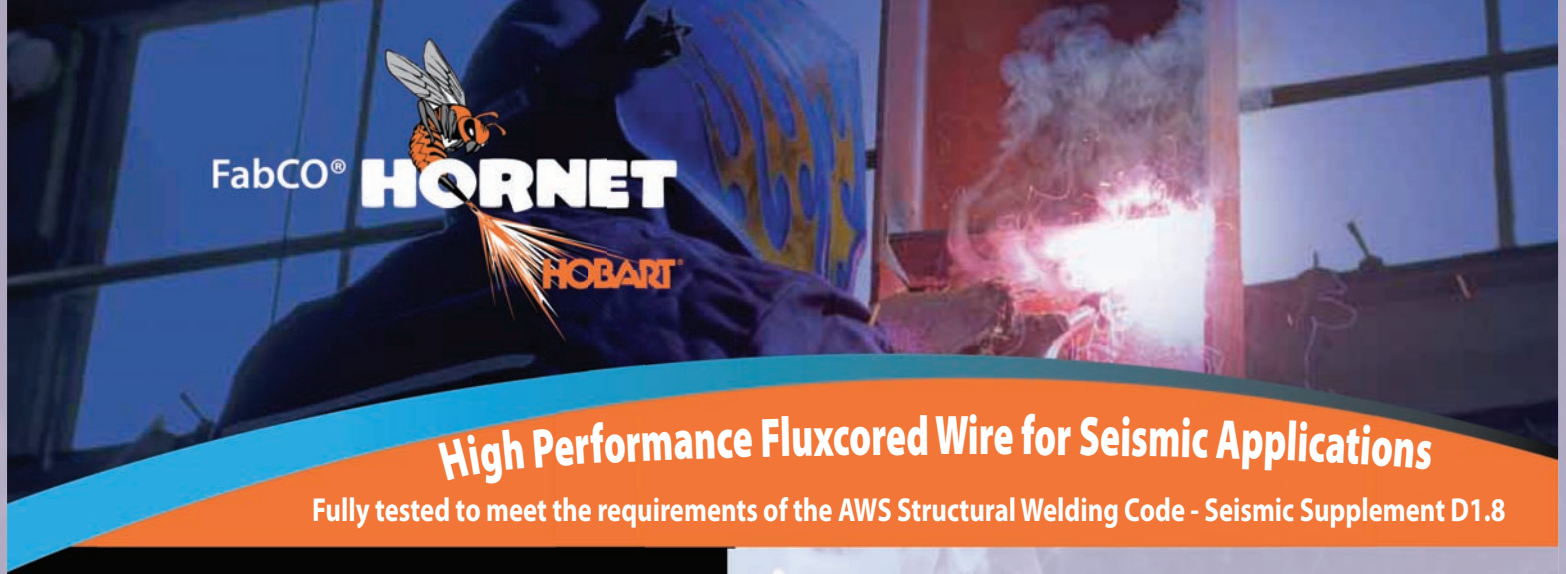
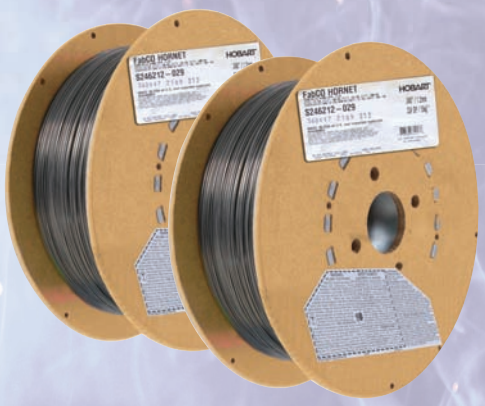


High Performance Fluxcored Wire for Seismic Applications

Fully tested to meet the requirements of the AWS Structural Welding Code - Seismic Supplement D1.8

***FabCO Hornet** is a tubular, flux-cored wire designed for **welding in all positions** for general fabrication work where penetration requirements are stringent. The wire is designed to have outstanding operator appeal under either 100% CO_2 or 75% Ar/25% CO_2 shielding gas. It produces flat bead profiles, low spatter levels, and easy slag removal, all while producing welds with superior penetration characteristics.*
FabCO Hornet provides good impact strength at low temperatures and meets the optional H8 diffusible hydrogen requirement.

