa	619 MPa
Elongation	28%	26%
CVN Impact Values	137J @ -20°C 108J @ -30°C	123@ -20°C 94@ -30°C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	15kg Spool	S247112-029
1.6	15kg Spool	S247119-029
2.0	15kg Spool	S247125-029

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.2, 1.6 & 2.0	1,080



FabCO XL-525

A RUTILE FLUX-CORED ALL POSITION WIRE FOR WELDING MILD & CARBON STEELS, ESPECIALLY WHEN GOOD IMPACT TOUGHNESS IS REQUIRED AT SUB ZERO TEMPERATURES.

CLASSIFICATIONS

- > AS/NZS ISO 17632-B - T494T1-1MA-U H5
- > AS/NZS ISO 17632-B - T494T12-1MA-U H5
- > AWS A5.20: E71T-1M, E71T-12MJ H8

TYPICAL APPLICATIONS

Suitable for ship building, earth moving equipment, off-shore structures, storage vessels and pipe welding.

IDEAL FOR SINGLE & MULTI-PASS APPLICATIONS

It delivers outstanding welding performance and produces high quality X-ray clear weld deposit with a bead contour that is flat to slightly convex.

It performs exceptionally well over rust, mill scale and some primers with no pre-cleaning of the steel necessary.

HIGH OPERATOR APPEAL

FabCO XL-525 has outstanding mechanical properties that resemble those of E7018 MMAW (SMAW) electrodes, plus high operator appeal with low fume levels, low spatter and easy slag removal.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

SHIELDING GAS	C	Mn	Si	P	S	Ni
80% Ar/20% CO ₂	0.04	1.01	0.30	0.007	0.004	0.34
75% Ar/25% CO ₂	0.04	1.01	0.27	0.010	0.006	0.32

TYPICAL DIFFUSIBLE HYDROGEN

Hydrogen Equipment	80% Ar/20% CO ₂	75% Ar/25% CO ₂
Gas Chromatography	3.6ml/100g	3.0ml/100g

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	80% Ar/20% CO ₂	75% Ar/25% CO ₂
Yield Stress	558 MPa	552 MPa
Tensile Strength	517 MPa	503 MPa
Elongation	28%	29%
CVN Impact Values	163J @ -20°C	136J @ -20°C
	102J @ -40°C	115J @ -30°C
		95J @ -40°C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	15kg Spool	S283212-029
1.6	15kg Spool	S283219-029

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.2 & 1.6	1,080



FabCO 811N1

A 1% Ni RUTILE FLUX CORED ALL POSITIONAL WIRE FOR WELDING HSLA & Q&T STEELS.

CLASSIFICATIONS

- > AS/NZS ISO 17632-B - T554T1-1C/MA-N2-UH5
- > AWS A5.29: E81T1-Ni1CJ H4, E81T1-Ni1MJ H4

TYPICAL APPLICATIONS

Suitable for high strength low-alloy steels, structural fabrication, heavy equipment fabrication, bridge fabrication, ship building and weathering steels.

DESIGNED FOR FABRICATION

Designed for mining and earthmoving equipment and other fabrication where low temperature impact values are needed.

SUPERIOR WELDER APPEAL

The improved slag system of this wire provides the superior welder appeal of acid slag (-T1) products and the mechanical properties normally associated with basic slag wires.

FOR DEMANDING APPLICATIONS

Weld metal diffusible hydrogen levels are kept low, making this an excellent choice for more demanding applications.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

SHIELDING GAS	C	Mn	P	S	Si	Ni
100% CO ₂	0.03	1.09	0.007	0.005	0.32	1.01
75% Ar/25% CO ₂	0.06	1.39	0.009	0.008	0.53	1.00

TYPICAL DIFFUSIBLE HYDROGEN

Hydrogen Equipment	100% CO ₂	75% Ar/25% CO ₂
Gas Chromatography	2.4ml/100g	3.0ml/100g

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	100% CO ₂	75% Ar/25% CO ₂
Tensile Stress	572 MPa	641 MPa
Yield Strength	503 MPa	586 MPa
Elongation	27%	23%
CVN Impact Values	88J @ -40°C	54J @ -40°C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	15kg Spool	S283612-053
1.6	15kg Spool	S283619-053

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.2 & 1.6	1,080



FabCO 803

A RUTILE FLUX-CORED ALL POSITIONAL WIRE FOR WELDING HSLA & Q&T STEELS.

