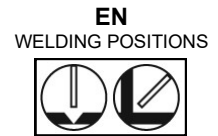
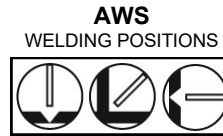


FabCO® RXR



AWS A5.20: E70T-1C, E70T-9C
EN ISO 17632-B: T55 2 T1 0 C1 A H10



FEATURES:

- Outstanding welding performance
- Smooth and stable arc
- Easy slag removal
- Deep side wall fusion
- High deposition rates
- Very flexible amperage range

BENEFITS:

- Excellent operator appeal
- Assists in producing welds with consistent appearance and quality
- Reduces clean-up time
- Minimizes risk of cold lap and lack of fusion
- Increases productivity
- Promotes versatility

APPLICATIONS:

- Steel structures
- Storage vessels
- Earth moving equipment
- Heavy fabrication
- Rail cars
- Single and multi-pass welding
- Non-alloyed and fine-grain steels

SLAG SYSTEM: Slow-freezing, rutile-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), 5/64" (2.0 mm), 3/32" (2.4 mm), 7/64" (2.8 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	100% CO ₂	AWS Spec
Carbon (C)	0.07	0.12
Manganese (Mn)	1.66	1.75
Silicon (Si)	0.64	0.90
Phosphorus (P)	0.012	0.030
Sulphur (S)	0.009	0.030

Note: AWS specification single values are maximums.

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

Mechanical Tests	100% CO ₂	AWS Spec
Tensile Strength	86,000 psi (592 MPa)	70,000-95,000 psi (490-670 MPa)
Yield Strength	75,000 psi (518 MPa)	58,000 psi (390 MPa) Minimum
Elongation % in 2" (50 mm)	26%	22% Minimum

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

CVN Temperatures	100% CO ₂	AWS Spec
Avg. at 0°F (-20°C)	30 ft •lbs (41 Joules)	20 ft •lbs (27 Joules) Minimum
Avg. at -20°F (-30°C)	25 ft •lbs (34 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.

FabCO® RXR

Diameter Inches (mm)		Weld Position	Amps	Volts	Wire-Feed Speed in/min (m/min)		Deposition Rate lbs/hr (kg/hr)		CTWD Inches (mm)	
0.045	(1.2)	Flat & Horizontal	150	25	225	(5.7)	3.5	(1.6)	3/4	(19)
0.045	(1.2)	Flat & Horizontal	180	27	280	(7.1)	5.3	(2.4)	3/4	(19)
0.045	(1.2)	Flat & Horizontal	250	29	450	(11.9)	8.0	(3.6)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	200	25	138	(3.5)	4.7	(2.1)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	300	27	230	(5.8)	8.4	(3.8)	3/4	(19)
1/16	(1.6)	Flat & Horizontal	375	29	311	(7.9)	11.6	(5.3)	3/4	(19)
5/64	(2.0)	Flat & Horizontal	250	26	119	(3.0)	6.6	(3.0)	1	(25)
5/64	(2.0)	Flat & Horizontal	300	29	145	(3.7)	8.4	(3.8)	1	(25)
5/64	(2.0)	Flat & Horizontal	350	31	181	(4.6)	10.2	(4.6)	1	(25)
5/64	(2.0)	Flat & Horizontal	400	33	226	(5.7)	12.1	(5.5)	1	(25)
3/32	(2.4)	Flat & Horizontal	350	26	120	(3.1)	9.2	(4.2)	1	(25)
3/32	(2.4)	Flat & Horizontal	400	29	142	(3.6)	11.5	(5.2)	1	(25)
3/32	(2.4)	Flat & Horizontal	450	32	174	(4.4)	13.7	(6.2)	1	(25)
3/32	(2.4)	Flat & Horizontal	470	34	234	(5.9)	18.1	(8.2)	1	(25)
7/64	(2.8)	Flat & Horizontal	500	30	125	(3.2)	13.4	(6.1)	1	(25)
7/64	(2.8)	Flat & Horizontal	600	34	176	(4.5)	18.5	(8.4)	1	(25)
7/64	(2.8)	Flat & Horizontal	700	36	221	(5.6)	23.6	(10.7)	1	(25)

- **Maintaining a proper welding procedure - including preheat 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)	33-lb. (15kg) Spool	44-lb. (20kg) Spool	60-lb. (27.2kg) Coil	250-lb. (113kg) Drum / X-Pak	600-lb. (272kg) X-Pak	800-lb. (363kg) Flat Reel
0.045 (1.2)	S246512-029	—	—	—	—	—
1/16 (1.6)	—	S246519-044	S246519-002	S246519-061	S246519-056	—
5/64 (2.0)	—	—	S246525-002	—	S246525-008	—
3/32 (2.4)	—	—	S246529-002	S246529-065	S246529-008	S246529-069
7/64 (2.8)	—	—	S246539-002	—	—	—

CONFORMANCES AND APPROVALS:

- **AWS A5.20**, E70T-1C, E70T-9C
- **AWS A5.20M**, E490T-1C, E490T-9C
- **ASME SFA 5.20**, E70T-1C, E70T-9C
- **ABS**, 100% CO₂, 2YSA H10
- **CWB**, 100% CO₂, E490T1-C1A3-CS1-H8 (E492T-9-H8) (1.2 mm - 2.4 mm diameter electrodes)
- **EN ISO 17632-B**: T55 2 T1 0 C1 A H10
- **CE Marked** per CPR 305/2011 (1.2 mm - 2.4 mm diameter electrodes)
- **MIL-E-24403/1**, MIL-70T-1C
- **AWS D1.8/D1.8M**, 100% CO₂, (1/16" [1.6 mm] & 3/32" [2.4 mm] diameter electrodes)

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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Revision Date: 200122 (Replaces 190823)

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