Flux-Cored Wires
FOR THE WORKSHOP OR ON-SITE

More Information:
For more information on Hobart’s flux-cored wires, contact the WIA Customer Support Centre or visit our website.

1300 300 884  
welding.com.au

When a Quality Result Matters, Hobart Delivers!

Hobart flux-cored wires offer high quality, repeatable performance for every job. The Hobart range includes high performance wires for both the workshop and on-site environments. Every product meets the stringent ISO 9001 certification standards for quality and consistency, as well as the strict mechanical property requirements of AS/NZ and AWS standards.
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welding.com.au
Global Brands. Local Support.

WHERE WE STARTED
Established in 1962, WIA began as a small team of welding specialists, working to develop industry leading, innovative products. Today, we are a leading welding supplier because of our innovation and expertise.

OUR PRODUCTS
50 years of experience gives us the expertise to develop products that deliver! The Arclast 16TC electrode and Weldmatic Fabricator have been industry icons for decades.

OUR GLOBAL PARTNERSHIPS
WIA is part of the global organisation ITW (Illinois Tool Works), a diversified manufacturing company. Our global partnerships give us access to the world’s leading welding brands.

OUR INDUSTRY EXPERTISE
Both locally and globally our products are developed, delivered and supported by a team of industry experts who understand the needs of our customers.

OUR APPROACH
We work with our customers to develop the best products and deliver the best solutions. Our customers have trust in our products and company because of how we do things. That’s why we’re trusted by the best.

OUR BRANDS
Our brands include WIA electrodes, wires and equipment; Miller industrial welding equipment; Hobart filler metals and Bernard™ and Centerfire™ consumables.

USED BY THE BEST
Our brands are selected by welding professionals and companies who demand the most reliable products, in-depth knowledge and cost-effective solutions.

WE KNOW THE MARKET
We work hard to build our knowledge and understand what our market needs. Whether it’s heavy engineering, mining, oil and gas or pipelines we know the market.

50 YEARS

THE ANS//AWS A5.20 (PLAIN CARBON) AND A5.29 (LOW ALLOY) ELECTRODE SPECIFICATIONS HAVE SIMILAR CLASSIFICATION SYSTEMS.

They are shown in a combined form to acquaint the user with the information provided by the classification. For full details of all test requirements, radiographic standards, manufacturing tolerances, packaging, weld metal compositions etc., please consult the latest edition of the appropriate specification.

TUBULAR Flux-Cored Electrode
ELECTRODE
POSITIONAL CAPABILITIES
"0" = Flat and Horizontal "1" = All Positions
TUBULAR Flux-Cored Electrode

WELD METAL STRENGTH DIGITS

CLASSIFICATIONS

THE AMERICAN WELDING SOCIETY CLASSIFICATION

AWS A5.20
AWS A5.29

WELD METAL STRENGTH DIGITS

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Our brands are selected by welding professionals and companies who demand the most cost-effective welding outcomes, innovative and reliable products and superior technical knowledge and support. This is why we are trusted by the best.
The Hobart Advantage
GET MORE WITH HOBART.
Every Hobart wire has been carefully formulated to offer the highest quality results for both on-site and workshop applications.

We work collaboratively with customers to develop and deliver successful and innovative solutions that contribute to reduced costs and increased productivity.

Hobart have been manufacturing flux-cored wires for over 90 years, giving them the experience to develop products that deliver.

To ensure product quality and reliability, every Hobart product is tested and certified, and complies with the stringent ISO 9001 certification standards, and the strict mechanical requirements of AS/NZ and AWS guidelines.

Like all WIA brands, Hobart products are preferred and relied on by welding professionals and companies who demand the most cost effective and high performing solutions.

Hobart offers an impressive track record of success, recognised right across the globe on major projects and across industry sectors.

Hobart Benefits

1. FORMULATED TO OFFER QUALITY RESULTS
   Every Hobart wire has been carefully formulated to offer the highest quality results for both on-site and workshop applications.

2. REDUCED COSTS & INCREASED PRODUCTIVITY
   We work collaboratively with customers to develop and deliver successful and innovative solutions that contribute to reduced costs and increased productivity.

3. LEADING MANUFACTURER
   Hobart have been manufacturing flux-cored wires for over 90 years, giving them the experience to develop products that deliver.