CLASSIFICATIONS

- > AS/NZS ISO 17632-B - T555T1-1C/MA-N5-UH5
- > AWS A5.29: E81T1-Ni2C/MJ H4

TYPICAL APPLICATIONS

Suitable for ship building, earth moving equipment, off-shore structures, storage vessels and pipe welding.

EXCELLENT ARC STABILITY & LOW SPATTER

Offers excellent arc stability and low spatter using either CO₂ or Ar/CO₂ mixtures with up to 80% Argon.

MULTIPLE PASS WELDING

Low diffusible hydrogen levels and good impact values makes the wire a good choice for single and multiple pass welding in all positions.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

SHIELDING GAS	C	Mn	Si	P	S	Ni
100% CO ₂	0.04	1.00	0.29	0.010	0.012	1.84
75% Ar/25% CO ₂	0.05	1.25	0.40	0.010	0.010	2.00

TYPICAL DIFFUSIBLE HYDROGEN

Hydrogen Equipment	100% CO ₂	75% Ar/25% CO ₂
Gas Chromatography	2.6ml/100g	2.7ml/100g

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	100% CO ₂	75% Ar/25% CO ₂
Yield Stress	535 MPa	598 MPa
Tensile Strength	609 MPa	660 MPa
Elongation	27.5%	24%
CVN Impact Values	98J @ -40°C 92J @ -51°C	74J @ -40°C 60J @ -51°C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	15kg Spool	S283712-029
1.6	15kg Spool	S283719-029

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.2 & 1.6	1,080



Megafil® 713R

A SEAMLESS FLUX-CORED WIRE WITH EXCELLENT OUT OF POSITION PERFORMANCE.

CLASSIFICATIONS

- > AS/NZS ISO: 17632-B - T494T12-1M/C A-U H5
- > AWS A5.20: E71T-1MJ H4, E71T-1C H4

TYPICAL APPLICATIONS

Suitable for single or multi-pass welding, non alloyed and fine grain steel, heavy equipment, pressure vessels, equipment repairs and modifications, offshore, general fabrication, pipelines and structural fabrication.

PRODUCTIVITY GAIN

- > Very low moisture re-absorption after extended exposure
- > Minimises risk of hydrogen-induced cracking
- > Excellent out-of-position performance
- > Assists producing welds of consistent appearance and quality
- > Reduces clean-up time, minimizes risk of inclusions
- > Minimises risk of cracking in critical applications

SEAMLESS FLUX-CORED WIRE

The Megafil 713R has a low hydrogen weld deposit, fast-freezing slag, smooth arc characteristics, easy slag removal and good impact toughness, especially when used with an Argon-CO₂ shielding gas mixture.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

SHIELD. GAS	C	Mn	Si	P	S	Ni	Cu
100% CO ₂	0.02	0.90	0.29	0.012	0.011	0.31	0.14
80% Ar/ 20% CO ₂	0.02	1.18	0.46	0.012	0.011	0.30	0.14

TYPICAL DIFFUSIBLE HYDROGEN

Hydrogen Equipment	100% CO ₂	80% Ar/20% CO ₂
Gas Chromatography	1.5ml/100g	1.6ml/100g

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

MECHANICAL TESTS	100% CO ₂	80% Ar/20% CO ₂
Tensile Strength	593 MPa	607 MPa
Yield Strength	545 MPa	558 MPa
Elongation	26%	26%
CVN Impact Values	34J @ -30°C	89J @ -30°C 81 @ -40°C 77J @ -46°C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	16kg Spool	71315
1.6	16kg Spool	71333

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.2	1024
1.6	1024





FabCOR 86R

A METAL CORED WIRE WITH HIGHER DEOXIDIZATION ELEMENTS.

CLASSIFICATIONS

- > AS/NZS ISO 17632-B - T494T15-OMA-UH5
- > AWS A5.18: E70C-6M H4

TYPICAL APPLICATIONS

Suitable for automatic and mechanised welding, storage vessels, non-alloyed and fine grain steels, steel structures, earth moving equipment, general fabrication, ship building, rail cars.

METAL CORED WIRE

A metal cored wire with higher deoxidization elements allow this wire to have greater tolerance for mill scale welding applications. Single and multiple pass applications.

