Key Facts

- Multiple pass applications
- Thicker gauges of galvanised & mild steel
- No shielding gas is required, no cylinder rental or handling
- Self-shielding, all-positional flux-cored wire for mild steel
- Very smooth arc action. Reduced fume and spatter
- The use of DC straight polarity welding current
- Deposition efficiency is higher than that of shielded metal arc electrodes

Description

71T-11 is a self-shielding flux cored wire designed for single or multi pass welding having a smooth spray-type transfer commonly used on mild steels less than 3/4" thick. Easy general all position wire to use in the field where shielding gas is not practical. Limit to three passes will ensure properties on the mechanicals and weld deposit chemistry. Operates with no external shielding gas. The arc transfer is quite smooth and exceptionally low in spatter. The soft arc minimizes burn through on thin materials and in instances of poor fit up. A fast freezing slag facilitates welding in all positions.

Welding Positions

All positions

Classification, Approvals & Conformances

ANSI/AWS A5.20 E71T-11, E4916, E4918
ASME SFA A5.20 E71T-11

Applications

71T-11 is ideal for those applications where the use of shielding gas is inappropriate and where charpy v-notch toughness is not of prime concern. This flux cored wire is well suited for butt, lap, and fillet welds on steels from 16 gauge through 1/2". When welding on steels from 3/8" to 1/2" thick, a preheat of 325-375o F is strongly recommended. The .045" flux cored wire is not usually welded on steels greater than 3/8" thick, normally the 1/16" diameter electrode (or larger) is selected for these applications.

Typical Analysis/Composition

C - Carbon	Mn - Manganese	Si - Silicon	P - Phosphorus
0.21	.30	0.15	0.010
S - Sulphur	**Ai - Aluminum**		
0.010	1.50		

Typical Weld Mechanical Properties

Elongation (5xD):	>22%

Packaging & Ordering Information

Size	Weight	Part Number
0.8mm	4.5 Kg	200353
0.9mm	4.5 Kg	200355
1.2mm	4.5 Kg	200356
1.6mm	4.5 Kg	200357
1.6mm	15 Kg	200358