4. QUALITY ASSURED
   To ensure product quality and reliability, every Hobart product is tested and certified, and complies with the stringent ISO 9001 certification standards, and the strict mechanical requirements of AS/NZ and AWS guidelines.

5. USED BY THE BEST
   Like all WIA brands, Hobart products are preferred and relied on by welding professionals and companies who demand the most cost effective and high performing solutions.

6. GLOBAL PARTNERSHIPS
   Hobart offers an impressive track record of success, recognised right across the globe on major projects and across industry sectors.
The Workshop

FLUX-CORED WIRES DESIGNED FOR WORKSHOP APPLICATIONS.
**FabCO XL-525**

**A RUTILE FLUX-CORED ALL POSITION WIRE FOR WELDING MILD & CARBON STEELS, ESPECIALLY WHEN GOOD IMPACT TOUGHNESS IS REQUIRED AT SUB ZERO TEMPERATURES.**

**CLASSIFICATIONS**
- AS/NZS ISO 17632-B - T494T1-1MA-U H5
- AS/NZS ISO 17632-B - T494T12-1MA-U H5
- AWS A5.20: E71T-1M, E71T-12MJ H8

**TYPICAL APPLICATIONS**
Can be used for ship building, earth moving equipment, off-shore structures, storage vessels and pipe welding.

**HIGH OPERATOR APPEAL**
FabCO XL-525 has outstanding mechanical properties that resemble those of E7018 MMAW (SMAW) electrodes, plus high operator appeal with low fume levels, low spatter and easy slag removal.

**ORDERING INFORMATION**

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>PACKET SIZE AND TYPE</th>
<th>PART NUMBER</th>
</tr>
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<tbody>
<tr>
<td>1.2</td>
<td>15kg Spool</td>
<td>S283212-029</td>
</tr>
<tr>
<td>1.6</td>
<td>15kg Spool</td>
<td>S283219-029</td>
</tr>
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**FULL PALLET QUANTITY**

<table>
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<tr>
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</thead>
<tbody>
<tr>
<td>1.2 &amp; 1.6</td>
<td>1,080</td>
</tr>
</tbody>
</table>

**TYPICAL ALL WELD METAL CHEMICAL ANALYSIS**

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Ni</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.04</td>
<td>1.24</td>
<td>0.29</td>
<td>0.37</td>
<td>Bal</td>
</tr>
</tbody>
</table>

**TYPICAL ALL WELD METAL MECHANICAL ANALYSIS**

- Gas Type: Ar+20% CO₂
- Yield Stress: 503 MPa
- Tensile Strength: 566 MPa
- Elongation: 29%
- CVN Impact Values: 90J @ -40°C
FabCO 811N1

A RUTILE FLUX-CORED ALL POSITION WIRE FOR WELDING HSLA & Q&T STEELS.

CLASSIFICATIONS
› AS/NZS ISO 17632-B - T554T1-1C/MA-N2-UH5
› AWS A5.29: E81T1-Ni1CJ H4, E81T1-Ni1MJ H4

TYPICAL DIFFUSIBLE HYDROGEN
Hydrogen Equipment
100% CO₂ 75% Ar/25% CO₂
Gas Chromatography
2.4ml/100g 3.0ml/100g

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS
Gas Type
100% CO₂ 75% Ar/25% CO₂
Tensile Stress
572 MPa 641 MPa
Yield Strength
503 MPa 586 MPa
Elongation
27% 23%
CVN Impact Values
88J @ -40ºC 54J @ -40ºC

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS
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<th>SHIELDING GAS</th>
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<th>Ni</th>
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<tbody>
<tr>
<td>100% CO₂</td>
<td>0.03</td>
<td>1.09</td>
<td>0.007</td>
<td>0.005</td>
<td>0.32</td>
<td>1.01</td>
</tr>
<tr>
<td>75% Ar/25% CO₂</td>
<td>0.06</td>
<td>1.39</td>
<td>0.009</td>
<td>0.008</td>
<td>0.53</td>
<td>1.00</td>
</tr>
</tbody>
</table>

TYPICAL DIFFUSIBLE HYDROGEN

- Hydrogen Equipment
  - 100% CO₂
  - 75% Ar/25% CO₂
- Gas Chromatography
  - 2.4ml/100g
  - 3.0ml/100g

superior welder appeal
The improved slag system of this wire provides the superior welder appeal of acid slag (T1) products and the mechanical properties normally associated with basic slag wires.

designed for fabrication
Designed for mining and earthmoving equipment and other fabrication where low temperature impact values are needed.

for demanding applications
Weld metal diffusible hydrogen levels are kept low, making this an excellent choice for the more demanding applications.

for demanding applications
Weld metal diffusible hydrogen levels are kept low, making this an excellent choice for the more demanding applications.

