

FABSHIELD 21B



SUMMARY

- > Self Shielded or “Gasless” Flux Cored Joining Wires
- > All Positional Welding Capabilities
- > Suitable For Single Pass/Multi-pass Applications
- > Suitable for Mild/Galvanised Steels

CLASSIFICATION

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

DESCRIPTION AND APPLICATION

Fabshield 21B is a general purpose self-shielded tubular wire that is designed for single and multi-pass welding of thin gauge to 20mm thick mild or galvanized steels. Great for welding fillet or lap welds, you will find that this all-position wire has high operator appeal, producing a smooth spray-like transfer with low spatter levels, excellent weld appearance and easy to remove slag.

Perfect for on-site applications such as the welding of machine parts, galvanized steels tanks, gates, frames, sheds, prefab construction, light structures, general fabrication etc.

OPERATIONAL DATA

Welding parameters shown below are for DC Electrode negative only.

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)	TYPICAL STICKOUT (MM)
0.9	55 - 120	17 - 20	12
1.2	130 - 160	15 - 18	12
1.6	150 - 250	18 - 20	19
2.0	200 - 300	16 - 23	19

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	S	P	Al	Fe
0.28	0.34	0.15	0.008	0.003	1.4	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

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

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
0.9	4.5kg spool	S222108-022
1.2	4.5kg spool	S222112-022
1.2	15kg spool	S222112-029
1.6	15kg spool	S222119-029
2.0	15kg spool	S222125-029

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