

Coreshield 11

AWS A5.20 E71T-11 / JIS Z3313 YFW-S50GB

Flux
CORED
WIRES

Description

- Coreshield 11 is a self-shielded all-position flux cored welding wire for single and multiple pass applications on mild steel.

Application

- Coreshield 11 is excellent for use on single or multiple pass, lap, fillet, and butt welds on mild steels in all welding positions.
- It meets the requirements for classification E71T-11 in AWS specification A5.20, and offers smooth arc action, full slag coverage, easy slag removal, and low spatter. Bead appearance and weld edges are smooth and no shielding gas is required.
- This product should find excellent acceptance in general purpose mild steel fabrication. The .045" diameter wire can be used on materials as thin as 1/16". For single pass welding on material as thin as .047", .030" diameter Coreshield 15(AWS E71T-GS) is recommended.

Application

- Dual Shield II 80Ni1 is used on petrochemical equipment, offshore oil construction, ship fabrication, and heavy machinery. The weld metal analysis is similar to an E8018-C3 low hydrogen covered electrode.

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)
440 {45}	620 {63}	23

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Al
0.20	0.65	0.40	0.010	0.004	1.65

Special Precautions

- Coreshield 11, like many other E71T-11 wires, contains fluoride compounds. The fume exposure limit for fluorides is 2.5mg/m³ as Fluoride (Permissible Exposure Limit per Occupational Safety and Health Administration 29 CFR 1910.1000). This limit may be reached before the general fume limit of 5mg/m³ is reached (Threshold Limit Value, per American Conference of Governmental Industrial Hygienists).