HIGH DEPOSITION RATES & EFFICIENCIES

- > Virtually no slag coverage
- > Outstanding high-production performance
- > Smooth arc characteristics
- > Low diffusible hydrogen weld deposit
- > Low smoke and spatter levels
- > Excellent for both CV and pulsed welding

PRODUCTIVITY GAIN

- > Improves productivity compared to solid wire or flux-cored electrodes
- > Reduces clean-up time, improves productivity
- > Excellent for robotic welding
- > Improved operator appeal, assists in maintaining consistent weld quality
- > Minimises risk of hydrogen-induced cracking
- > Improves operator appeal and productivity
- > Promotes versatility in procedure development

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

SHIELDING GAS	C	Mn	Si	S	P
95% Ar / 5% O ₂	0.04	1.48	0.64	0.010	0.008
95% Ar / 5% CO ₂	0.03	1.68	1.78	0.009	0.002
75% Ar / 25% CO ₂	0.03	1.44	0.67	0.015	0.008

TYPICAL DIFFUSABLE HYDROGEN

Hydrogen Equipment	95% Ar / 5% O ₂	95% Ar / 5% CO ₂	75% Ar / 25% CO ₂
Gas Chromatography	3.3ml / 100g	2.7ml / 100g	2.0ml / 100g

MECHANICAL TESTS	95% Ar / 5% O ₂	95% Ar / 5% CO ₂	75% Ar / 25% CO ₂
Tensile Strength	524 MPa	586 MPa	558 MPa
Yield Strength	421 MPa	517 MPa	476 MPa
Elongation	29%	27%	30%
CVN Impact Values	161J @ -30°C 57J @ -40°C	68J @ -30°C 43J @ -40°C	101J @ -30°C 54J @ -40°C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	15kg Spool	S249412-029
1.2	227kg X-pak	S249412-050
1.6	15kg Spool	S249419-029

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.2 & 1.6 (15kg)	1080
1.2 (227kg)	908

FabCOR Edge Ni1

METAL CORED WIRE WITH HIGHER DEPOSITION RATES & TRAVEL SPEEDS THAN SOLID WIRE.

CLASSIFICATIONS

- > AS/NZS ISO 17632-B - T554T15-OMA-N1-UH5
- > AWS A5.28: E80C-Ni1 H4

TYPICAL APPLICATIONS

Suitable for high strength low-alloy steels, single or multi-pass welding, structural fabrications, nickel-molybdenum steels, heavy equipment and weathering steels.

LOW ALLOY METAL CORED WIRE

- > Virtually no silicon deposits at weld bead toe lines
- > Excellent gap bridging capabilities
- > Higher deposition rates and travel speeds than solid wire
- > Good impact toughness at low temperature

PRODUCTIVITY GAIN

- > Reduces clean-up time, minimises risk of inclusions
- > Minimises burn-through, reduces part rejection
- > Increases productivity, more parts per hour
- > Resists cracking in severe applications

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

SHIELD. GAS	C	Mn	Si	S	P	Ni
95% Ar/5% CO ₂	0.04	1.24	0.65	0.009	0.008	1.01
75% Ar/25% CO ₂	0.05	1.10	0.57	0.011	0.013	1.0

TYPICAL DIFFUSIBLE HYDROGEN

Hydrogen Equipment	95% Ar/5% O ₂	75% Ar/25% CO ₂
Gas Chromatography	3.4ml/100g	2.1 ml/100g

MECHANICAL TESTS

	95% Ar/5% O ₂	75% Ar/25% CO ₂
Tensile Strength	634 MPa	586 MPa
Yield Strength	554 MPa	503 MPa
Elongation	26%	25%
CVN Impact Values	56J @ -45°C	60J @ -45°C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO
1.2	15kg Spool	S279512-029
1.6	15kg Spool	S279519-029

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.2 & 1.6	1080





FabCOR 1100

A METAL CORED WIRE WITH A HIGH TENSILE STRENGTH & HIGH DEPOSITION RATES.

CLASSIFICATIONS

- > AWS A5.28: E110C-K4
- > AS/NZS 18276 B-T765T15-0MA-N4C1M2-U H5

TYPICAL APPLICATIONS

Suitable for heavy equipment, ship building, quench and temper steels, high strength low alloy steels, and castings.

