

# 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	0.011	0.005	1.42	Bal

### TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	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

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.

Issue CA - December 2014