

**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 gasshielded 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