



PRODUCT DATA SHEET

WCD 6711

SELF SHIELDED FLUX CORED MIG WIRE

FABSHIELD 21B



- ▶ Self Shielded or "Gasless" Flux Cored Joining Wires
- ▶ All Positional Welding Capabilities
- ▶ Suitable For Single Pass / Multi-pass Applications
- ▶ Suitable for Mild / Galvanised Steels

Classifications

AS 2203.1 ETD-GNn-W500A. CM2 (superseded)
 AS/NZS ISO 17632 BT 49 Z T11 1 N A*
 AWS A5.20 E71T-11

*New classification replaces AS/NZS 2203.1

Description & Applications

Fabshield 21B is a general purpose self-shielded tubular wire that is designed for single and multi-pass welding of thin gauge to 20mm thick mild or galvanized steels. Great for welding fillet or lap welds, you will find that this all-position wire has high operator appeal, producing a smooth spray-like transfer with low spatter levels, excellent weld appearance and easy to remove slag.

Perfect for on-site applications such as the welding of machine parts, galvanized steels tanks, gates, frames, sheds, prefab construction, light structures, general fabrication etc.

Operational Data

Welding parameters shown below are for DC Electrode negative only.

WIRE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*	TYPICAL STICKOUT (mm)
1.2	130 - 160	15 - 17	12
1.6	150 - 250	19 - 20	19
2.0	200 - 300	19 - 23	19

Welding Current DC-

*Voltage is determined by arc current and wire arc length. Welding currents and voltage shown are operational guides only.

Typical All Weld Metal Chemical Analysis

C	Mn	Si	P	S	Al
0.28	0.34	0.15	0.008	0.003	1.04

Typical All Weld Metal Mechanical Properties

Yield Stress	427 Mpa
Tensile Strength	627 Mpa
Elongation	22%
CVN Impact Values	Not required

Packaging Data

WIRE SIZE (mm)	PACK SIZE (kg)	PART NUMBER
1.2	4.5	S222112-022
1.2	15	S222112-029
1.6	15	S222119-029
2.0	15	S222125-029

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

Wire should be stored in the plastic bag provided when not in use for extended periods. Recommended conditions of storage are minimum temperature of 15OC and a humidity of 60% RH.

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

Issue AA

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