

### Fabshield XLR-8



#### SUMMARY

- > Welds Out of Position at High Currents
- > Low Hydrogen Weld Deposit
- > Excellent Slag Removal
- > No Shielding Gas Required
- > High Impact Strength at Low Temperatures
- > Excellent Mechanical Properties Under a Wide Range of Heat Input

#### CLASSIFICATION

- > AS/NZS ISO 17632-B - T492T8-1NA-U H10
- > AWS A5.20: E71T-8JD H8

#### DESCRIPTION AND APPLICATION

Low hydrogen T-8 self-shielded, all positional flux cored wire, producing 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. 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. 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. Specifically designed for increased productivity and high deposition rates on challenging structural steel erection, heavy equipment repair, mining equipment, bucket repairs, storage tanks, pipe spooling, ship construction and site work applications.

#### OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.6	180 - 275	18 - 23
1.8	170 - 315	18 - 23
2.0	200 - 340	18 - 24

Recommended electrical stick out is 25-35mm. Welding Current DC -  
 \*Voltage is determined by arc current and wire arc length.  
 Welding currents and voltage shown are operational guides only.

#### SHIPPING APPROVAL

ABS 3YSA; AWS D1.8 Conformance

#### TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	P	S	Al	Fe
0.19	0.51	0.17	0.009	0.006	0.51	Bal

#### TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	469 MPa
Tensile Strength	579 MPa
Elongation	28%
CVN Impact Values	68J @ -20°C 54J @ -30°C 42J @ -40°C

#### PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.6	15kg Vacuum Packed Spool	S225719-053
1.8	15kg Vacuum Packed Spool	S225724-053
2.0	15kg Vacuum Packed Spool	S225725-053
2.0	22.7kg Coil	S225725-014

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Issue CA - December 2014

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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)
1.6	All Position	180	18	3.7	1.5	25
1.6	All Position	210	21	4.8	2.1	25
1.6	All Position	230	22	5.3	2.5	25
1.6	All Position	255	23	6.4	2.8	25
1.6	Flat & Horizontal	265	22	6.9	3.3	25
1.6	Flat & Horizontal	275	23	8.0	3.8	25
1.8	All Position	170	18	2.4	1.5	25
1.8	All Position	230	22	4.1	2.7	25
1.8	All Position	245	22	4.3	2.9	25
1.8	All Position	265	22	5.1	3.4	25
1.8	Flat & Horizontal	315	23	7.1	4.8	25
2.0	All Position	200	18	2.5	1.8	32
2.0	All Position	230	18	3.2	2.3	32
2.0	All Position	255	22	4.1	2.9	32
2.0	All Position	280	23	5.1	3.7	32
2.0	Flat & Horizontal	340	24	7.1	5.1	32

Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded. Fabshield XLR-8 is intended to be used with constant-voltage (CV) power sources. All positions include: Flat, Horizontal, Vertical Up, and Overhead.