

Fabshield XLR-8



SUMMARY

- > Welds Out of Position at High Currents
- > Low Hydrogen Weld Deposit
- > Excellent Slag Removal
- > No Shielding Gas Required
- > High Impact Strength at Low Temperatures
- > Excellent Mechanical Properties Under a Wide Range of Heat Input

CLASSIFICATION

- > AS/NZS ISO 17632-B - T492T8-1NA-U H10
- > AWS A5.20: E71T-8JD H8

DESCRIPTION AND APPLICATION

Low hydrogen T-8 self-shielded, all positional flux cored wire, producing 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. 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. 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. Specifically designed for increased productivity and high deposition rates on challenging structural steel erection, heavy equipment repair, mining equipment, bucket repairs, storage tanks, pipe spooling, ship construction and site work applications.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.6	180 - 275	18 - 23
1.8	170 - 315	18 - 23
2.0	200 - 340	18 - 24

Recommended electrical stick out is 25-35mm. Welding Current DC -

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

SHIPPING APPROVAL

ABS 3YSA; AWS D1.8 Conformance

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	68J @ -20°C 54J @ -30°C 42J @ -40°C

PACKAGING DATA

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

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