

# FabStar 72G

AWS A5.26 EG72T-G

## Characteristics and Applications:

FabStar 72G is a self-shielded flux-cored wire used for single pass, vertical up, electrogas welding (EGW) of storage tank, shipbuilding, heavy equipment fabrication and structural welding. It provides good low-temperature impact toughness at -46°C. It is suitable for welding 490N/mm<sup>2</sup> high tensile steels with high deposition rate and without consumable guide.

## Notes on Usage:

1. Use DC(+) polarity.
2. Mechanical properties are dependent on plate chemistry and joint geometry.
3. Pre-heat the workpiece and star-up zone.
4. Baffle plate should be tightened firmly to prevent a leak of deposited metal.
5. Control all parameters with cares during welding, such as shape of weld joint, cooling rate.

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Mo
0.04	1.25	0.29	0.013	0.008	1.28	0.13

## Typical mechanical properties of weld metal on A36 base metal

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-1bf) -46°C (-51°F)
495(72)	595(86)	26	50(37)

## Sizes and recommended current range ( DC < + > )

Parameters	Diameter (mm)
	φ1.6
Plate thickness (mm)	9-16
Current (Amps)	250-300
Voltage(Volt)	28-32

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