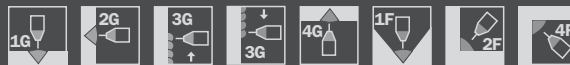




PRODUCT DATA SHEET

SELF SHIELDED FLUX CORED WELDING WIRE

AUSTFIL T-11



SUMMARY

- > Self-Shielded Flux Cored Wire
- > All Positional Welding
- > Single Pass / Multi Pass Applications
- > Full Slag Covering and Easy Slag Removal
- > Shielding Gas not required

CLASSIFICATION

- > AS/NZS ISO 17632-B - T49ZT11-1NA-H15
- > AWS A5.20: E71T-11

DESCRIPTION AND APPLICATION

The Austfil T-11 is a self-shielded flux cored wire for single and multi pass applications in all positions. Arc is smooth and soft, good welding performance, full slag covering and easy slag removal.

The Austfil T-11 is suitable for welding of mild and galvanized steels, gates, frames, sheds, light structures and general fabrication.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
0.8	25 - 125	14 - 16
0.9	80 - 150	15 - 18
1.2	130 - 190	17 - 20

Welding Current DC -

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	S	P	Al
0.06	0.60	0.05	0.008	0.012	1.22

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Strength	430 MPa
Tensile Strength	530 MPa
Elongation	24%

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
0.8	5kg spool	AUST11085KG
0.9	5kg spool	AUST11095KG
1.2	5kg spool	AUST11125KG

The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Welding Industries of Australia expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with the AWS and or AS/NZS specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique by Welding Industries of Australia.

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