

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	Automotive Civil Construction Industrial and General Fabrication

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 (63 ksi)	620 MPa (90 ksi)	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	Deposition Efficiency (%)	TTW Dist.	Deposition Rate
0.9 mm (.035 in.)	120 A	17 V	394 cm/min (155 in./min)	77 %	9.5 mm (3/8 in.)	0.8 kg/h (1.7 lbs/h)
0.9 mm (.035 in.)	200 A	17 V	995 cm/min (392 in./min)	81 %	9.5 mm (3/8 in.)	2.0 kg/h (4.5 lbs/h)
0.9 mm (.035 in.)	80 A	15 V	206 cm/min (81 in./min)	75 %	9.5 mm (3/8 in.)	0.4 kg/h (0.9 lbs/h)
1.2 mm (.045 in.)	150 A	17 V	300 cm/min (118 in./min)	79 %	12.5 mm (1/2 in.)	1.0 kg/h (2.1 lbs/h)
1.2 mm (.045 in.)	225 A	18 V	356 cm/min (140 in./min)	82 %	12.5 mm (1/2 in.)	1.2 kg/h (2.6 lbs/h)
1.2 mm (.045 in.)	95 A	15 V	137 cm/min (54 in./min)	74 %	12.5 mm (1/2 in.)	0.4 kg/h (0.9 lbs/h)
1.6 mm (1/16 in.)	160 A	17 V	142 cm/min (56 in./min)	78 %	16 mm (5/8 in.)	1.0 kg/h (2.1 lbs/h)
1.6 mm (1/16 in.)	200 A	18 V	193 cm/min (76 in./min)	80 %	16 mm (5/8 in.)	1.3 kg/h (2.9 lbs/h)
1.6 mm (1/16 in.)	275 A	19 V	335 cm/min (132 in./min)	81 %	16 mm (5/8 in.)	2.4 kg/h (5.2 lbs/h)
2.0 mm (5/64 in.)	185 A	19 V	127 cm/min (50 in./min)	77 %	25 mm (1 in.)	1.1 kg/h (2.4 lbs/h)
2.0 mm (5/64 in.)	250 A	20 V	231 cm/min (91 in./min)	79 %	25 mm (1 in.)	2.0 kg/h (4.5 lbs/h)
2.0 mm (5/64 in.)	300 A	21 V	343 cm/min (135 in./min)	81 %	25 mm (1 in.)	3.0 kg/h (6.6 lbs/h)