IDEAL FOR SINGLE OR MULTI-PASS APPLICATIONS

The FabCOR 1100 is a high tensile strength wire that delivers excellent wetting characteristics, high deposition rates and has an all position capability when using pulsed spray transfer.

Can be used with standard CV equipment.

BENEFITS

- > Assists in producing smooth weld beads and uniform fusion
- > Promotes versatility
- > Reduces equipment costs

PRODUCTIVITY GAIN

- > Minimises heat affected zone (HAZ)
- > Reduces clean up time

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

SHIELD. GAS	C	Mn	Si	S	P	Ni	Cr	Mo
90% Ar/10% CO ₂	0.08	1.50	0.50	0.005	0.003	1.84	0.24	0.46
75% Ar/25% CO ₂	0.07	1.52	0.52	0.007	0.004	1.92	0.18	0.47

TYPICAL DIFFUSIBLE HYDROGEN

Hydrogen Equipment	90% Ar/10% CO ₂	75% Ar/25% CO ₂
Gas Chromatography	1.6ml/100g	1.5ml/100g

MECHANICAL TESTS

	90% Ar/10%CO ₂	75% Ar/25% CO ₂
Tensile Strength	883 MPa	810 MPa
Yield Strength	800 MPa	725 MPa
Elongation	17%	19%
CVN Impact Values	38J @ -50 °C	58J @ -50 °C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	15kg Spool	S280212-029
1.6	15kg Spool	S280219-029

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.2 & 1.6	1080

Vertiwear 600

GAS-SHIELDED, ALL POSITION, HARD SURFACING FLUX-CORED WIRE.

CLASSIFICATIONS

- > AS 2576: 1855-B5*
- * Nearest Classification

TYPICAL APPLICATIONS

Suitable for dragline chains, dozer blades, ripper teeth, facing of agricultural points and equipment, and sliding metal parts and kiln trunnions.

HARD SURFACING FLUX-CORED WIRE

Gas shielded, all position, hard surfacing flux-cored wire depositing a multi-purpose martensitic steel alloy.

EXCELLENT OPERATOR APPEAL

Exhibits excellent compressive strength and metal to metal wear resistance. Excellent operator appeal in all positions.

MEDIUM TO HIGH IMPACT

Can be used to hard surface mild and low alloy steel components subject to moderate abrasion coupled with medium to high impact.

RECOMMENDED SHIELDING GAS IS 75% ARGON - 25% CO₂

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe
0.40	0.75	0.60	6.50	1.00	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

HARDNESS	NUMBER OF LAYERS	AS DEPOSITED	
		1020 STEEL	
55 HRc	1	52 HRc	
	2	56 HRc	
	3 - 8	57 HRc	
HARDNESS AS DEPOSITED	TIME AT TEMP	HARDNESS AFTER TEMPING	
		535°C	620°C
55 HRc	10 Hours	54 HRc	46 HRc
	20 Hours	49 HRc	40 HRc
	80 Hours	47 HRc	40 HRc

Abrasion Resistance:	Good
Impact Resistance:	Good
Machinability:	Good
Flame Cutting:	Difficult
Magnetic	

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	11.3kg Spool	S607112-029



The background of the advertisement is a composite image. The top half shows a Miller welding mask with the Miller logo on the side, resting on a surface. The bottom half shows a close-up of a weld being performed on a large pipe, with bright sparks and a glowing orange light from the welding process. The overall color palette is dominated by dark greys, oranges, and browns.

On-site

**FLUX-CORED WIRES DESIGNED
FOR ON-SITE APPLICATIONS.**

Fabshield XLR-8

LOW HYDROGEN T-8 SELF-SHIELDED, ALL POSITIONAL FLUX-CORED WIRE.

CLASSIFICATIONS

- > AS/NZS ISO 17632-B - T494T8-1NA-H10
- > AWS A5.20: E71T-8JD H8

TYPICAL APPLICATIONS

Suitable for heavy equipment repair, mining equipment, bucket repairs, storage tanks, pipe spooling, ship construction and site work.

SUITED FOR VERTICAL-UP WELDS

Produces a stable arc and flat bead profile, especially suited for vertical-up welds at high currents with excellent mechanical properties and a tensile strength of 490 MPa.

