

### Fabshield 21B



#### SUMMARY

- > Self Shielded or “Gasless” Flux Cored Joining Wires
- > All Positional Welding Capabilities
- > Suitable for Single Pass/Multi-pass Applications
- > Suitable for Mild/Galvanised Steels

#### CLASSIFICATION

- > AS/NZS ISO 17632-B - T49ZT11-1NA-H15
- > AWS A5.20: E71T-11

#### DESCRIPTION AND APPLICATION

Fabshield 21B is a general purpose self shielded tubular wire that is designed for single and multi-pass welding of thin gauge to 20mm thick mild or galvanized steels. Great for welding fillet or lap welds, you will find that this all-position wire has high operator appeal, producing a smooth spray-like transfer with low spatter levels, excellent weld appearance and easy to remove slag.

Perfect for on-site applications such as the welding of machine parts, galvanized steels tanks, gates, frames, sheds, prefab construction, light structures, general fabrication etc.

#### OPERATIONAL DATA

Welding parameters shown below are for DC electrode negative only.

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)	TYPICAL STICKOUT (MM)
0.8	25 - 125	14 - 16	12
0.9	55 - 120	17 - 20	12
1.2	130 - 160	15 - 18	12
1.6	150 - 250	18 - 20	19
2.0	200 - 300	16 - 23	19

Welding Current DC -

\*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

#### TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	S	P	Al	Fe
0.28	0.34	0.15	0.008	0.003	1.72	Bal

#### TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	427 MPa
Tensile Strength	627 MPa
Elongation	22%
CVN Impact Values	Not Required

#### PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
0.8	4.5kg Spool	S222106-022
0.9	4.5kg Spool	S222108-022
0.9	15kg Spool	S222108-029
1.2	4.5kg Spool	S222112-022
1.2	15kg Spool	S222112-029
1.6	15kg Spool	S222119-029
2.0	15kg Spool	S222125-029

The information contained or otherwise referenced herein is presented only as “typical” without guarantee or warranty, and Welding Industries of Australia expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with the AWS and or AS/NZS specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique by Welding Industries of Australia.

Issue CA - December 2014