

CIGWELD

AN ESAB BRAND

GASLESS

SHIELD-COR X11

GASLESS WELDING WIRE

PRODUCT DATA SHEET



ALL POSITIONAL MULTI PASS E71T-11 WIRE



SELF-SHIELDED FLUX CORED ARC WELDING (FCAW) WIRES

SHIELD-COR X11:

- Self-shielded Flux Cored wire.
- For single or multi pass applications.
- Versatile, all Positional Capabilities.
- Excellent operator appeal.
- Smooth Rippled Fillets with good Edge Wetting.
- Ideal for welding Thin Section Mild and Galvanised Steels.
- Excellent tolerance to Joint Misalignment or Poor Joint Fit-up.

CLASSIFICATIONS:

ISO AS/NZS: 17632

B T 49 Z T11 1 NA

AWS/ASME-SFA A5.20:

E71T-11

RECOMMENDED SHIELDING GAS:

Not Required.

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	425 MPa
Tensile Strength	585 MPa
Elongation	23%

TYPICAL ALL WELD METAL ANALYSIS:

Single values are maximum allowable, unless otherwise stated.

C:	0.18%
Mn:	0.64%
Si:	0.26%
Al:	1.13%
S:	0.003%
P:	0.014%

DESCRIPTION AND APPLICATIONS:

Shield-Cor X11 is an all positional self-shielded flux cored wire recommended for the general purpose single or multi-pass lap, fillet and butt welding of mild and galvanised steels.

Shield-Cor X11 meets the performance requirements of AWS A5.20: E71T-11 and when used with DC electrode negative polarity produces smooth arc characteristics with low spatter and an easy-to-remove full covering slag.

The soft arc transfer gives Shield-Cor X11 improved tolerance to joint misalignment or poor fit-up. Smooth stable arcing and excellent fillet shape and edge wetting are achieved when welding galvanised steel fixtures. When 'tuned in' to the optimum current and voltage settings 1.2mm Shield-Cor X11 can be easily used in all welding positions including vertical-up / down and overhead.

Applications include the general purpose fabrication or repair of mild and galvanised steel fixtures and structures including gates, fences, steel frames, galvanised tanks and ornamental iron work etc.

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

15.0 - 20.0 mls of hydrogen / 100gms of deposited weld metal*.





* - for "as manufactured" product using the recommended E.S.O. lengths.

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
0.8	Spool	1kg	720926
0.8	Spool	5kg	720930
0.9	Spool	1kg	720928
0.9	Spool	5kg	720932
1.2	Spool	5kg	720934
1.2	Spool	15kg	720936

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation and DC electrode negative only.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING POSITION
0.8	90-150	14-16	10-12	 Flat
0.9	110-180	15-17	12-15	
1.2	180-230	16-18	15-20	
0.8	80-140	14-16	10-12	 HV Fillet
0.9	100-170	15-17	12-15	
1.2	150-200	16-18	15-20	
0.8	60-120	14-16	10-12	 Vertical Up
0.9	80-150	15-17	12-15	
1.2	130-180	16-18	15-20	
0.8	60-120	14-16	10-12	 Overhead
0.9	80-150	15-17	12-15	
1.2	130-180	16-18	15-20	

These machine settings are a guide only. Actual voltage, welding current and CTWD used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