X-RAY QUALITY WELDS

Capable of depositing X-ray quality welds, making it highly suitable for critical welding applications requiring a high degree of crack resistance due to its low diffusible hydrogen levels, less than 6.7ml per 100g of weld metal deposited.

SINGLE & MULTI-PASS WELDING

XLR-8 has been designed for single and multi-pass welding applications with improved productivity in out-of-position welding, offering high impact strength of (42J) at sub zero temperatures to -40°C.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	P	S	Al	Fe
0.19	0.51	0.17	0.009	0.006	0.51	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	469 MPa
Tensile Strength	579 MPa
Elongation	28%
CVN Impact Values	42J @ -40°C, 54J @ -30°C, 68J @ -20°C

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.6	15kg VCI Spool	S225719-053
1.8	15kg VCI Spool	S225724-053
2.0	15kg VCI Spool	S225725-053
2.0	22.7kg Coil	S225725-014

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
1.6, 1.8 & 2.0 (15kg)	1,080
2.0 (22.7kg)	726.4



Fabshield 21B

AN ALL POSITIONAL GENERAL PURPOSE, SELF-SHIELDING, FLUX-CORED WIRE.

CLASSIFICATIONS

- > AS/NZS ISO 17632-B - T49ZT11-1NA-H15
- > AWS A5.20: E71T-11

TYPICAL APPLICATIONS

Suitable for fences, frames and sheds, prefabricated steel frame construction, galvanised tank fabrication, repair of trucks, tractors and earth moving equipment.

SINGLE & MULTI-PASS WELDING

Designed specifically for single and multi-pass welding of mild steel and galvanised steel up to a maximum of 20mm in thickness.

ALL POSITIONAL CAPABILITY

SAVE ON GAS BOTTLE RENTAL

EASY TO REMOVE SLAG, MAKING CLEAN-UP QUICK & EASY

IDEAL FOR OUTDOOR, ON-SITE CONDITIONS

EXCELLENT WELD APPEARANCE

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	S	P	Al	Fe
0.28	0.34	0.15	0.008	0.003	1.72	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	427 MPa
Tensile Strength	627 MPa
Elongation	22%
CVN Impact Values	Not Required

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
0.8	4.5kg Spool	S222106-022
0.9	4.5kg Spool	S222108-022
0.9	15kg Spool	S222108-029
1.2	4.5kg Spool	S222112-022
1.2	15kg Spool	S222112-029
1.6	15kg Spool	S222119-029
2.0	15kg Spool	S222125-029

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
0.8, 0.9 & 1.2 (4.5kg)	864
0.9, 1.2, 1.6 & 2.0 (15kg)	1,080

SHIPPING QUANTITY (KG)

0.8, 0.9 (4.5kg) - 27 (6 spools)
1.2 (4.5kg) - 18 (4 spools)



Fabshield 4

VERY HIGH DEPOSITION RATE, FOR DOWN HAND SINGLE OR MULTI-PASS.

CLASSIFICATIONS

- > AS/NZS ISO 17632-B - T49ZT4-0NA-H15
- > AWS A5.20: E70T-4

TYPICAL APPLICATIONS

Suitable for on-site field construction including repair of structural members and machinery.

SELF-SHIELDING FLUX-CORED WIRE

Specifically designed to desulphurise the weld deposit to reduce risk of weld cracking.

BENEFITS

- > Low Spatter Levels
- > Excellent Bead Appearance
- > Crack Resistant Weld Deposits

VERY HIGH DEPOSITION RATE

The Fabshield 4 self-shielding flux cored wire has a very high deposition rate for down hand single or multi-pass welding applications.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	P	S	Al	Fe
0.27	0.73	0.30	0.011	0.005	1.42	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	432 MPa
Tensile Strength	652 MPa
Elongation	25%
CVN Impact Values	Not Required

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
2.0	15kg Spool	S224525-029
2.4	22.7kg Coil	S224529-014
3.0	22.7kg Coil	S224541-014

FULL PALLET QUANTITY

WIRE SIZE (MM)	WEIGHT (KG)
2.0	1080
2.4 & 3.0	726.4



Roller Arc

A SELF-SHIELDED HARD SURFACING FLUX-CORED WIRE FOR SUPERIOR WIRE FEEDING.