DESIGNED FOR FABRICATION
Designed for mining and earthmoving equipment and other fabrication where low temperature impact values are needed.

SUPERIOR WELDER APPEAL
The improved slag system of this wire provides the superior welder appeal of acid slag (T1) products and the mechanical properties normally associated with basic slag wires.

FOR DEMANDING APPLICATIONS
Weld metal diffusible hydrogen levels are kept low, making this an excellent choice for the more demanding applications.

TYPICAL APPLICATIONS
Uses include high strength low-alloy steels, structural fabrication, heavy equipment fabrication, bridge fabrication, ship building and weathering steels.

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<tr>
<td>1.2</td>
<td>15kg Vacuum Packed Spool</td>
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<tr>
<td>1.6</td>
<td>15kg Vacuum Packed Spool</td>
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FabCO 803

A RUTILE FLUX-CORED ALL POSITION WIRE FOR WELDING HSLA & Q&T STEELS.

CLASSIFICATIONS
› AS/NZS ISO 17632-B · T555T1.1C/MA-N5-UH5
› AWS A5.29: E81T1-Ni2C/MJ H4

TYPICAL APPLICATIONS
Can be used for ship building, earth moving equipment, off-shore structures, storage vessels and pipe welding.

EXCELLENT ARC STABILITY & LOW SPATTER
Offers excellent arc stability and low spatter using either CO₂ or Ar/CO₂ mixtures with up to 80% Argon.

MULTIPLE PASS WELDING
Low diffusible hydrogen levels and good impact values makes the wire a good choice for single and multiple pass welding in all positions.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

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<td>100% CO₂</td>
<td>0.04</td>
<td>1.00</td>
<td>0.29</td>
<td>0.010</td>
<td>0.012</td>
<td>1.84</td>
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<tr>
<td>75% Ar/25% CO₂</td>
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<td>1.25</td>
<td>0.40</td>
<td>0.010</td>
<td>0.010</td>
<td>2.00</td>
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<tr>
<th>Gas Type</th>
<th>Yield Stress</th>
<th>Tensile Strength</th>
<th>Elongation</th>
<th>CVN Impact Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>100% CO₂</td>
<td>535 MPa</td>
<td>609 MPa</td>
<td>27.5%</td>
<td>98J @ -40°C</td>
</tr>
<tr>
<td>75% Ar/25% CO₂</td>
<td>598 MPa</td>
<td>660 MPa</td>
<td>24%</td>
<td>92J @ -51°C</td>
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FabCOR Edge Ni1

METAL CORED WIRE WITH HIGHER DEPOSITION RATES & TRAVEL SPEEDS THAN SOLID WIRE.

**CLASSIFICATIONS**
- AS/NZS ISO 17632-B - T554T15-0MA-N1-UH5
- AWS A5.28: E80C-Ni1 H4

**LOW ALLOY METAL CORED WIRE**
- Virtually no silicon deposits at weld bead toe lines.
- Excellent gap bridging capabilities.
- Higher deposition rates and travel speeds than solid wire.
- Good impact toughness at low temperature.

**PRODUCTIVITY GAIN**
- Reduces clean-up time, minimises risk of inclusions.
- Minimises burn-through, reduces part rejection.
- Increases productivity, more parts per hour.
- Resists cracking in severe applications.

**TYPICAL APPLICATIONS**
Suitable for, high strength low-alloy steels, single or multi-pass welding, structural fabrications, nickel-molybdenum steels, heavy equipment and weathering steels.

