



# PRODUCT DATA SHEET

## WCD 7065

# SELF SHIELDED FLUX CORED MIG WIRE

## FABSHIELD XLR-8 H8



- ▶ Self Shielded or "Gasless" Flux Cored Joining Wire
- ▶ All Positional at High Currents (except vertical down)
- ▶ X-ray Quality Weld Deposits
- ▶ Hermetically Sealed Packaging
- ▶ Low Hydrogen H8 Weld Metal
- ▶ High Impact Strength at Sub-Zero Temperatures to -40°C
- ▶ Ideal T-8 Wire for Site Work Applications
- ▶ Excellent Slag Removal and Stable Arc Characteristics

### Classifications

AS/NZS ISO	17632 BT 49 4 T8 1 N A H10
AWS A5.20/5.20M	E71T-8J H8

### Description & Applications

Fabshield XLR-8 is the next generation low hydrogen T-8 self-shielded, all positional flux-cored wire, producing a stable arc and flat bead profile. It is especially suited for vertical-up welds at high currents with excellent mechanical properties and a tensile strength of 490Mpa. 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 -40oC.

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 (amps)	ARC VOLTAGE RANGE (volts)*	TYPICAL STICKOUT (mm)
1.6	140 - 300	18 - 23	25 - 30
1.8	150 - 350	18 - 23	25 - 30
2.0	145 - 350	18 - 23	25 - 30

Welding Current DC -

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

### Issue AB

The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Welding Industries of Australia expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with the AWS and or AS/NZS specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique by Welding Industries of Australia.

### Typical All Weld Metal Chemical Analysis

C	Mn	Si	P	S	Al
0.19	0.51	0.17	0.009	0.006	1.51

### Typical All Weld Metal Mechanical Properties

Yield Stress	470 Mpa
Tensile Strength	580 Mpa
Elongation	25%
CVN Impact Values	42J @ -40°C
Diffusible Hydrogen	6.7ml/100g of weld deposited

### Packaging Data

WIRE SIZE (mm)	PACK SIZE (kg)	PART NUMBER
1.6	15	S225719-053
1.8	15	S225724-053
2.0	15	S225725-053
2.0	22.7	S225725-014
Full Pallet	1080	

### 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 15°C and a humidity of 60% RH.

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

08/04/2009