

Inweld Fusion Flow 71T-11

AWS A5.20 E71T-11

Chemical Composition of Inweld Fusion Flow 71T-11

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu	Al
Balance	0.30	0.20	0.50	0.30	1.75	0.60	0.03	0.03	0.08	0.35	1.80

Single values are maximum unless otherwise specified.

Description and Applications

Electrodes of this class are self-shielded, operate on DCEN and have a small droplet transfer. They are general purpose electrodes for single and multi-pass welding in all positions. Their use is generally not recommended on thicknesses greater than 3/4" (19mm). Commonly used for butt, lap, and fillet welds on steel 1/2". Also used for assembly welding and maintenance welding.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Average As-Welded Brinell Hardness:	
Tensile Strength:	86,000 psi
Yield Strength:	68,000 psi
Elongation:	23%

Recommended Parameters

FCAW (DCEN – Electrode-)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.035"		90-130
0.045"		140-180
1/16"		175-300

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