

## Gasless Wire E71T-11

### ALL POSITION SELF-SHIELDING - GASLESS

#### Description

An all-position, self-shielded flux-cored wire designed for single pass and multi pass fillet and lap welding on galvanized or carbon steel, as thin as 20 gauge, without burn-through. Commonly used on Mig welding machines, DC-polarity, offering smooth arc action with very little spatter. Travel speed is fast, penetration is good and slag removal is easy.

#### SHIELDING GAS:

NONE REQUIRED

#### CONFORMANCES:

AS/NZS ISO 17632 BT 49 Z T1

AWS A5.20/E71T-11

#### TYPICAL APPLICATIONS

- Popular among home workshop welders because it works so well on 220 volt and 380 volt machines
- Can be used on thin gauge steel
- Suitable for automobile body shops on door & auto body repair work
- Sheet metal duct work
- Lap and butt joints on galvanised pipe and box sections

#### TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield Strength MPa	Tensile Strength MPa	Elongation %
520	590	21.0

#### OPERATING DATA

All positional: Flat, V-up, V-down, Overhead

Polarity: DC- (welding torch negative, earth lead positive)

Wire Size	Welding Positions	Amperage	Voltage
0.8mm	Horizontal/Flat	90-150	14-16
	Vertical/Overhead	60-125	10-12
0.9mm	Horizontal/Flat	90-200	12-17
	Vertical/Overhead	70-150	12-15
1.2mm	Horizontal/Flat	160-220	16-18
	Vertical/Overhead	120-180	16-18

#### SAFETY NOTE

As with all self-shielded wires, Gasless Wire MG-11 does contain fluoride compounds, which require more attention to ventilation when being used to weld galvanized steel. The zinc oxide formed during welding should not be inhaled as it can cause metal fume fever. When welding indoors or in an enclosed area, be sure that the ventilation is adequate.