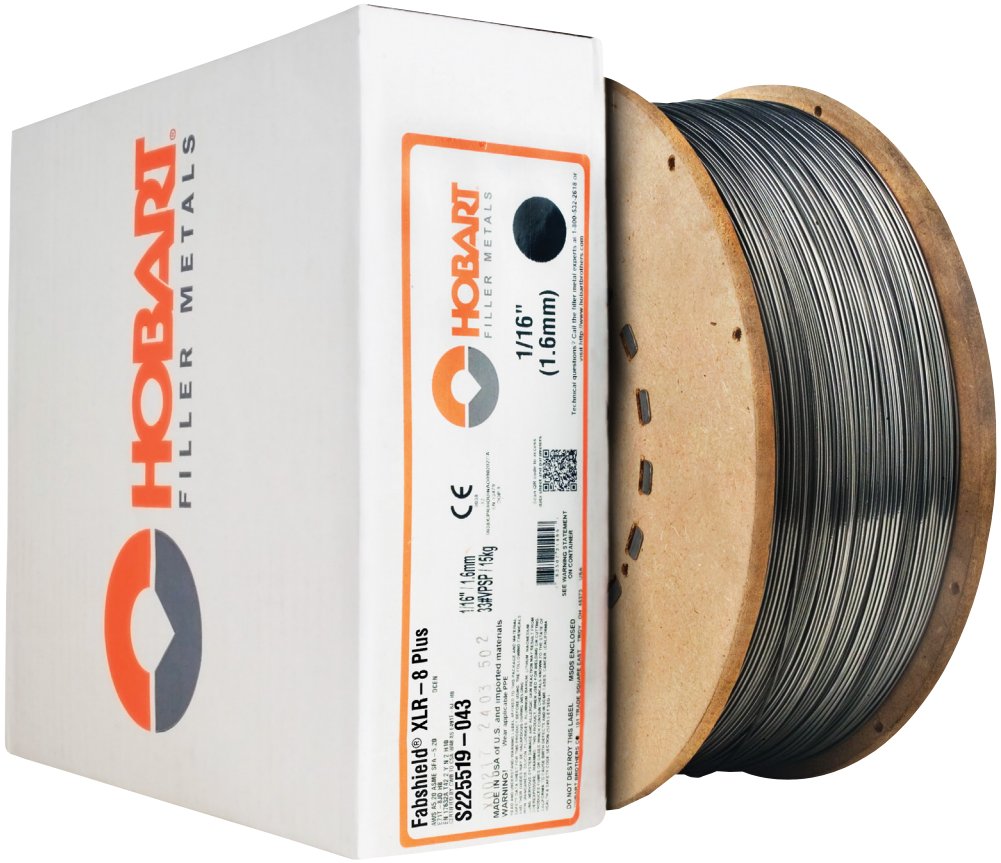
HOBART

FLUX-CORED SELF SHIELDED WIRES

FABSHIELD XLR-8 PLUS

- Welds out of position at high currents
- Low hydrogen weld deposit
- Excellent slag removal
- No shielding gas required
- High impact strength at low temperatures
- Excellent mechanical properties under a wide range of heat input
- Prequalified for steel types 1-7C, as specified in AS/NZS 1554.1



FABSHIELD XLR-8 PLUS

DESCRIPTION AND APPLICATION

Low hydrogen T-8 self-shielded, all positional flux cored wire, producing a stable arc and flat bead profile, especially suited for vertical-up welds at high currents with excellent mechanical properties and a tensile strength of 490 MPa.

Capable of depositing X-ray quality welds, making it highly suitable for critical welding applications requiring a high degree of crack resistance due to its low diffusable hydrogen levels, less than 7ml per 100g of weld metal deposited. XLR-8 Plus has been designed for single and multi-pass welding applications with improved productivity in out of position welding, offering high impact strength of (47J) at sub zero temperatures to -30°C.

Specifically designed for increased productivity and high deposition rates on challenging structural steel erection, heavy equipment repair, mining equipment, bucket repairs, storage tanks, pipe spooling, ship construction and site work applications.

ENHANCED NOTCH TOUGHNESS

Superior impact resistance for critical structural applications.

EXTREME TEMPERATURE PERFORMANCE

Works reliably in conditions down to -30°C.

ABS THIRD-PARTY APPROVAL

Ready for approval demanding applications.

AS/NZS 1554.1 PRE-QUALIFICATION

Eliminates costly procedure trials for Australian/NZ projects.

IMPROVED EASE OF USE

Enhanced arc characteristics and broader parameter window.

CLASSIFICATION

– AS/NZS ISO 17632-B: T49 3 T8-1NA-U H10

– AWS A5.20: E71T-8J H8

SHIPPING APPROVAL

ABS 3YSA H10

INDUSTRIAL APPLICATIONS

Construction Fabrication | Site Fabrication | On-Site Structural Fabrication | Bridge & Pile Work

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	P	S	Al	Fe
0.18	0.65	0.20	0.010	0.005	0.5	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	Tensile Strength	Elongation	CVN Impact Values
482 MPa	587 MPa	25%	57J @ -30°C 61J @ -20°C

FABSHIELD XLR-8 PLUS

OPERATIONAL DATA

Wire Size (mm)	Welding Current Range (A)	Arc Voltage Range* (V)
1.6	180 - 275	18 - 23
1.8	170 - 315	18 - 23

Recommended electrical stick out is 25-35mm.
Welding Current DC -
*Voltage is determined by arc current and wire arc length. Welding currents and voltage shown are operational guides only.

OPERATIONAL DATA

Diameter (MM)	Weld Position	Amps	Volts	Wire Feed Speed (m/min)	Depositon Rate (kg/hr)	Contact Tip to Work Distance (mm)
1.6	All Positions	180	18	3.7	1.5	25
		210	21	4.8	2.1	25
		230	22	5.3	2.5	25
		255	23	6.4	2.8	25
	Flat & Horizontal	265	22	6.9	3.3	25
		275	23	8.0	3.8	25
1.8	All Positions	170	18	2.4	1.5	25
		230	22	4.1	2.7	25
		245	22	4.3	2.9	25
		265	22	5.1	3.4	25
	Flat & Horizontal	315	23	7.1	4.8	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.
Fabshield XLR-8 Plus is intended to be used with constant-voltage (CV) power sources. All positions include: Flat, Horizontal, Vertical Up, and Overhead.

PACKAGING DATA

Wire Size (mm)	Pack Size and Type	Part No.
1.6	15kg spool	S225519-043
1.8	15kg spool	S225524-043