

#### DESCRIPTION

Executive 71T-11 is a self-shielding flux cored wire designed for single and limited multi-pass applications. It is intended for semiautomatic and automatic welding of carbon steel. This all position wire can be used in the field where shielding gases are not available or practical. The portability and increased deposition of this semi-automatic wire can increase productivity.

As part of the Executive family of welding wires, the arc transfer is quite smooth and produces very little spatter. The soft arc minimizes burn through on thin materials and in instances of poor fit up. As with most self-shielding wires, Executive 71T-11 is designed to operate on straight polarity only (DCEN).

#### APPLICATIONS & FEATURES

This wire is an excellent choice for maintenance and repair welding as well as light assembly applications. EXECUTIVE 71T-11 is commonly used on steels from 16 gauge to ½" thick where charpy v-notch toughness is not of prime concern.

Additional features of this wire include excellent operator appeal and great bead appearance. Easy to remove slag ensures quick and easy cleanup.

#### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Si	P	S	Al
0.28	0.34	0.15	0.008	0.003	1.72

<b>Tensile Strength:</b>	90,500 PSI min	<b>Elongation:</b>	22%	<b>Diffusible Hydrogen:</b>	H8
<b>Yield Strength:</b>	62,000 PSI min				

#### TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	Wire Feed Speed (in./min)	Stick-Out	Position
.030"	14	30	55	1/2"	All Position
	18	135	250		
.035"	15	60	75	1/2"-5/8"	All Position
	18	115	110		
	20	150	200		
.045"	16	120	70	1/2"-5/8"	All Position
	17	160	110		
	19	175	135		

#### STANDARD PACKAGING

<b>Spools</b>	2-lb plastic spools 10-lb plastic spools
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#### CLASSIFICATION

AWS A5.20/ASME SFA A5.20 Class E71T-11