CLASSIFICATIONS

- > AS/NZS 2576: 2145-B7
- > WIA TECH NOTE 4 2145-B7

UNIQUE SEAMLESS TUBE CONSTRUCTION

Allows the wire to be copper coated for enhanced wire feeding and improved current transfer from gun contact tip to wire. This feature of Roller Arc is particularly important for difficult out-of-position applications where long gun cables and awkward gun angles are often unavoidable.

Roller Arc is also suitable for conventional open arc hard surfacing applications where resistance to both heavy abrasion and high impact are required. Such applications include the surfacing of crushing and earth moving equipment.

TYPICAL APPLICATIONS

The Roller Arc is a trademark protected copper coated flux cored wire primarily suited for the “open arc” surfacing of cast iron sugar mill rolls. Often used “in situ” during cane crushing, the chromium carbide/austenitic iron deposit of Roller Arc gives mill roll teeth an enhanced gripping action and superior resistance to abrasive wear.

BENEFITS

- > Tough, wear resistant, high chromium austenitic iron deposit
- > Unique seamless construction for superior wire feeding
- > Copper coated for improved current transfer

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Cr	Si	Ni	Fe
2.05	1.37	13.2	0.90	0.002	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

HARDNESS	NUMBER OF LAYERS	AS-DEPOSITED ON
	1	40 - 50 HRc
Abrasion Resistance		Excellent
Impact Resistance		Good
Non Machinable		Grinding Only
Flame Cutting		Difficult
Deposit will Relief Check Crack		

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
2.8	25kg Coil	RA28C-1



Tube-Alloy 240-0

CHROMIUM CARBIDE SURFACING ALLOY SELF-SHIELDED HARD SURFACING WIRE.

CLASSIFICATIONS

> AS/NZS 2576: 2155-B7

TOUGHER THAN CONVENTIONAL CHROMIUM CARBIDE

Can be used on components subject to severe abrasive wear and heavy impact.

TYPICAL APPLICATIONS

Suitable for ammonia knives, hammer mill hammers, augers, impactor crusher bars, bucket teeth and lips, manganese pump shells, bulldozer end bits and blades, mill guides, conveyer screws, muller tires, crusher jaws and cones, pipeline ball joints, crusher rolls, pulverizer hammers, cultivator chisels and sweeps, scraper blades, dragline buckets, screw conveyors, dredge pump impellers and side plates, sheepsfoot tampers and sizing screens.



TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Cr	Si	Fe
3.20	1.80	15.50	1.90	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

HARDNESS	NUMBER OF LAYERS	AS DEPOSITED	
		1020 STEEL	Mn STEEL
	1	40 HRc	35 HRc
	2	48 HRc	42 HRc
	3-5	52 HRc	50 HRc

Abrasion Resistance	Very Good
Impact Resistance	Fair
Non Machinable	Grinding is Difficult
Cannot be Flame Cut	
Deposit will Relief Check Crack	
Thickness Should be Limited to Five Layers Maximum	

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	11.3kg Spool	S604012-029

Tube-Alloy 258-0

SELF-SHIELDED, ALL POSITION, HARD SURFACING FLUX-CORED WIRE.

CLASSIFICATIONS

> AS/NZS 2576: 1550-B7*
*Nearest Classification

TYPICAL APPLICATIONS

Suitable for machine components, tools and sliding metal to metal parts, dragline chains, kiln trunnions, mill guides, spindles and wobbler ends.

DESIGNED FOR SURFACING MILD & LOW ALLOY STEEL COMPONENTS

Designed for surfacing mild and low alloy steel components subject to moderate abrasive wear and impact under high compressive stresses and/or at temperatures up to 530°C.

OPEN ARC TUBULAR WIRE

A fabricated type, open arc tubular flux-cored wire depositing a Cr-Mo-W Martensitic steel alloy.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Mo	W	Fe
0.45	1.40	0.80	6.00	1.50	1.50	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

HARDNESS	NUMBER OF LAYERS	AS DEPOSITED	
		1020 STEEL	Mn STEEL
	1	49 HRc	51 HRc
	2	53 HRc	54 HRc
	3 - 5	57 HRc	57 HRc

Abrasion Resistance	Good
Impact Resistance	Good
Non Machinable	Grinding Only
Flame Cutting	Difficult
Heat Treatable and Forgettable	
Maintains Hot Hardness up to 530°C	

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.2	11.3kg Spool	S605812-029



Tube-Alloy A43-0

SELF-SHIELDED WIRE DEPOSITING A HIGH CR/NB SURFACING ALLOY.