**LOW ALLOY METAL CORED WIRE**

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<td>0.011</td>
<td>0.013</td>
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<td>Bal</td>
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**TYPICAL DIFFUSIBLE HYDROGEN***

**HYDROGEN EQUIPMENT** 75% Ar/25% CO₂
Gas Chromatography 2.1 ml/100g

**MECHANICAL TESTS** 75% Ar/25% CO₂
- Tensile Strength 586 MPa (85,000 psi)
- Yield Strength 503 MPa (73,000 psi)
- Elongation 25%
- CVN Impact Values 60 J @ -45°C

**CVN TEMPERATURES** 75% Ar/25% CO₂
-45°C 60 Joules

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FabCOR 86R

A METAL CORED WIRE WITH HIGHER DEOXIDIZATION ELEMENTS.

**CLASSIFICATIONS**
- AS/NZS ISO 17632-B - T494T15-OMA-UH5
- AWS A5.18: E70C-6M H4

**TYPICAL APPLICATIONS**
Automatic and mechanised welding, storage vessels, non-alloyed and fine grain steels, steel structures, earthmoving, equipment, general fabrication, shipbuilding, rail cars.

**MECHANICAL TESTS 75% Ar/25% CO₂**
- Tensile Strength: 558 MPa
- Yield Strength: 476 MPa
- Elongation: 30%
- CVN Impact Values:
  - 101J @ -30°C
  - 54J @ -40°C

**MECHANICAL TESTS -45°C**
- 60 Joules

**METAL CORED WIRE**
A metal cored wire with higher deoxidization elements allow this wire to have greater tolerance for mill scale welding applications. Single and multiple pass applications.

**HIGH DEPOSITION RATES AND EFFICIENCIES**
- Virtually no slag coverage.
- Outstanding high-production performance.
- Smooth arc characteristics.
- Low diffusible hydrogen weld deposit.
- Low smoke and spatter levels.
- Excellent for both CV and pulsed welding.

**PRODUCTIVITY GAIN**
- Improves productivity compared to solid wire or flux-cored electrodes.
- Reduces clean-up time, improves productivity.
- Excellent for robotic welding.
- Improved operator appeal, assists in maintaining consistent weld quality.
- Minimises risk of hydrogen-induced cracking.
- Improves operator appeal and productivity.
- Promotes versatility in procedure development.

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<td>1.2</td>
<td>227kg X-Pak</td>
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<td>HIGH DEPOSITION RATES AND EFFICIENCIES</td>
<td>Virtually no slag coverage. Outstanding high-production performance. Smooth arc characteristics. Low diffusible hydrogen weld deposit. Low smoke and spatter levels. Excellent for both CV and pulsed welding.</td>
</tr>
</tbody>
</table>
Vertiwear 600

GAS SHIELDED, ALL POSITION, HARD SURFACING FLUX-CORED WIRE.

CLASSIFICATIONS
› AS 2576: 1855-B5*
* Nearest Classification

HARDFACING GAS-SHIELDED FLUX-CORED WIRE
Gas shielded, all position, hard surfacing flux-cored wire depositing a multi-purpose martensitic steel alloy.

MEDIUM TO HIGH IMPACT
Can be used to hard surface mild and low alloy steel components subject to moderate abrasion coupled with medium to high impact.

EXCELLENT OPERATOR APPEAL
Exhibits excellent compressive strength and metal to metal wear resistance. Excellent operator appeal in all positions.

RECOMMENDED SHIELDING GAS IS 75% ARGON - 25% CO₂

TYPICAL APPLICATIONS
Uses include dragline chains, dozer blades, ripper teeth, facing of agricultural points and equipment, and sliding metal parts and kiln trunnions.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS
<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Cr</th>
<th>Mo</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.40</td>
<td>0.75</td>
<td>0.60</td>
<td>6.50</td>
<td>1.00</td>
<td>Bal</td>
</tr>
</tbody>
</table>

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

<table>
<thead>
<tr>
<th>HARDNESS</th>
<th>NUMBER OF LAYERS</th>
<th>AS DEPOSITED 1020 STEEL</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>52 HRC</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>56 HRC</td>
<td></td>
</tr>
<tr>
<td>3 - 8</td>
<td>57 HRC</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>HARDNESS AS DEPOSITED</th>
<th>TIME AT TEMP</th>
<th>HARDNESS AFTER TEMPING</th>
</tr>
</thead>
<tbody>
<tr>
<td>55 HRC</td>
<td>535°C</td>
<td>54 HRC 46 HRC</td>
</tr>
<tr>
<td></td>
<td>620°C</td>
<td>49 HRC 40 HRC</td>
</tr>
<tr>
<td></td>
<td>20 Hours</td>
<td>47 HRC 40 HRC</td>
</tr>
<tr>
<td></td>
<td>80 Hours</td>
<td></td>
</tr>
</tbody>
</table>

