

Coreshield 11

Coreshield 11 is an all-position self-shielded flux cored welding wire meeting all requirements for the E71T-11 classification. Coreshield 11 is excellent for use on single or multiple pass lap, fillet and butt welds on mild steels in all welding positions. Limitations do exist for multipass welds in excess of 1/2 in (12.7 mm). It produces smooth arc action, full slag coverage, easy slag removal, and low spatter. This product should find excellent acceptance in general purpose mild steel fabrication. In structural fabrication, the product can be used where no seismic requirements are present. Coreshield 11 is run DCEN.

Specifications

Classifications	AWS A5.36 : E71T11-Z-CS3 AWS A5.20 : E71T-11
Approvals	CWB : CSA W48 E491T-11-H16
Industry	Civil Construction Industrial and General Fabrication Automotive

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	435 MPa	620 MPa	22 %

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Al
0.22	0.60	0.21	0.003	0.01	1.10

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Efficiency (%)	TTW Dist.	Deposition Rate
0.9 mm	120 A	17 V	394 cm/min	77 %	9.5 mm	0.8 kg/h
0.9 mm	200 A	17 V	995 cm/min	81 %	9.5 mm	2.0 kg/h
0.9 mm	80 A	15 V	206 cm/min	75 %	9.5 mm	0.4 kg/h
1.2 mm	150 A	17 V	300 cm/min	79 %	12.5 mm	1.0 kg/h
1.2 mm	225 A	18 V	356 cm/min	82 %	12.5 mm	1.2 kg/h
1.2 mm	95 A	15 V	137 cm/min	74 %	12.5 mm	0.4 kg/h
1.6 mm	160 A	17 V	142 cm/min	78 %	16 mm	1.0 kg/h
1.6 mm	200 A	18 V	193 cm/min	80 %	16 mm	1.3 kg/h
1.6 mm	275 A	19 V	335 cm/min	81 %	16 mm	2.4 kg/h
2.0 mm	185 A	19 V	127 cm/min	77 %	25 mm	1.1 kg/h
2.0 mm	250 A	20 V	231 cm/min	79 %	25 mm	2.0 kg/h
2.0 mm	300 A	21 V	343 cm/min	81 %	25 mm	3.0 kg/h