



## XTR 71T-11

AWS A5.20 E71T-11

### Description:

71T-11 is a carbon steel, flux cored electrode for use without an external shielding gas. An excellent option for outdoor welding when adverse conditions prohibit the use of a shielding gas. Easy slag removal and fast freezing characteristics allow for poor fit-up situations.

### Typical Applications:

XTR E71T-11 is a self-shielding flux cored wire used for welding carbon steels. Does not require a shielding gas and can be used in limited multi-pass welding operations. Typically used for butt, lap, and fillet welds on steel 16 gauge through 1/2"; assembly and maintenance welding; machine parts, tanks, prefab construction. Can be used on structural beams and most prefab building construction.

### Chemistry:

	Typical	AWS Spec. Single values are max.
Carbon (C)	0.250	0.300
Manganese (Mn)	0.735	1.750
Silicon (Si)	0.348	0.600
Phosphorus (P)	0.012	0.030
Sulfur (S)	0.006	0.030
Chromium (Cr)	0.038	0.200
Nickel (Ni)	0.061	0.500
Molybdenum (Mo)	0.049	0.300
Vanadium (V)	0.003	0.080
Copper (Cu)	0.042	0.350
Aluminum (Al)	1.645	1.800



### Mechanical Properties: (As Welded FCAW)

	Typical	AWS Spec. Single values are min.
Tensile Strength	89,000	70,000 psi
Yield Strength	74,000	58,000 psi
Elongation in 2" (%)	26	20
Charpy V-Notch	ns	ns

### Welding Positions:

All - H, F, VU, VD, OH

### Operating Parameters: MIG (FCAW), DCEN DC-

No Shielding Gas					
Diameter	Amperage	Voltage	Speed (IPM)	Stickout (In.)	Flow Rate (CFH)
0.030 (.8mm)	115	15	180	3/8	na
0.035 (.9mm)	150	17	205	1/2	na
0.045 (1.14mm)	190	17	180	1/2	na
1/16 (1.6mm)	190	18	115	3/4	na

When welding in VU, VD or OH positions, amperage should drop by about 25% as well as wire feed speed.

Typically, the wire speed is set, then adjust to voltage to the desirable performance



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