E71T-11 is a self-shielding flux cored wire used for welding carbon steels. This product does not require a shielding gas and can be used in limited multi-pass welding operations. The bead appearance is not equal to a gas shielded product, but the benefits of not having to use gas makes this product popular. E71T-11 operates on straight polarity only (DCEN).

**Typical Applications**
- Butt, lap and fillet welds on steel 16 gauge through 1/2"
- Assembly and maintenance welding
- Machine parts • Tanks • Prefab construction
- Light structural • Short assembly welds
- Railroad car repairs

**AWS Specification**
AWS A5.20/A5.20M:2005
AWS Classification E71T-11

**Welding Current**
DCEN (Electrode Negative, Straight Polarity)

**Typical Wire Chemistry**
- C 0.30
- Mn 1.75
- Si 0.60
- S 0.03
- P 0.03
- Cr 0.20
- Ni 0.50
- Mo 0.30
- V 0.08
- Al 1.8
- Cu 0.35

**Typical Mechanical Properties**
(As Welded)
- Yield Strength, ksi 58
- Tensile Strength, ksi 70 - 95
- Elongation%, min 20

**Welding Positions**
F,H,V-down,OH

**Available Diameters and suggested Operating Range in Amps**
- .030" 40 - 100
- .035" 100 - 130
- .045" 140 - 180
- 1/16" 175 - 300