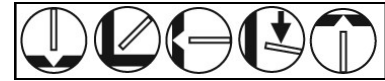


Fabshield® 71T8



AWS A5.29: E71T8-Ni1 J H8

WELDING POSITIONS:



FEATURES:

- Excellent operator appeal
- Fast-freezing slag
- Easy slag removal
- High impact strengths at low temperatures
- No shielding gas required
- Smaller diameter T8 electrode

BENEFITS:

- Increases productivity
- Suitable for all-position welding
- Reduces clean-up time, increases productivity
- Resists cracking in severe applications
- Suitable for welding outdoors
- Easier welding and training

APPLICATIONS:

- APL 5L Grades X70 and below with proper welding procedures
- API 5L oil and gas transmission pipelines
- Distribution pipeline

SLAG SYSTEM: Fast freezing, basic type, flux-cored wire

SHIELDING GAS: None required

TYPE OF CURRENT: Direct Current Electrode Negative (DCEN)

STANDARD DIAMETERS: 1/16" (1.6mm), 5/64" (2.0mm)

RE-DRYING: Not recommended

STORAGE: Product should be stored in a dry, enclosed environment, and in its original intact packaging

TYPICAL WELD METAL PROPERTIES* (Chem Pad):

Weld Metal Analysis	Fabshield 71T8	AWS Spec
Carbon (C)	0.02	0.12
Manganese (Mn)	1.44	1.50
Silicon (Si)	0.06	0.80
Sulphur (S)	0.004	0.03
Phosphorus (P)	0.010	0.03
Aluminum (Al)	1.00	1.80
Nickel (Ni)	0.95	0.80-1.10

Note: AWS specification single values are maximums.

TYPICAL DIFFUSIBLE HYDROGEN*:

Hydrogen Equipment	Fabshield 71T8	AWS Spec
(GAS CHROMATOGRAPHY)	5.5ml/100g	8.0ml/100g Maximum

TYPICAL MECHANICAL PROPERTIES* [Aged 48 Hrs. @ 200°F (93°C)]:

Mechanical Tests	1/16" (1.6mm) Diameter	5/64" (2.0mm) Diameter	AWS Spec
Tensile Strength	80,000 psi (552 MPa)	82,000 psi (565 MPa)	70,000-90,000 psi (483-621 MPa)
Yield Strength	71,000 psi (490 MPa)	71,000 psi (490 MPa)	58,000 psi (400 MPa) Minimum
Elongation % in 2" (50 mm)	29%	25%	20% Minimum

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded):

CVN Temperatures	1/16" (1.6mm) Diameter	5/64" (2.0mm) Diameter	AWS Spec
Avg. at -20°F (-30°C)	295 ft•lbs (400 Joules)	256 ft•lbs (347 Joules)	20 ft•lbs (27 Joules) Minimum
Avg. at -40°F (-40°C)	141 ft•lbs (191 Joules)	135 ft•lbs (183 Joules)	20 ft•lbs (27 Joules) Minimum "J" Requirement

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.29 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

Fabshield® 71T8

Diameter		Weld Position	Amps	Volts	Wire-Feed Speed		Deposition Rate		Contact Tip to Work Distance	
Inches	(mm)				in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
1/16	(1.6)	All Position	160	17	95	(2.4)	2.8	(1.3)	3/4	(19)
1/16	(1.6)	All Position	180	18	110	(2.8)	3.5	(1.6)	3/4	(19)
1/16	(1.6)	Flat, Horizontal	200	19	130	(3.3)	4.1	(1.9)	3/4	(19)
1/16	(1.6)	Flat, Horizontal	225	21	160	(4.1)	5.1	(2.3)	3/4	(19)
5/64	(2.0)	All Position	170	17	70	(1.8)	2.7	(1.2)	1	(25)
5/64	(2.0)	All Position	190	18	80	(2.0)	3.4	(1.5)	1	(25)
5/64	(2.0)	Flat, Horizontal	220	19	85	(2.2)	3.9	(1.7)	1	(25)
5/64	(2.0)	Flat, Horizontal	240	20	95	(2.4)	5.0	(2.3)	1	(25)

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**
- **All positions include:** Flat, Horizontal, Vertical Down, and Overhead.

STANDARD DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543, or (937) 332-5188 for International Customer Service.

Diameter		14-lb. (6.4kg) Coil
Inches	(mm)	
Net Pallet Weight		1695-lb. (769kg)
1/16	(1.6)	S228519-P01
5/64	(2.0)	S228525-P01

CONFORMANCES AND APPROVALS:

- **AWS A5.29**, E71T8-Ni1 J H8
- **AWS A5.29M**, E491T8-Ni1 J H8
- **ASME SFA 5.29**, E71T8-Ni1 J H8

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 Nw 36th St., Miami FL 33166; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers LLC is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

Fabshield is a registered trademark of Hobart Brothers LLC, Troy, Ohio.

Revision Date: 210122 (Replaces 130712)

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