Fabco Hornet from Weldwell New Zealand is a prequalified welding consumable to AS/NZS 1554.1 plus it gives the added assurance of having been subject to the extra test requirements of the American Welding Society codes and is suitable for seismic applications.



CONFORMANCES:

AWS A5.20: E71T-1C H8, E71T-1M H8, E71T-9C H8, E71T-9M H8
AS/NZS ISO 17632-B-T493T1-1CMA-U-H10

TYPICAL APPLICATIONS:

Suitable for structural steel seismic sensitive fabrications; mild steels, low alloy steels, multiple pass welds, single pass welds.

WELDING CHARACTERISTICS:

- Superior penetration profiles
- Easy slag removal and low spatter levels
- Good impact strength
- Low fume generation rate

BENEFITS:

- Easier to produce sound welds
- Reduced clean up time
- Increased toughness at low temperatures
- Increased welder appeal, improved working environment

PACKAGING:

Product Code 182660	1.2 mm - 15 kg spool
Product Code 182661	1.6 mm - 15 kg spool

Brought to you by

WELDWELL®

Branches at
Auckland : Hamilton : Tauranga : Napier : New Plymouth : Wellington : Christchurch
Phone - 0800 WELDWELL : Web - www.weldwell.co.nz

See our website for the list of our Authorised Distributors

TYPICAL WELD METAL COMPOSITION:*

SHIELDING GAS:	100% CO_2	75% Ar/25% CO_2
Carbon	0.030	0.035
Manganese	1.45	1.65
Silicon	0.30	0.40
Sulphur	0.011	0.010
Phosphorus	0.009	0.008

TYPICAL DIFFUSIBLE HYDROGEN:*

Gas Chromatography	5.0ml/100g	7.0m/100g

TYPICAL WELD METAL MECHANICAL PROPERTIES:*(aged 48 hrs @ 104°C)

	100% CO_2	75% Ar/25% CO_2
Yield:	545 MPa	548 MPa
Tensile Strength	569 MPa	621 MPa
Elongation in 2" (51 mm)	27%	26%
Average Impact Value at -18°C	122J	108J
Average Impact Value at -29°C	81J	102J

CONFORMANCES AND APPROVALS:

- AWS A5.20, E71T-1C H8, E71T-1M H8, E71T-9C H8, E71T-9M H8, ASME SFA 5.20, E71T-1C/M
- ABS 100% CO2 3SA, 3YSA H10, 75%/Ar/25%CO2 3SA, 3YSA H10
- CWB 100% CO2 E491T-9 H8, 80%/Ar/20%CO2 E491T-9M H8

SUGGESTED WELDING PARAMETERS:

		Weld Position	Amps	Volts	Wire Feed Speed		Deposition Rate Kg/Hr	Stickout +/- 19mm
					Inches	mm		
1.2mm	100% CO_2	Vertical Up, Overhead	170	23	260	660	2.00	19mm
		Vertical Up, Overhead	185	24	310	787	2.77	
		Vertical Up, Overhead	220	25	383	973	3.40	
		Horizontal and Flat	260	27	500	1270	4.03	
	75 Ar/25% CO_2	Vertical Up, Overhead	170	22	260	660	2.04	
		Vertical Up, Overhead	185	23	310	787	2.81	
		Vertical Up, Overhead	220	24	383	973	3.44	
		Horizontal and Flat	250	26	500	1270	4.08	
1.6mm	100% CO_2	Vertical Up, Overhead	215	24	160	406	2.54	25mm
		Vertical Up, Overhead	245	25	189	481	2.94	
		Horizontal	280	26	225	572	3.53	
		Flat	360	29	329	836	5.44	
	75 Ar/25% CO_2	Vertical Up, Overhead	215	22	160	406	2.58	
		Vertical Up, Overhead	245	23	189	481	2.99	
		Horizontal	280	24	225	572	3.58	
		Flat	360	27	329	836	5.48	

Material Safety data sheets can be obtained by contacting Weldwell Customer Service 0800WELDWELL

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Weldwell New Zealand and the manufacturer 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 the manufacturer.