Abrasion Resistance: Good
Impact Resistance: Good
Machinability: Good
Flame Cutting: Difficult
Magnetic

ORDERING INFORMATION

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>PACKET SIZE AND TYPE</th>
<th>PART NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2</td>
<td>11.3kg Spool</td>
<td>S607112-029</td>
</tr>
</tbody>
</table>
On-site

FLUX-CORED WIRES DESIGNED FOR ON-SITE APPLICATIONS.
FLUX-CORED SELF-SHIELDED WIRE

Fabshield XLR-8
LOW HYDROGEN T-8 SELF-SHIELDED, ALL POSITIONAL FLUX-CORED WIRE.

CLASSIFICATIONS
▷ AS/NZS ISO 17632-B · T494T8-1NA-H10
▷ AWS A5.20: E71T-8JD H8

TYPICAL APPLICATIONS
Uses include heavy equipment repair, mining equipment, bucket repairs, storage tanks, pipe spooling, ship construction and site work.

SUITED FOR VERTICAL-UP WELDS
Produces 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.

X-RAY QUALITY WELDS
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.

SINGLE & MULTI-PASS WELDING
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.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

<table>
<thead>
<tr>
<th></th>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>P</th>
<th>S</th>
<th>Al</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>0.19</td>
<td>0.51</td>
<td>0.17</td>
<td>0.009</td>
<td>0.006</td>
<td>0.51</td>
<td>Bal</td>
</tr>
</tbody>
</table>

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

<table>
<thead>
<tr>
<th></th>
<th>Yield Stress</th>
<th>Tensile Strength</th>
<th>Elongation</th>
<th>CVN Impact Values</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>469 MPa</td>
<td>579 MPa</td>
<td>28%</td>
<td>42J @ -40°C, 54J@ -30°C, 68J @ -20°C</td>
</tr>
</tbody>
</table>

ORDERING INFORMATION

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>PACKET SIZE AND TYPE</th>
<th>PART NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.6</td>
<td>15kg Vacuum Packed Spool</td>
<td>S225719-053</td>
</tr>
<tr>
<td>1.8</td>
<td>15kg Vacuum Packed Spool</td>
<td>S225724-053</td>
</tr>
<tr>
<td>2.0</td>
<td>15kg Vacuum Packed Spool</td>
<td>S225725-053</td>
</tr>
<tr>
<td>2.0</td>
<td>22.7kg Coil</td>
<td>S225725-014</td>
</tr>
</tbody>
</table>

FULL PALLET QUANTITY

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>WEIGHT (KG)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.6, 1.8 &amp; 2.0 (15kg)</td>
<td>1,080</td>
</tr>
<tr>
<td>2.0 (22.7kg)</td>
<td>726.4</td>
</tr>
</tbody>
</table>
Fabshield 21B

AN ALL POSITIONAL GENERAL PURPOSE, SELF-SHIELDING, FLUX-CORED WIRE.

CLASSIFICATIONS
› AS/NZS ISO 17632-B - T49ZT11-1NA-H15
› AWS A5.20: E71T-11

SINGLE & MULTI-PASS WELDING
Designed specifically for single and multi-pass welding of mild steel and galvanised steel up to a maximum of 20mm in thickness.

ALL POSITIONAL CAPABILITY

SAVE ON GAS BOTTLE RENTAL

EASY TO REMOVE SLAG, MAKING CLEAN-UP QUICK & EASY

EXCELLENT WELD APPEARANCE

IDEAL FOR OUTDOOR, ON-SITE CONDITIONS

TYPICAL APPLICATIONS
Can be used for fences, frames and sheds, prefabricated steel frame construction, galvanised tank fabrication, repair of trucks, tractors and earth moving equipment.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>S</th>
<th>P</th>
<th>Al</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.28</td>
<td>0.34</td>
<td>0.15</td>
<td>0.008</td>
<td>0.003</td>
<td>1.72</td>
<td>Bal</td>
</tr>
</tbody>
</table>

