



# 71T-11

## Specifications / Certifications:

AWS A5.20 E71T-11  
AWS A5.36 E71T11-AZ-CS3-H8

### Features

- Good arc stability
- High efficiency
- Good bead shape and slag removal
- Suitable for outdoor welding

### Applications

- High tensile steel
- Self-shielded wire

### Technical Specifications

- DCEN (electrode negative).
- Shielding gas is not required.

#### Recommended GMAW Weld Parameters:

Flat		
Diameter	Amps	Volts
0.030"	125-200A	15-18 V
0.035"	130-200A	17-21V
0.040"	130-200A	17-23V
0.045"	140-220A	22-32V
Horizontal Fillet		
Diameter	Amps	Volts
0.030"	125-200A	15-18V
0.035"	130-200A	16-22V
0.040"	130-200A	17-23V
0.045"	140-220A	22-32V
Vertical Up		
Diameter	Amps	Volts
0.030"	100-180A	15V
0.035"	100-170A	16V
0.040"	100-170A	16V
0.045"	100-160A	24-30V

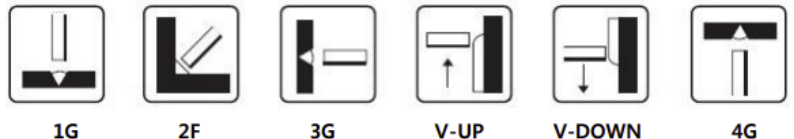
#### Typical Chemical Composition:

	C	Mn	Si	P	S	Al
71T11	0.15	0.77	0.39	0.009	0.003	1.25
AWS A5.20	0.30	1.75	0.60	0.03	0.03	1.8

#### Typical Mechanical Properties:

	Tensile Strength (psi)	Yield Strength (psi)	Elongation
71T11	81,511 psi	71,503 psi	24%
AWS	71,068-97,175 psi	56,564 psi	20%

#### Welding positions



**Diameters & Packages**

Diameter		Lbs	Pkg
0.030"	1/32"	2	Spool
		10	Spool
0.035"	7/200"	2	Spool
		10	Spool
		11	Spool
		25	Spool
		33	Spool
0.045"	3/64"	10	Spool
		11	Spool
		33	Spool
0.062"	1/16"	11	Spool
		33	Spool