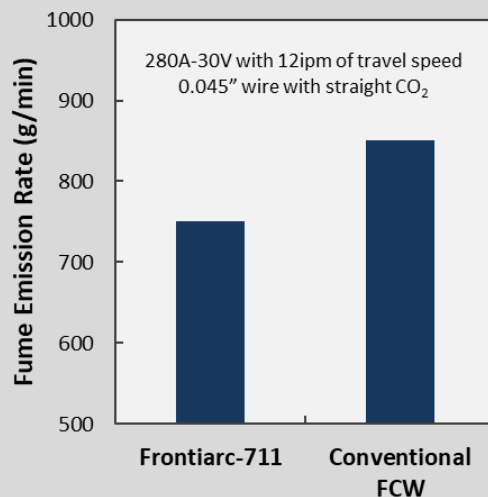




Features and typical fields of application

- Frontiarc-711 is a mild steel flux cored wire for all position single pass and multi-pass welding with straight CO₂ or 75%Ar-25%CO₂ mixed shielding gas.
- Its low fume emission, minimized spatter generation formula creates a clean welding environment at any welding condition.
- Frontiarc-711 is the right choice for shipbuilding, bridge construction, tanks, the structural steel industry including seismic applications and other general fabrication use with its versatile welder-friendly characteristics.



Typical mechanical properties of all-weld metal per AWS A5.20 and D1.8 Structural welding code

Code	Shielding Gas	0.2% PS (ksi)	TS (ksi)	El (%)	CVN (ft-lbs)
AWS A5.20	100%CO ₂	68	81	30	60 at -20°F
	75%Ar-25%CO ₂	76	88	31	78 at -20°F
AWS D1.8 Low H. lpt: 30kJ/in	100%CO ₂	74	84	30	139 at +70°F
AWS D1.8 High H. lpt: 79kJ/in		62	74	34	181 at +70°F

Chemical Composition of all weld metal as per AWS A5.20 (%)

Shielding Gas	C	Si	Mn	P	S
100%CO ₂	0.05	0.40	1.23	0.016	0.009
75%Ar-25%CO ₂	0.06	0.50	1.40	0.016	0.009

Diffusible Hydrogen Content per AWS A4.3

5.0 mL/100g

Approvals

ABS, CWB, LR, AWS D1.8

Rutile flux cored wire for all position with less fume emission

AWS A5.20 E71T-1C/M H8, 12C/M H8

CWB W48-18 E491T 9/9M H8



Recommended welding conditions and deposition rate

Wire Dia.	Wire Feed Speed (in/min)	Current (A)	Arc Voltage (V)	Deposition Rate (lbs/hr)	Wire Stick-Out
0.045"	140	120	23-26	4.0	3/4"
	200	160	25-28	6.0	
	290	200	27-30	8.0	
	330	220	27-30	9.0	
	400	250	28-30	10.5	
0.052"	120	140	24-27	3.5	3/4"
	175	180	24-27	5.5	
	265	240	26-28	8.5	
	300	260	27-29	10.0	1"
	395	300	29-31	11.5	
1/16"	100	180	24-27	4.5	3/4"
	165	240	25-28	7.0	
	190	260	26-29	8.0	
	250	300	29-31	10.0	1"
	300	340	30-32	11.5	

Table shown are approximate values that will vary depending on welding conditions (WESO, Cable length etc.).

Arc voltage shown are for straight CO₂ shielding gas. For 75%Ar-25%CO₂ use two volts less than shown.

Available Products

Wire Dia.	0.045", 0.052", 1/16"
Package	28 lbs spool, 44 lbs spool, 550 lbs Drum

DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

KOBELCO WELDING OF AMERICA INC.