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress 427 MPa
Tensile Strength 627 MPa
Elongation 22%
CVN Impact Values Not Required

ORDERING INFORMATION

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>PACKET SIZE AND TYPE</th>
<th>PART NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.8</td>
<td>4.5kg Spool</td>
<td>S222106-022</td>
</tr>
<tr>
<td>0.9</td>
<td>4.5kg Spool</td>
<td>S222108-022</td>
</tr>
<tr>
<td>0.9</td>
<td>15kg Spool</td>
<td>S222108-029</td>
</tr>
<tr>
<td>1.2</td>
<td>4.5kg Spool</td>
<td>S222112-022</td>
</tr>
<tr>
<td>1.2</td>
<td>15kg Spool</td>
<td>S222112-029</td>
</tr>
<tr>
<td>1.6</td>
<td>15kg Spool</td>
<td>S222119-029</td>
</tr>
<tr>
<td>2.0</td>
<td>15kg Spool</td>
<td>S222125-029</td>
</tr>
</tbody>
</table>

FULL PALLET QUANTITY

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>WEIGHT (KG)</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.8, 0.9 &amp; 1.2 (4.5kg)</td>
<td>864</td>
</tr>
<tr>
<td>0.9, 1.2, 1.6 &amp; 2.0 (15kg)</td>
<td>1,080</td>
</tr>
</tbody>
</table>

SHIPPING QUANTITY (KG)

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>QUANTITY</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.8 &amp; 0.9 (4.5kg)</td>
<td>27 (6 spools)</td>
</tr>
<tr>
<td>1.2 (4.5kg)</td>
<td>18 (4 spools)</td>
</tr>
</tbody>
</table>
Fabshield 4

VERY HIGH DEPOSITION RATE, FOR DOWN HAND SINGLE OR MULTI-PASS.

CLASSIFICATIONS
› AS/NZS ISO 17632-B · T49ZT4-0NA-H15  
› AWS A5.20: E70T-4

SELF-SHIELDING FLUX-CORED WIRE
Specifically designed to desulphurise the weld deposit to reduce risk of weld cracking.

TYPICAL APPLICATIONS
For on-site field construction including repair of structural members and machinery.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS
<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>P</th>
<th>S</th>
<th>Al</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.27</td>
<td>0.73</td>
<td>0.30</td>
<td>0.011</td>
<td>0.005</td>
<td>1.42</td>
<td>Bal</td>
</tr>
</tbody>
</table>

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS
- Yield Stress: 432 MPa
- Tensile Strength: 652 MPa
- Elongation: 25%
- CVN Impact Values: Not Required

ORDERING INFORMATION

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>PACKET SIZE AND TYPE</th>
<th>PART NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.4</td>
<td>22.7kg Coil</td>
<td>S224529-014</td>
</tr>
<tr>
<td>3.0</td>
<td>22.7kg Coil</td>
<td>S224541-014</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>WEIGHT (KG)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.4 &amp; 3.0</td>
<td>726.4</td>
</tr>
</tbody>
</table>
Tube-alloy 240-0
CHROMIUM CARBIDE SURFACING ALLOY SELF-SHIELDED HARD SURFACING WIRE.

CLASSIFICATIONS
› AS/NZS 2576: 2155-B7

TOUGHER THAN CONVENTIONAL CHROMIUM CARBIDE
Can be used on components subject to severe abrasive wear and heavy impact.

TYPICAL APPLICATIONS
Uses include ammonia knives, hammer mill hammers, augers, impactor crusher bars, bucket teeth and lips, manganese pump shells, bulldozer end bits and blades, mill guides, conveyer screws, muller tires, crusher jaws and cones, pipeline ball joints, crusher rolls, pulverizer hammers, cultivator chisels and sweeps, scraper blades, dragline buckets, screw conveyors, dredge pump impellers and side plates, sheepsfoot tampers and sizing screens.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS
<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Cr</th>
<th>Si</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.20</td>
<td>1.80</td>
<td>15.50</td>
<td>1.90</td>
<td>Bal</td>
</tr>
</tbody>
</table>