CLASSIFICATIONS

> AS/NZS 2576: 2460-B7

SELF-SHIELDING WIRE

Self-shielding wire depositing a high Cr/Nb surfacing alloy which resists severe high and low stress abrasion and low to moderate impact.

HIGH TEMPERATURE WEAR

The weld deposit will check crack readily and can be used where high temperature wear resistance is required.

TYPICAL APPLICATIONS

Suitable for augers, bucket lips and teeth, coal feeder screws, coal pulverizer rolls and tables, coke chutes, coke pusher shoes, conveyer screws, dredge cutter heads and teeth, dredge pump inlet nozzle and side plates, fan blades, grizzly bars and fingers, muller tires, paving agitator screws, pipeline ball joints, pug mill paddles, scraper blades, sheepsfoot tampers and sizing screws.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr	Nb	Fe
5.50	0.20	1.00	22.00	6.50	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

HARDNESS	NUMBER OF LAYERS	AS DEPOSITED	
		1020 STEEL	Mn STEEL
	1	56-60 HRc	45-50 HRc
	2-3	60-64 HRc	54-58 HRc

Abrasion Resistance: Excellent

Impact Resistance: Poor

Non Machinable: Grinding Only

Cannot be Flame Cut

Deposit will Relief Check Crack

Thickness 2-3 Layers Maximum

ORDERING INFORMATION

WIRE SIZE (MM)	PACKET SIZE AND TYPE	PART NO.
1.6	11.3kg Spool	S607719-029





How to Videos

Learn how to get the best out of your weld!

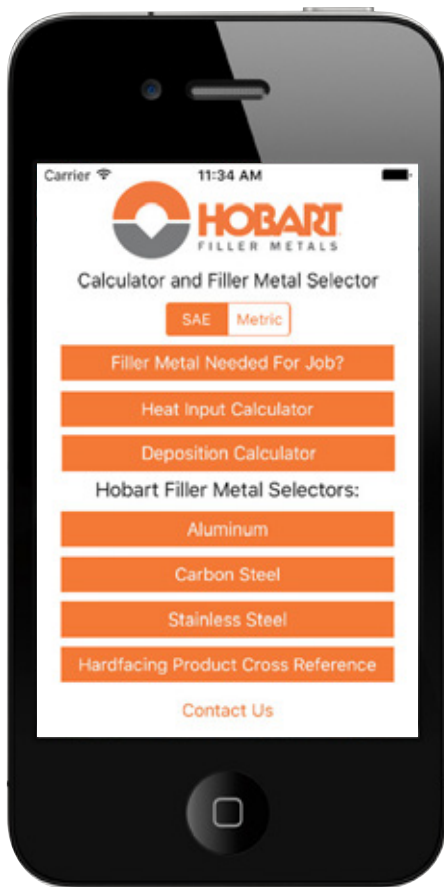
Our End Market Specialist team demonstrate how you can get the best out of flux-cored wire, by considering the correct welding techniques, settings, preparation and product selection.



HOW DO I USE FLUX-CORED SELF-SHIELDED WIRE?



HOW DO I MINIMISE SPATTER?



