

FABSHIELD 4



SUMMARY

- > 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

CLASSIFICATION

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

DESCRIPTION AND APPLICATION

Fabshield 4 is an outstanding, high deposition rate, (up to 12.7kg/hr using 2.4mm size wire) 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

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
2.4	250 - 500	28 - 34
3.0	450 - 680	28 - 37

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
0.27	0.73	0.30	0.11	0.005	1.42	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Strength	432 MPa
Tensile Strength	652 MPa
Elongation	25%
CVN Impact Values	Not Required

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
2.4	22.7kg coil	S224529-014
3.0	22.7kg coil	S224541-014

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