

FabCOR[®] 90



AWS A5.28: E90C-K3 H4

WELDING POSITIONS:



FEATURES:

- Excellent wetting characteristics
- High tensile strength electrode
- High deposition rates possible at low heat inputs
- Can be used with standard CV equipment
- All-position capability when using pulsed-spray transfer

BENEFITS:

- Assists in producing smooth weld beads with uniform fusion
- Suitable for quench and temper high-strength low-alloy steels
- Increases productivity, minimizes Heat Affected Zone (HAZ)
- Promotes versatility, reduces equipment cost
- Increases productivity, reduces clean-up time

APPLICATIONS:

- High-strength low-alloy steels
- Quench and temper steels
- Single or multi-pass welding
- Castings
- Heavy equipment

WIRE TYPE: Gas-shielded, metal powder, metal-cored wire

SHIELDING GAS: 75-95% Argon (Ar)/Balance 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)

RE-DRYING: Not recommended

STORAGE: Product should be stored in a dry, enclosed environment, and in its original packaging

TYPICAL WELD METAL PROPERTIES* (Chem Pad):

Weld Metal Analysis	75% Ar/25% CO ₂	90% Ar/10% CO ₂	AWS Spec
Carbon (C)	0.06	0.06	0.15
Manganese (Mn)	1.19	1.41	0.75-2.25
Silicon (Si)	0.25	0.31	0.80
Sulphur (S)	0.012	0.012	0.025
Phosphorus (P)	0.009	0.006	0.025
Nickel (Ni)	1.84	1.83	0.50-2.50
Chromium (Cr)	0.08	0.08	0.15
Molybdenum (Mo)	0.34	0.34	0.25-0.65
Vanadium (V)	0.00	0.01	0.03
Copper (Cu)	0.06	0.06	0.35

Note: AWS specification single values are maximums.

TYPICAL DIFFUSIBLE HYDROGEN:

Hydrogen Equipment	75% Ar/25% CO ₂	AWS Spec
(GAS CHROMATOGRAPHY)	2.3 ml/100g	4.0 ml/100g Maximum

TYPICAL MECHANICAL PROPERTIES* (AS WELDED):

Mechanical Tests	75% Ar/25% CO ₂	90% Ar/10% CO ₂	AWS Spec
Tensile Strength	102,000 psi (703 MPa)	110,000 psi (758 MPa)	90,000 psi (620 MPa) Minimum
Yield Strength	94,000 psi (648 MPa)	104,000 psi (717 MPa)	78,000 psi (540 MPa) Minimum
Elongation % in 2" (50 mm)	23%	22%	18% Minimum

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (AS WELDED):

CVN Temperatures	75% Ar/25% CO ₂	90% Ar/10% CO ₂	AWS Spec
Avg. at -60°F (-50°C)	71 ft•lbs (96 Joules)	23 ft•lbs (31 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 AWS A5.28 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.

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Diameter		Weld Position	Amps	Volts	Wire Feed Speed		Deposition Rate		Contact Tip to Work Distance	
Inches	(mm)				in/min	(m/min)	lbs/hr	(kg/hr)	Inches	(mm)
0.045	(1.2)	Flat & Horizontal	200	27	245	(6.2)	5.9	(2.7)	5/8	(16)
0.045	(1.2)	Flat & Horizontal	300	29	455	(11.6)	12.0	(5.4)	3/4	(19)
0.045	(1.2)	Flat & Horizontal	350	30	580	(14.7)	15.2	(6.9)	3/4	(19)

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**
- **For out of position welding, short circuit or pulsed spray transfer mode must be used.**
- **Pulse waveforms are designed with nominal operating points that may result in average voltage and current values that differ from the above table. Generally, pulse processes can be expected to produce lower heat inputs than a standard CV process.**
- **See Above:** This information was determined by welding using 75% Ar/25% CO₂ shielding gas with a flow rate between 35-50 cfh (17-24 l/min). For the lower CO₂ shielding gas mixtures within the recommended range, reduce listed voltages by 1-3 volts.

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. (15 kg) Spool	500-lb. (227 kg) X-Pak	1000-lb. (453.6 kg) X-Pak
Net Pallet Weight	2376-lb (1078 kg)	2000-lb. (907 kg)	2000-lb. (907 kg)
0.045 (1.2)	S281612-029	S281612-050	S281612-058

CONFORMANCES AND APPROVALS:

- **AWS A5.28**, E90C-K3 H4
- **AWS A5.28M**, E62C-K3 H4
- **ASME SFA 5.28**, E90C-K3 H4

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.

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