



# WELDCOTE E71T-11



Description: E71T-11 is a self-shielding flux cored wire designed for single or multi pass welding while having a spray type transfer commonly used for carbon/mild steels less than 3/4" thick. This all position wire can be used in the field where shielding gases are not practical. Limit to three passes to ensure properties on the mechanicals and weld deposit chemistry. E71T-11 operates on straight polarity only (DCEN).

Specifications: ANSI/AWS A5.20, E71T-11  
ASME SFA A5.20, E71T-11

### Typical Mechanical Properties of Weld Metal:

	AWS Spec	Typical
Tensile Strength (psi)	70-95,000	77,000
Yield Strength (psi)	58,000 (min)	70,000
Elongation % in 2"	20% (min)	22%

### Typical Filler Wire/Rod Chemistry in weight percent:

	C	Mn	Si	Al	P	S	Fe
AWS <sup>1</sup>	0.3	1.75	0.6	1.8	0.03	0.03	Balance
Result	0.2	0.6	0.3	1.42	0.01	0.013	Balance

AWS<sup>1</sup> Chemical Composition Requirements Range with single value maximum.

### Recommended Welding Parameters: E71T-11

FCAW Parameters (DCEN) Electrode Negative Optimum in Bold

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout
.030	60-175-200	30-115-200	14-15-18	3/8-1/2
.035	40-210-240	50-150-220	13-17-19	3/8-1/2
.045	50-170-200	80-180-220	13-17-20	3/8-5/8
1/16"	60-100-180	120-185-300	15-16-20	1/2-1"

Procedures may vary with changes in position, base metals, equipment and other variables

Available sizes: .030, .035, .045 in 10 lb. spools

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