

# PRODUCT DATA SHEET

## Hobart FabCO 115



FabCO 115 is a high strength, flux cored wire that is comparable to a low alloy E11018M electrode but with higher deposition rates. It is used primarily for welding A514, A517, HY100 and similar quenched and tempered high strength, low alloy steels, producing a low hydrogen deposit with basic slag which helps to minimise cracking. FabCO 115 has high impact values at low temperatures and provides a modified globular metal transfer. For use with 100% CO<sub>2</sub> shielding gas only.

### Classifications

AWS	A5.29	E110T5-K4
-----	-------	-----------

### Chemical Analysis

% Carbon	0,04	% Sulphur	0,014
% Manganese	1,5	% Chromium	0,42
% Silicon	0,41	% Nickel	2,37
% Phosphorous	0,012	% Molybdenum	0,42

### Typical Mechanical Properties (All weld metal PWHT 48 hr @ 104°C)

Tensile Strength	>690 MPa
0,2% Proof Stress	>770 MPa
% Elongation on 5d	>17
Charpy V-Notch at -40°C	>47 J

### Packing Data (DC-)

Diameter (mm)	Current		Stick Out (mm)	Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)			
2,4	290 - 525	25 - 32	25,0	27,2	W078188

Suggested gas for FCW welding: 100% CO<sub>2</sub>

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance therein. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02  
E-mail: [customer.service@afrox.linde.com](mailto:customer.service@afrox.linde.com) Website: [www.afrox.com](http://www.afrox.com)