



PRODUCT DATA SHEET

WCD 6713

SELF SHIELDED FLUX CORED MIG WIRE

FABSHIELD 4



- ▶ Self Shielded or "Gasless" Flux Cored Joining Wires
- ▶ For Fast Downhand Fillet and Butt Welding Applications
- ▶ Excellent Bead Appearance/Low Spatter Levels
- ▶ Crack Resistant Weld Deposits/Tolerant to Poor Joint Fit-up

Classifications

AS 2203.1 ETD-GNp-W500A. CM2H15 (superseded)
 AS/NZS ISO 17632 BT 49 2 T1 O N A H15*
 AWS A5.20 E70T-4

*New classification replaces AS/NSZ 2203.1

Description & Applications

FABSHIELD 4 is an outstanding, high deposition rate, self-shielded or "gasless" flux cored wire for downhand single or multi-pass welding applications. It is specifically designed to de-sulphurise the weld deposit and thereby resist cracking. Fabshield 4 is particularly suited to the fast fillet welding of mild and medium strength steels. Typical applications include the welding of structural members and machinery. Due to its self shielding arc, Fabshield 4 is ideal for "on site" field construction and repair applications.

Operational Data

Welding parameters shown below are for DC Electrode negative only, with a stickout length of 60mm for the 2.4mm wire.

WIRE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
2.4	250 - 500	28 - 34

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	Fe
0.25	0.73	0.30	0.011	0.005	1.42	Bal

Typical All Weld Metal Mechanical Properties

Yield Stress	432 Mpa
Tensile Strength	652 Mpa
Elongation	25%
CVN Impact Values	Not required

Packaging Data

PACK SIZE	PART NUMBER
22.7kg (50lb)	S224529-014

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.*

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

Issue AA

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