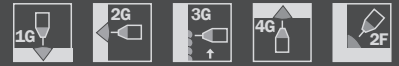




PRODUCT DATA SHEET

GAS SHIELDED WIRE

FABCO® 910



SUMMARY

- > Fast freezing, rutile type flux cored wire
- > Specially formulated to be used with high-argon shielding gas mixtures (>85% argon)
- > All positional
- > Excellent low-temperature impact toughness
- > Suitable for use in a wide variety of critical applications
- > Provides good puddle control and bead contour
- > Can help lower fume generation rate and visible smoke levels

CLASSIFICATION

- > AS/NZS ISO 17632-BT494T1-1MA-U-H10, T494T12-1MA-U-H10
- > AWS A5.20 E71T-1 M, E71T-12 MJ

DESCRIPTION AND APPLICATION

Welding can be done in all positions without the need to change the parameters. In addition, vertical up welding can be done without the need to weave.

FabCO 910 has been specially designed to be used with high argon shielding gas mixes. It is also suited for high heat input, slow cooling rate and low heat input high cooling rate welding conditions.

OTHER

- > **Wire Type:** Gas Shielded, Metal Powder, Metal-Cored Wire
- > **Shielding Gas:** 75-95% Argon (Ar)/Balance Carbon Dioxide (CO₂), 14-24 l/min
- > **Type of Current:** Direct Current Electrode Positive (DCEP)
- > **Standard Diameters:** 1.2mm
- > **Re-drying:** Not recommended
- > **Storage:** Product should be stored in a dry, enclosed environment, and in its original intact packaging

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	200 - 325	23 - 27

Recommended electrical stick out is 15-20mm. Welding Current DC - *Voltage is determined by arc current and wire arc length. Welding currents and voltage shown are operational guides only.

CONFORMANCES & APPROVALS

- > **AWS A5.20:** E71T-1MJ, E71T-9MJ, E71T-12MJ
- > **AWS A5.20M:** E491T-1MJ, E491T-9MJ, E491T-12MJ
- > **ASME:** SFA 5.20 E71T-1MJ, E71T-9MJ, E71T-12MJ
- > **CWB:** 75-92% Ar/Balance CO₂

TYPICAL WELD METAL CHEMISTRY

Shielding Gas	C	Mn	Si	P	S	Ni
75 Ar/25% CO ₂	0.5	0.84	0.39	0.008	0.009	0.40
92% Ar/8% CO ₂	0.06	0.86	0.41	0.012	0.011	0.41

TYPICAL MECHANICAL PROPERTIES

	75 Ar/25% CO ₂	92% Ar/8% CO ₂
Tensile strength	565 MPa	586 MPa
Yield Strength	503 MPa	538 MPa
Elongation	27%	27%
CVN Impact Values	122J @ -20 °C 47J @ -40 °C	142J @ -20 °C 68J @ -40 °C

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	15kg spool	MIGFCTM91012

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