



WASHINGTON ALLOY'S Quality  
Management System is  
Certified to **ISO 9001:2008**  
Cert # 05-R0925

# 71T-11 Carbon Steel Gasless Welding Wire



**American Welding Society**  
Sustaining Company Member



## ALLOY DESCRIPTION AND APPLICATION;

71T-11 is a self-shielding flux cored wire designed for single or multi pass welding having a smooth spray-type transfer commonly used on mild steels less than 3/4" thick. Easy general all position wire to use in the field where shielding gas is not practical. Limit to three passes will ensure properties on the mechanicals and weld deposit chemistry.

## TYPICAL FCAW WELDING PROCEDURES; DCEN

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout
0.030	60- <b>175</b> -200	30- <b>115</b> -200	14- <b>15</b> -18	3/8-1/2
0.035	40- <b>210</b> -240	50- <b>150</b> -220	13- <b>17</b> -19	3/8-1/2
0.045	50- <b>170</b> -200	80- <b>180</b> -220	13- <b>17</b> -20	3/8-5/8
1/16"	60- <b>100</b> -180	120- <b>185</b> -300	15- <b>16</b> -20	1/2-1"

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

## TYPICAL WIRE CHEMISTRY (%) AND WELD METAL PROPERTIES;

	AWS Spec.	U.S. ALLOY 71T-11		AWS Spec	Typical
Carbon	0.30 max	0.10			
Manganese	1.75 max	0.55	Tensile Strength (psi)	70-95,000	77,000
Silicon	0.60 max	0.10	Yield Strength (psi)	58,000 min.	70,000
Aluminum	1.80 max	1.20	Elongation in 2"	20% min.	22%
Phosphorus	0.030 max.	0.016			
Sulfur	0.030 max.	0.006			

**AVAILABLE SIZES:** TW 71T-11= Spools of .030, .035, .045, .068, 1/16, 5/64

**SPECIFICATIONS;** ANSI/AWS A5.20  
ASME SFA A5.20

E71T-11  
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