

### Conformances

AWS A5.36/ ASME SFA5.36 E71T11-AZ-CS3  
(AWS A5.20/ ASME SFA5.20 E71T-11)  
JIS Z3313 T49 T14-1 N A  
EN ISO 17632-A-T 42 Y Z Z NO 1  
CE

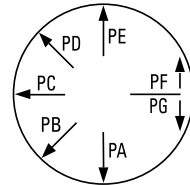
### Applications

- General fabrication
- Galvanized steel
- Civil construction

### Features

- All position self-shielded flux cored wire
- Single & multi-pass welding of thin plate

### Welding Position



### Current

DC -

### Shielding Gas

No shielding gas

### Diameter / Packaging

Diameter mm (in)	Spool	
	15kg (33lbs)	20kg (44lbs)
1.0 (0.040)	✓	✓
1.2 (0.045)	✓	✓
1.4 (0.052)	✓	✓
1.6 (1/16)	✓	✓

### Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.18	0.34	0.50	0.012	0.006	1.35

### Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)
510 (74,000)	580 (84,100)	24

### Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
1.6mm (1/16 in) DC+						
No shielding gas	25 (1)	2.5 (98)	130-180	14-18	0.9 (2.0)	77-81
		3.4 (134)	180-240	16-20	1.2 (2.6)	
		4.0 (157)	220-280	18-23	2.2 (4.8)	