

FabStar 712

AWS A5.20 E71T-1C
AWS A5.36 E71T1-C1A0-CS1
EN ISO 17632-A-T 46 2 P C 1 H10
JIS Z3313 T 49 2 T1-1 C A-U

Characteristics and Applications:

FabStar 712 is a rutile type gas shielded flux cored wire designed for mild steel and 490MPa high tensile steel. It is suitable for all position welding. It provides stable arc, less spatter, easy release of slag and excellent X-Ray clear weld deposit. It can reduce welding costs due to its superior usability in vertical up welding at higher currents and higher travel speeds. Typical applications include shipbuilding, storage vessels, structural fabrication, machinery and piping etc.

Notes on usage:

1. Use DC(+) polarity.
2. Use CO₂ (more than 99.8% purity) as shielding gas and flow rate should be around 20~25 l/min.
3. Maintain inter-pass temperature under 150°C in multiple pass welding to keep excellent mechanical properties.
4. Keep the product dry, while it is stored or delivered.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S
0.04	1.25	0.50	0.015	0.008

Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -20°C (0°F)
525(76)	585(85)	29	95(70)

Welding position:



Sizes and recommended parameter range (DC < + >):

Stick out: 15-25 (mm), gas flow rate: 20-25 (l/min):

Position	Diameter (mm)	1.2
F、HF、H		150A-320A/23V-32V
VU、VD、OH		170A-280A/23V-30V

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