

Fabshield[®] 718



AWS A5.20: E71T-8 H8

WELDING POSITIONS:



FEATURES:

- Excellent operator appeal
- Fast-freezing slag
- Self-shielded
- Excellent impact properties
- Easy slag removal

BENEFITS:

- Increases productivity
- Excellent for all-position welding
- Suitable for welding outdoors
- Helps to ensure weld integrity, reduces re-work
- Makes clean-up easy and quick

APPLICATIONS:

- APL 5L Grades: X46, X52, X60 and below
- Outdoor steel structures
- Water pipeline
- 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: 5/64" (2.0 mm)

RE-DRYING: Not recommended

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

TYPICAL WELD METAL CHEMISTRY* (Chem Pad):

Weld Metal Analysis (%)	Fabshield 718	AWS Spec
Carbon (C)	0.05	0.30
Manganese (Mn)	1.65	1.75
Silicon (Si)	0.05	0.60
Sulphur (S)	0.004	0.03
Phosphorus (P)	0.012	0.03
Aluminum (Al)	0.92	1.80
Nickel (Ni)	0.01	0.50

Note: AWS specification single values are maximums.

TYPICAL DIFFUSIBLE HYDROGEN:*

Hydrogen Equipment	Fabshield 718	AWS Spec
(Gas Chromatography)	6.2ml/100g	8.0ml/100g Maximum

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

Mechanical Tests	Fabshield 718	AWS Spec
Tensile Strength	76,000 psi (524 MPa)	70,000-95,000 psi (490-670 MPa)
Yield Strength	62,000 psi (427 MPa)	58,000 psi (390 MPa) Minimum
Elongation % in 2" (50mm)	26.8%	22% Minimum

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

CVN Temperatures	Fabshield 718	AWS Spec
Avg. at -20°F (-30°C)	68 ft•lbs (92 Joules)	20 ft•lbs (27 Joules) Minimum

*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 A5.20 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.

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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)
5/64	(2.0)	All Position	170	17	70	(1.7)	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	(2.1)	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 position includes:** Flat, Horizontal, Vertical Up, 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)	
5/64	(2.0)	S229225-P01

CONFORMANCES AND APPROVALS:

- **AWS A5.20**, E71T-8 H8
- **AWS A5.20M**, E491T-8 H8
- **ASME SFA 5.20**, E71T-8 H8

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 36 St, # 130, Doral, FL 33166-6672 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material 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.

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