

FabCO[®] 115



AWS A5.29: E110T5-K4C H4

WELDING POSITIONS:



FEATURES:

- Higher deposition rate than 11018M stick electrode
- Basic slag system
- 2% nickel content

BENEFITS:

- Increases productivity
- Minimizes the possibility of cracking
- Provides increased weld toughness for critical welds at low temperatures

APPLICATIONS:

- Mining equipment
- Earthmoving equipment
- Off-the-road vehicles

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

SHIELDING GAS: 100% Carbon Dioxide (CO₂) 35-50 cfh (17-24 l/min)

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STANDARD DIAMETERS: 0.045" (1.2 mm), 1/16" (1.6 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 PROPERTIES* (Chem Pad):

Weld Metal Analysis (%)	100% CO ₂	AWS Spec
Carbon (C)	0.04	0.15
Manganese (Mn)	1.50	1.20-2.25
Silicon (Si)	0.41	0.80
Phosphorus (P)	0.012	0.030
Sulphur (S)	0.014	0.030
Chromium (Cr)	0.42	0.20-0.60
Nickel (Ni)	2.37	1.75-2.60
Molybdenum (Mo)	0.42	0.20-0.65

TYPICAL DIFFUSIBLE HYDROGEN:

Hydrogen Equipment	100% CO ₂	AWS Spec
(GAS CHROMATOGRAPHY)	1.8 ml/100g	4.0 ml/100g Maximum

TYPICAL MECHANICAL PROPERTIES* (Aged 48 hrs@220°F):

Mechanical Tests	100% CO ₂	AWS Spec
Tensile Strength	126,000 psi (869 MPa)	110-130 psi (760-900 MPa)
Yield Strength	102,000 psi (701 MPa)	98,000 psi (680MPa) Minimum
Elongation % in 2" (50 mm)	18%	15%

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

CVN Temperatures	100% CO ₂	AWS Spec
Avg. at -60°F (-51°C)	48 ft•lbs (65 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 A5.29 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.

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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)
0.045	(1.2)	Flat & Horizontal	120	22	160	(4.1)	3.1	(1.4)	3/4	(19)
0.045	(1.2)	Flat & Horizontal	170	24	254	(6.5)	4.6	(2.1)	3/4	(19)
0.045	(1.2)	Flat & Horizontal	220	27	359	(9.1)	6.4	(2.9)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	190	22	117	(3.0)	4.3	(2.0)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	240	24	155	(3.9)	6.0	(2.7)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	290	26	204	(5.2)	7.0	(3.2)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	350	30	265	(6.7)	8.6	(3.9)	3/4	(19)
3/32	(2.4)	Flat & Horizontal	290	25	103	(2.6)	8.5	(3.9)	1	(25)
3/32	(2.4)	Flat & Horizontal	325	26	116	(2.9)	9.5	(4.3)	1	(25)
3/32	(2.4)	Flat & Horizontal	375	27	136	(3.5)	11.3	(5.1)	1	(25)
3/32	(2.4)	Flat & Horizontal	425	28	159	(4.0)	13.2	(6.0)	1	(25)
3/32	(2.4)	Flat & Horizontal	475	30	195	(5.0)	17.3	(7.8)	1	(25)
3/32	(2.4)	Flat & Horizontal	525	32	218	(5.5)	19.1	(8.7)	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.**
- **See Above:** This information was determined by welding using 100% CO₂ shielding gas with a flow rate between 35-50 cfm (17-24 l/min).

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		33-lb. (15kg)	60-lb. (27.2kg)
Inches	(mm)	Spool	Coil
0.045	(1.2)	S243512-029	—
1/16	(1.6)	—	S243519-002
3/32	(2.4)	—	S243529-002

CONFORMANCES AND APPROVALS:

- **AWS A5.29**, E110T5-K4C H4
- **ASME SFA 5.29**, E110T5-K4C H4
- **ABS**, 100% CO₂, E110T5-K4C H4
- **CWB**, 100% CO₂, E760T5-K4C H4 (E110T5-K4C H4)

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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