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

<table>
<thead>
<tr>
<th>HARDNESS</th>
<th>NUMBER OF LAYERS</th>
<th>AS DEPOSITED</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>1020 STEEL</td>
</tr>
<tr>
<td>1</td>
<td>40 HRc</td>
<td>35 HRc</td>
</tr>
<tr>
<td>2</td>
<td>48 HRc</td>
<td>42 HRc</td>
</tr>
<tr>
<td>3-5</td>
<td>52 HRc</td>
<td>50 HRc</td>
</tr>
</tbody>
</table>

- Abrasion Resistance: Very Good
- Impact Resistance: Fair
- Non Machinable: Grinding is Difficult
- Cannot be Flame Cut
- Deposit will Relief Check Crack
- Thickness Should be Limited to Five Layers Maximum

ORDERING INFORMATION

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>PACKET SIZE AND TYPE</th>
<th>PART NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2</td>
<td>11.3kg Coil</td>
<td>S604012-029</td>
</tr>
</tbody>
</table>
**Tube-alloy 258-0**

**GAS SHIELDED, ALL POSITION, HARD SURFACING FLUX-CORED WIRE.**

**CLASSIFICATIONS**
- AS/NZS 2576: 1550-B7*
  *Nearest Classification

**OPEN ARC TUBULAR WIRE**
A fabricated type, open arc tubular flux-cored wire depositing a Cr-Mo-W Martensitic steel alloy.

**DESIGNED FOR SURFACING MILD & LOW ALLOY STEEL COMPONENTS**
Designed for surfacing mild and low alloy steel components subject to moderate abrasive wear and impact under high compressive stresses and/or at temperatures up to 530 °C.

**TYPICAL APPLICATIONS**
Uses include machine components, tools and sliding metal to metal parts, dragline chains, kiln trunnions, mill guides, spindles and wobbler ends.

**TYPICAL ALL WELD METAL CHEMICAL ANALYSIS**

<table>
<thead>
<tr>
<th></th>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Cr</th>
<th>Mo</th>
<th>W</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>0.45</td>
<td>1.40</td>
<td>0.80</td>
<td>6.00</td>
<td>1.50</td>
<td>1.50</td>
<td>Bal</td>
</tr>
</tbody>
</table>

**TYPICAL ALL WELD METAL MECHANICAL ANALYSIS**

<table>
<thead>
<tr>
<th>HARDNESS</th>
<th>NUMBER OF LAYERS</th>
<th>AS DEPOSITED</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>1020 STEEL</td>
</tr>
<tr>
<td>1</td>
<td></td>
<td>49 HRc</td>
</tr>
<tr>
<td>2</td>
<td></td>
<td>53 HRc</td>
</tr>
<tr>
<td>3 - 5</td>
<td></td>
<td>57 HRc</td>
</tr>
</tbody>
</table>

- Abrasion Resistance: Good
- Impact Resistance: Good
- Non Machinable: Grinding Only
- Flame Cutting: Difficult
- Heat Treatable and Forgettable
- Maintains Hot Hardness up to 530°C

**ORDERING INFORMATION**

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>PACKET SIZE AND TYPE</th>
<th>PART NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2</td>
<td>11.3kg Spool</td>
<td>S605812-029</td>
</tr>
</tbody>
</table>
Tube-alloy A43-0

SELF SHIELDING WIRE DEPOSITING A HIGH CR/NB SURFACING ALLOY.

**CLASSIFICATIONS**
> AS/NZS 2576: 2460-B7

**SELF-SHIELDING WIRE**
Self shielding wire depositing a high Cr/Nb surfacing alloy which resists severe high and low stress abrasion and low to moderate impact.

**HIGH TEMPERATURE WEAR**
The weld deposit will check crack readily and can be used where high temperature wear resistance is required.

**TYPICAL APPLICATIONS**
Uses include augers, bucket lips and teeth, coal feeder screws, coal pulverizer rolls and tables, coke chutes, coke pusher shoes, conveyer screws, dredge cutter heads and teeth, dredge pump inlet nozzle and side plates, fan blades, grizzly bars and fingers, muller tires, paving agitator screws, pipeline ball joints, pub mill paddles, scraper blades, sheepfoot tampers and sizing screws.

