



PRODUCT DATA SHEET

SELF SHIELDED FLUX CORED WELDING WIRE

AUSTFIL T-11



SUMMARY

- Self-Shielded Flux Cored Wire
- All Positional Welding
- Single Pass / Multi Pass Applications
- Full Slag Covering and Easy Slag Removal
- Shielding Gas not required

CLASSIFICATION

- AS/NZS ISO 17632-B - T49ZT11-1NA-H15
- AWS A5.20: E71T-11

DESCRIPTION AND APPLICATION

The Austfil T-11 is a self-shielded flux cored wire for single and multi pass applications in all positions. Arc is smooth and soft, good welding performance, full slag covering and easy slag removal.

The Austfil T-11 is suitable for welding of mild and galvanized steels, gates, frames, sheds, light structures and general fabrication.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
0.8	25 - 125	14 - 16
0.9	80 - 150	15 - 18
1.2	130 - 190	17 - 20

Welding Current DC -

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	S	P	Al
0.06	0.60	0.05	0.008	0.012	1.22

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Strength	430 MPa
Tensile Strength	530 MPa
Elongation	24%

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
0.8	5kg spool	AUST11085KG
0.9	5kg spool	AUST11095KG
1.2	5kg spool	AUST11125KG

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