

# Fabshield® XLNT-6™



AWS A5.20: E70T-6

WELDING POSITIONS:



## FEATURES:

- Excellent slag removal
- No shielding gas required
- Good impact strength at low temperatures

## BENEFITS:

- Increases productivity, minimizes slag entrapment
- Suitable for welding outdoors
- Resists cracking in severe applications

## APPLICATIONS:

- Non-alloyed and fine grain steels
- Structural steel erection
- Bridge construction
- Ship and barge construction
- Heavy equipment repair

**SLAG SYSTEM:** Slow freezing, basic type, flux-cored wire

**SHIELDING GAS:** None 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	Fabshield XLNT-6	AWS Spec
Carbon (C)	0.10	0.30
Manganese (Mn)	1.34	1.75
Silicon (Si)	0.18	0.60
Phosphorus (P)	0.010	0.03
Sulphur (S)	0.004	0.03
Aluminum (Al)	1.00	1.80
Nickel (Ni)	0.42	0.50

**Note:** AWS specification single values are maximums.

## TYPICAL MECHANICAL PROPERTIES\* [Aged 48 hrs@200°F (93°C)]:

Mechanical Tests	Fabshield XLNT-6	AWS Spec
Tensile Strength	85,000 psi (586 MPa)	70,000-95,000 psi (490-670 MPa)
Yield Strength	64,000 psi (441 MPa)	58,000 psi (400 MPa) Minimum
Elongation % in 2" (50 mm)	25%	22% Minimum

## TYPICAL CHARPY V-NOTCH IMPACT VALUES\* (AS WELDED):

CVN Temperatures	Fabshield XLNT-6	AWS Spec
Avg. at 70°F (20°C)	45 ft •lbs (61 Joules)	Not specified
Avg. at -20°F (-30°C)	21 ft •lbs (28 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 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 Inches (mm)		Weld Position	Amps	Volts	Wire-Feed Speed in/min (m/min)		Deposition Rate lbs/hr (kg/hr)		Contact Tip to Work Distance Inches (mm)	
5/64	(2.0)	Flat & Horizontal	270	21	150	(3.8)	7.0	(3.2)	1	(25)
5/64	(2.0)	Flat & Horizontal	335	23	200	(5.1)	9.7	(4.4)	1	(25)
5/64	(2.0)	Flat & Horizontal	395	25	275	(7.0)	13.5	(6.1)	1	(25)
5/64	(2.0)	Flat & Horizontal	450	27	350	(8.9)	17.4	(7.9)	1	(25)
3/32	(2.4)	Flat & Horizontal	310	22	130	(3.3)	8.5	(3.9)	1	(25)
3/32	(2.4)	Flat & Horizontal	400	23	175	(4.4)	12.9	(5.9)	1	(25)
3/32	(2.4)	Flat & Horizontal	460	24	210	(5.3)	15.8	(7.2)	1	(25)
3/32	(2.4)	Flat & Horizontal	490	26	260	(6.6)	19.0	(8.6)	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.

**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 Inches (mm)	20-lb. (9kg) Vacuum-Packed Spool	50-lb. (22kg) Coil
<b>Net Pallet Weight</b>	<b>1440-lb. (653kg)</b>	<b>1600-lb. (726kg)</b>
5/64 (2.0)	S225625-H82	—
3/32 (2.4)	S225629-H82	S225629-014

## CONFORMANCES AND APPROVALS:

- AWS A5.20, E70T-6
- AWS A5.20M, E490T-6
- ASME SFA 5.20, E70T-6
- AWS D1.8 Conformance: 3/32" (2.4 mm)

**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](mailto: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](http://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](http://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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