

Strongweld Self Shielded Tubular Wire E71T-11

Carbon Steel Tubular Wire for Flux Core Arc Welding (FCAW) without gas protection.

Classification

AWS A5.20/A5.20M

E71T-11

Description

- Strongweld 71T-11 is a self-shielded flux cored wire for lap and fillet welds of mild and medium tensile steels not exceeding 510MPa. It is suitable for a variety of applications such as prefab, building fabrication, tanks, ornamental iron, farm implement, repairs and general fabrication.
- Wire is for all-positional welding of single- and multiple pass fabrications.
- The arc characteristics are so smooth and stable, even the most novice welder can produce good welds.
- It is designed for on-site general fabrication and structural work requiring no impact properties.
- It can be used with DCEN polarity.

Typical Chemical Composition of All-Weld Metal (%):

C	Si	Mn	P	S	Al
0.10	0.10	0.55	0.016	0.006	1.2

Typical Mechanical Properties of All-Weld Metal:

	Yield Strength, Ksi	Tensile Strength, Ksi	Elongation (L=4d), %
AWS A5.20	Min. 58	70-95	20 min.
Strongweld 71T11	72	76	23

Packaging, sizes and code SAP:

Diameter	0.045"/1.1mm	1/16"/1.6mm	5/64"/2.0mm
Packaging	33Lb	33Lb	33Lb
Code SAP	1034065	1034067	1034068

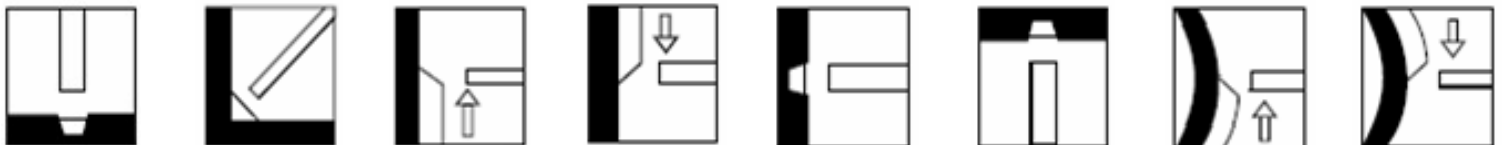
Calculation Data:

Diameter	Stick- Out (Pulg)	Wire Feed Speed (Pulg/min)	Current (A)	Arc Voltage (v)	Deposition Rate (lb/h)
0.045"	5/8	90	140	16-17	1.8
		110	160	17-18	2.5
		130	170	18-19	2.8

Recommender Operating Parameters:

Diameter, Inch	0.045"/1.1mm		1/16"/1.6mm		5/64"/2.0mm	
Type Parameter	Current (amp)	Voltage, Volts	Current (amp)	Voltage, Volts	Current (amp)	Voltage, Volts
Flat (1G/2F)	140	16	320	23	320	21
Horizontal (2G)	140	16	320	20	250	18
Vertical (3G/3F ↑)	130	16	190	18	-	-
Overhead (4G↑)	160	17	280	21	250	18
Pipe (5G↑ / 6G)	160	17	280	21	320	20
ESO, Inch	1/2 to 1"		1/2 to 1"		1/2 to 1"	

Welding Positions



DCEN – DC-