

FabCO XL-525



SUMMARY

- > Low Diffusible Hydrogen
- > Excellent Toughness at Low Temperatures
- > Outstanding Weldability
- > Exceeds 47J CVN @ -40°C

CLASSIFICATION

- > 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

DESCRIPTION AND APPLICATION

A rutile flux cored all position wire designed for welding mild and carbon steels, especially when good impact toughness is required at sub zero temperatures. Ideal for single and multi-pass applications, it delivers outstanding welding performance and produces high quality X-ray clear weld deposit with a bead contour that is flat to slightly convex. It performs exceptionally well over rust, mill scale and some primers with no pre-cleaning of the steel necessary. Formula 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.

Recommended for ship building, storage vessels, off-shore structures, earth moving equipment and pipe welding.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	150 - 300	24 - 31
1.6	200 - 350	24 - 34

Recommended electrical stick out is 15-20mm.

Welding Current DC +

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

SHIPPING APPROVAL

LR 3S, 3YS; ABS 3SA, 3YSA Impact @ -40°C 34 ft, lbs
 DNV Y40MS BVS 3YM; CWB E491T-12MJ-H4;

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Ni	Fe
0.03	1.10	0.30	0.34	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	Ar+20% CO ₂
Yield Stress	503 MPa
Tensile Strength	566 MPa
Elongation	29%
CVN Impact Values	90J @ -40°C

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	15kg Spool	S283212-029
1.6	15kg Spool	S283219-029

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DIAMETER (mm)	WELD POSITION	AMPS	VOLTS	WIRE-FEED SPEED (m/min)	DEPOSITION RATE (kg/hr)	CONTACT TIP TO WORK DISTANCE (mm)
1.2	All Position	100	24	5.6	2.0	16
1.2	All Position	200	25	9.4	3.4	19
1.2	All Position	210	25	10.9	4.1	19
1.2	Flat & Horizontal	250	27	13.5	4.9	19
1.6	All Position	250	24	4.6	3.0	19
1.6	All Position	275	25	5.3	3.6	19
1.6	Flat & Horizontal	350	27	7.4	5.0	19
1.6	Flat & Horizontal	400	28	10.4	7.2	19
1.6	Flat & Horizontal	475	29	13.5	9.2	19

Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded. See Above: This information was determined by welding using 75% Argon (Ar)/25% Carbon Dioxide (CO₂) shielding gas with a flow rate between 17-24 l/min. All positions include: Flat, Horizontal, Vertical Up, and Overhead.