



ISO 9001:2000

71T-11 Carbon Steel Gasless Welding Wire

U.S. ALLOY CO.
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ALLOY DESCRIPTION AND APPLICATION;

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.

TYPICAL FCAW WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout
0.035	40-140	50-180	13-19	1/4-1/2
0.045	50-175	80-220	13-20	1/8-5/8
1/16"	60-180	120-300	15-20	1/4-1"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WIRE CHEMISTRY (%) AND WELD METAL PROPERTIES;

	AWS Spec.	U.S. ALLOY 71T-11		AWS Spec	Typical
Carbon	0.30 max	0.10			
Manganese	1.75 max	0.55	Tensile Strength (psi)	70-95,000	77,000
Silicon	0.60 max	0.10	Yield Strength (psi)	58,000 min.	70,000
Aluminum	1.80 max	1.20	Elongation in 2"	20% min.	22%
Phosphorus	0.030 max.	0.016			
Sulfur	0.030 max.	0.006			

AVAILABLE SIZES: TW 71T-11= Spools of .030, .035,.045, .068, 1/16, 5/64

SPECIFICATIONS; ANSI/AWS A5.20 E71T-11
ASME SFA A5.20 E71T-11

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