**TYPICAL ALL WELD METAL CHEMICAL ANALYSIS**

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Cr</th>
<th>Nb</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>5.50</td>
<td>0.20</td>
<td>1.00</td>
<td>22.00</td>
<td>6.50</td>
<td>Bal</td>
</tr>
</tbody>
</table>

**TYPICAL ALL WELD METAL MECHANICAL ANALYSIS**

<table>
<thead>
<tr>
<th>HARDNESS</th>
<th>NUMBER OF LAYERS</th>
<th>AS DEPOSITED</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>1020 STEEL</td>
</tr>
<tr>
<td>1</td>
<td></td>
<td>56-60 HRc</td>
</tr>
<tr>
<td>2</td>
<td></td>
<td>60-64 HRc</td>
</tr>
</tbody>
</table>

- Abrasion Resistance: Excellent
- Impact Resistance: Poor
- Non Machinable: Grinding Only
- Cannot be Flame Cut
- Deposit will Relief Check Crack
- Thickness 2-3 Layers Maximum

**ORDERING INFORMATION**

<table>
<thead>
<tr>
<th>WIRE SIZE (MM)</th>
<th>PACKET SIZE AND TYPE</th>
<th>PART NUMBER</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.6</td>
<td>11.3kg Spool</td>
<td>S607719-029</td>
</tr>
</tbody>
</table>
NEW How to Videos

Learn how to get the best out of your weld!

Our specialist filler metal team demonstrate how you can get the best out of flux-cored wire, by considering the correct welding techniques, settings, preparation and product selection.

HOW DO I USE FLUX-CORED SELF-SHIELDED WIRE?

HOW DO I MINIMISE SPATTER?
The NEW Filler Metal Selector & Calculator is Available NOW!

DOWNLOAD YOUR COPY FOR IPHONE OR IPAD VIA THE APP STORE TODAY!

HOBART PRODUCT DATA SHEETS
Visit welding.com.au and download all of the Hobart product data sheets today!
The New AS/NZS ISO 17632 Standard

A SERIES OF ADOPTED ISO STANDARDS TO COVER FLUX-CORED ARC WELDING (FCAW) ELECTRODES FOR NON-ALLOY & FINE GRAIN STEELS.

The following provides a brief introduction into the classification systems, and the standard series cover different electrode range.

- AS/NZS ISO 18276: High strength steels
- AS/NZS ISO 17634: Creep resisting steels
- AS/NZS ISO 17633: Stainless steels

**COMPULSORY CLASSIFICATION DESIGNATORS**

- Classification by tensile strength and 27J CVN requirement.
- Tubular cored electrode.
- Minimum tensile strength meets 550 MPa.
- Tested temperature @ -40°C meets the minimum impact properties of 27J.
- Usability designator.
  - T5 indicates Lime-flouride flux, and generally refers to basic flux system.
- Welding position. 1 indicates all positional; and 0 - downhand only.
- Shielding gas M indicates mixed gases
- Indicates tested in the as welded condition.
- Chemical composition designator, N2 indicate 2% Nil in deposited weld metal.

**OPTIONAL SUPPLEMENTAL DESIGNATORS**

- 47J impact energy at the normal 27J test temperature has also been met.
- Diffusible hydrogen, “H5,H10,H15” is used to indicate a maximum diffusible hydrogen content of “5, 10 and 15 ml/100g of deposited metal, respectively.”
WE KNOW THE MARKET
We work hard to build our knowledge and understand what our market needs. Whether it's heavy engineering, mining, oil and gas or pipelines we know the market.

USED BY THE BEST
Both locally and globally our products are developed, delivered and supported by a team of industry experts who understand the needs of our customers.

WHERE WE STARTED
Established in 1962, WIA began as a small team of welding specialists, working to develop industry leading, innovative products. Today, we are a leading welding supplier because of our innovation and expertise.

CLASSIFICATIONS

THE ANSI/AWS A5.20 (PLAIN CARBON) AND A5.29 (LOW ALLOY) ELECTRODE SPECIFICATIONS HAVE SIMILAR CLASSIFICATION SYSTEMS.

They are shown in a combined form to acquaint the user with the information provided by the classification. For full details of all test requirements, radiographic standards, manufacturing tolerances, packaging, weld metal compositions etc., please consult the latest edition of the appropriate specification.
Flux-Cored Wires

FOR THE WORKSHOP OR ON-SITE

More Information:
For more information on Hobart’s flux-cored wires, contact the WiA Customer Support Centre or visit our website.
1300 300 884
welding.com.au