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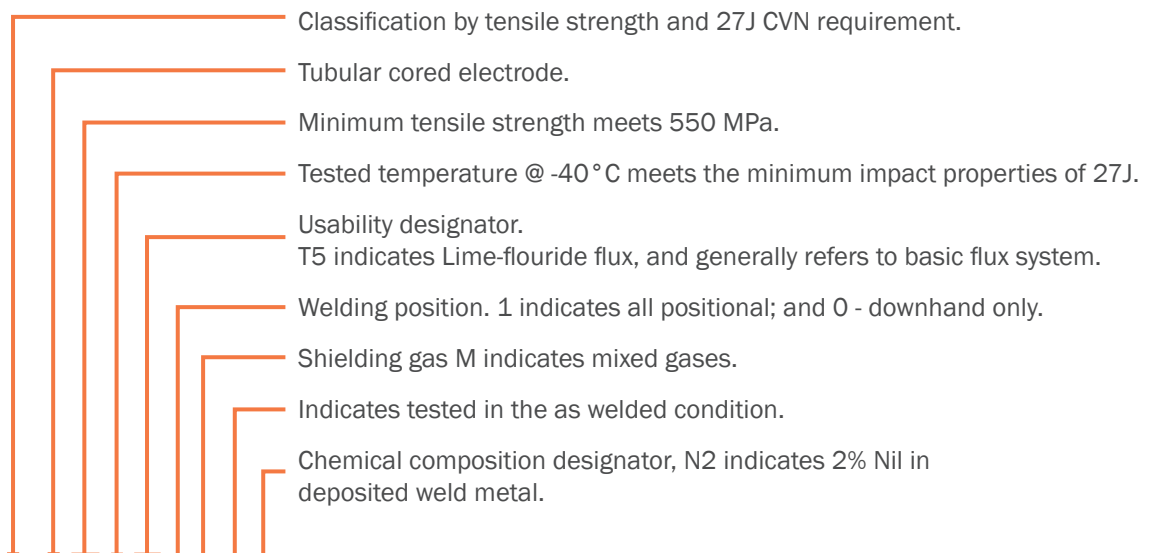
The New AS/NZS ISO 17632 Standard

A SERIES OF ADOPTED ISO STANDARDS TO COVER FLUX-CORED ARC WELDING (FCAW) ELECTRODES FOR NON-ALLOY & FINE GRAIN STEELS.

The following provides a brief introduction into the classification systems, and the standard series cover different electrode range.

- AS/NZS ISO 18276: High strength steels
- AS/NZS ISO 17634: Creep resisting steels
- AS/NZS ISO 17633: Stainless steels

COMPULSORY CLASSIFICATION DESIGNATORS



AS/NZS ISO 17632-B - T 55 4 T5-1 M A-N2-U H5

OPTIONAL SUPPLEMENTAL DESIGNATORS

- 47J impact energy at the normal 27J test temperature has also been met.
- Diffusible hydrogen. "H5,H10,H15" is used to indicate a maximum diffusible hydrogen content of "5, 10 and 15 ml/100g of deposited metal, respectively.



The American Welding Society Classification

THE ANSI/AWS A5.20 (PLAIN CARBON) AND A5.29 (LOW ALLOY) ELECTRODE SPECIFICATIONS HAVE SIMILAR CLASSIFICATION SYSTEMS.

They are shown in a combined form to acquaint the user with the information provided by the classification. For full details of all test requirements, radiographic standards, manufacturing tolerances, packaging, weld metal compositions etc., please consult the latest edition of the appropriate specification.

WELD METAL STRENGTH DIGITS

The strength digits '6' and '7' in A5.20 and '6', '7', '8', '9', '10', '11' and '12' in A5.29 represent 0.1 of the min. tensile strength in ksi, eg. '8'=80ksi (550MPa) '11'=110ksi (760MPa)

Each strength group has a min. yield strength, 12ksi (10ksi for '6' in A5.29) below the min. tensile strength and a min. elongation requirement.

WELD METAL COMPOSITION

Electrodes to A5.20 have a weld metal composition requirement that ensures they are plain carbon steels and do not employ an alloy suffix. Electrodes to A5.29 have specific compositions and employ the designations these include the A1, B2, B3, Ni1, Ni2, D1, D2, D3, K1 to K7 & W types.

TUBULAR

Flux-Cored Electrode

AWS A5.20 E X X T - X

ELECTRODE

AWS A5.29 E X X T X - X

POSITIONAL CAPABILITIES

"0" = Flat and Horizontal
"1" = All Positions

USABILITY AND PERFORMANCE

Note: A5.20 Classifications shown here are T-X, A5.29 as TX

IMPACT STRENGTH

The A5.20 classification EXXT-1, T-5, T-6 & T-8 have min. impact requirements shown in the usability table. In A5.29 the requirement for impact testing on as-welded or PWHT specimens and the test temperature for min. 20ft-lb (27J) is specified against a set of different classifications eg. E81T1-Ni2 AW-40 °F (40 °C) E80T5-Ni2 PWHT - 75 °F (-60 °C).

More Information:

For more information on Hobart's flux-cored wires, contact the WIA Customer Support Centre or visit our website.

1300 300 884
welding.com.au

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