

FabStar 82G

AWS A5.26 EG82T-G

Characteristics and Applications:

FabStar 82G 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 590N/mm² 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 start-up zone.
4. Baffle plate should be tightened firmly to prevent a leak of deposited metal.
5. Control all parameters with care during welding, such as shape of weld joint, cooling rate.
6. Keep the product dry, while it is stored or delivered.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Mo
0.04	1.37	0.34	0.013	0.008	1.3	0.14

Typical mechanical properties of weld metal on A36 base metal

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -46 (-50)
530(77)	625(91)	26	50(37)

Sizes and recommended current range (DC +)

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

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