

Characteristics and Applications:

HOBART 9J is a gas-shielded flux cored wire designed for mild steel and 490N/mm² high tensile steel. It is suitable for all position welding. It provides stable arc, less spatter, easy slag removable, and excellent X-Ray inspection. It provides good low-temperature impact value due to 0.4%Ni in weld metal. The typical applications include shipbuilding, vessels, piping etc.

Notes on Usage:

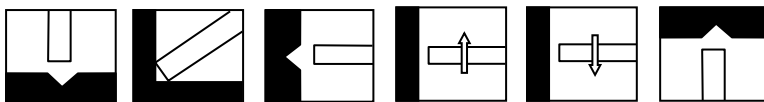
1. Use (DC+) polarity.
2. Use CO₂ as shielding gas.
3. Welding Heat Input must be controlled in order to get required impact value, since notch toughness tends to decrease due to excessive heat input.
4. Keep dry while in storage and delivery.

Typical Chemical Composition of Weld Metal (wt%)

	C	Mn	Si	P	S	Ni
AWS	≤0.12	≤1.75	≤0.90	≤0.03	≤0.03	≤0.50
EN ISO	-	≤2.0	-	-	-	≤0.5
Typical value	0.04	1.30	0.33	0.015	0.009	0.42

Typical Mechanical Properties of Weld Metal

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -40°C(-40°F)
AWS	≥ 390(58)	490-670(70-95)	≥ 22	≥ 27(20)
EN ISO	≥ 420(61)	500-640(73-93)	≥ 20	≥ 47(35)
Typical value	490(71)	560(81)	31	80(59)

Welding Position

Sizes and Recommended Operating Range (DC <+>) :
Stick Out: 15-25 (mm), Flow Rate: 20-25 (l/min):

Position	Diameter (mm)	1.2	1.6
	F, HF		160A~280A / 24V~33V
VU, OH		150A~220A / 24V~28V	160A~230A / 24V~28V
VD		230A~280A / 28V~33V	250A~300A / 24V~30V
H		200A~260A / 26V~30V	220A~280A / 23V~29V

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