

HOBART 77TM



SUMMARY

- > Gas Shielded, Metal-Cored Wire
- > Slag-Free Weld Bead
- > Higher Deposition Rates
- > Low Spatter/Smooth Appearance
- > Better Fusion Profile

CLASSIFICATION

- > AS/NZS ISO 17632-B - T-493T15-OMA-UH5
- > AWS A5.18: E70C-6M H4

DESCRIPTION AND APPLICATION

Hobart 77TM is a metal-cored wire designed for high speed fillet and butt welding in the downhand position using Argon + 18-25% CO₂ shielding gas mixture. Weld beads are almost completely slag free with only minimal silicon islands, reducing the time and effort spent between runs and on cleanup prior to surface finishing.

Hobart 77TM is recommended for single and multi pass welding in both flat and horizontal positions for mild steel, carbon and manganese carbon steels with minimum clean up and where high deposition rates and efficiencies are required in high productivity, semi automatic and fully automatic welding installations. Suitable applications include mining buckets, structural fabrication and tank construction where high speed welding is required.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	200 - 350	26 - 34
1.6	300 - 450	28 - 35

Welding Current DC +

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

Welding currents and voltage shown are operational guides only.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	S	P	Cu	Ni
0.05	1.39	0.48	0.02	0.02	0.01	0.01

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	Ar+25% CO ₂
Yield Strength	515 MPa
Tensile Strength	580 MPa
Elongation	25%
CVN Impact Values	63J @ -30°C

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	15kg spool	H8-070C3112-158
1.6	15kg spool	H8-070C3116-158

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 - April 2019