



HOBART H800



- ▶ Neutral Agglomerated SAW Flux
- ▶ Suitable for use with AC or DC Applications
- ▶ Single and Multi-pass Applications
- ▶ Wire - EM12K / Flux - H800

Classifications

AS 1858.1 EM12K-FMM-W503A
 AWS A5.17 F7A2-EM12K

Description & Applications

Hobart H800 has excellent bead appearance and easy slag removal in deep groove applications with good AC and DC arc stability.

It produces good impact properties and minimum 500 Mpa tensile when used with Hobart M12K wire in the as welded condition. This flux is designed for multi-pass groove welds while still meeting the 500 Mpa tensile class using EM12K wire.

Typical applications include pressure vessels, pipe-mill applications, shipbuilding, etc.

Typical All Weld Metal Chemical Analysis

C	Mn	Si	P	S	Cu
0.09	1.09	0.27	0.0019	0.008	0.02

In as welded condition using Hobart M12K

Typical All Weld Metal Chemical Properties

Yield Strength	475
Tensile Strength	557 Mpa
Elongation	30 Mpa
CVN AVE; Joules	74 @ -29°C

Packaging Data

PACK SIZE	PART NUMBER
25kg bag	H9-08000000-255

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.*

To ensure the integrity of Hobart H800 over an extended period, flux should be stored in controlled dry conditions, preferably at a minimum of 15°C and a maximum humidity of 60% RH. Lengthy periods of exposure, uncovered in workshops should be avoided and normal precautions taken to prevent direct contamination by moisture, oil, grease and rust. When contamination by moisture is suspected, H800 can be restored to its original condition by rebaking. For most applications, the rebaking of H800 in shallow trays (less than 50mm deep) for one hour at 350°C will be sufficient to restore flux to low moisture levels.

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