

Fabshield[®] 4



AWS A5.20: E70T-4

WELDING POSITIONS:



FEATURES:

- Ease of operation
- No shielding gas required
- High deposition rates
- Easy slag removal

BENEFITS:

- Reduces welder training time
- Can be used outdoors
- Allows faster travel speeds
- Reduces clean-up

APPLICATIONS:

- Machine fabrication
- Certain ship equipment
- Industrial and heavy equipment repair

SHIELDING GAS: Not required

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS: 5/64" (2.0 mm), 3/32" (2.4 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 | | AWS Spec |
|---------------------|-------|----------|
| Carbon (C) | 0.27 | 0.30 |
| Manganese (Mn) | 0.73 | 1.75 |
| Phosphorus (P) | 0.011 | 0.03 |
| Sulphur (S) | 0.005 | 0.03 |
| Silicon (Si) | 0.30 | 0.60 |
| Aluminum (Al) | 1.42 | 1.80 |

TYPICAL MECHANICAL PROPERTIES* [Aged 48 Hrs. @ 220°F (93°C)]:

| Mechanical Tests | |
|----------------------------|----------------------|
| Tensile Strength | 94,600 psi (652 MPa) |
| Yield Strength | 62,600 psi (432 MPa) |
| Elongation % in 2" (50 mm) | 24% |

TYPICAL CHARPY V-NOTCH IMPACT VALUES*: Not required

*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 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) | Flat, Horizontal | 290 | 29 | 200 | (5.1) | 11 | (4.9) | 2 | (51) |
| 5/64 | (2.0) | Flat, Horizontal | 330 | 30 | 250 | (6.4) | 13 | (5.9) | 2 | (51) |
| 5/64 | (2.0) | Flat, Horizontal | 370 | 31 | 300 | (7.6) | 16 | (7.3) | 2 | (51) |
| 3/32 | (2.4) | Flat, Horizontal | 250 | 28 | 125 | (3.2) | 9 | (4.1) | 2-1/2 | (64) |
| 3/32 | (2.4) | Flat, Horizontal | 320 | 29 | 150 | (3.8) | 12 | (5.4) | 2-1/2 | (64) |
| 3/32 | (2.4) | Flat, Horizontal | 400 | 31 | 230 | (5.8) | 18 | (8.2) | 2-1/2 | (64) |
| 3/32 | (2.4) | Flat, Horizontal | 450 | 32 | 275 | (7.0) | 22 | (10.0) | 2-1/2 | (64) |
| 3/32 | (2.4) | Flat, Horizontal | 500 | 34 | 375 | (9.5) | 28 | (12.7) | 2-1/2 | (64) |

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**

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 | | 20-lb. (9.1kg) Spool | 33-lb. (15kg) Spool | 50-lb. (22.7kg) Coil | 600-lb. (272.2kg) Drum |
|----------|-------|----------------------|---------------------|----------------------|------------------------|
| Inches | (mm) | | | | |
| 5/64 | (2.0) | S224525-082 | S224525-029 | S224525-014 | - |
| 3/32 | (2.4) | - | - | S224529-V14 | S224529-008 |

CONFORMANCES AND APPROVALS:

- AWS A5.20, E70T-4
- AWS A5.20M, E490T-4
- ASME SFA 5.20, E70T-4

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 (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

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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