

## OA E-71 T-11

**CATEGORY** FCAW Flux-Cored

**TYPE** Self-shielded flux-cored wire for C. and C-Mn steels.

**APPLICATIONS** Tanks, boilers, steel structural works (large thickness), earthworks and construction works.

**PROPERTIES** Open-arc flux cored wire (self-shielded) designed for welding thin carbon and carbon-manganese steels in all positions. Easily removable slag, versatility and manuality; suitable for welding zinc-coated plates as well. Completely free of barium salts. . To be used on DC- (DC operation, electrode negative polarity).

**CLASSIFICATION** AWS 5.20: E71T-11  
EN ISO 17632-A: T 42 Z WN 1 H15

**SUITABLE FOR**

ASTM	EN
A 131 Gr A, B, D	10025 S185, S235, S275, S355
A 131 Gr AH32 to DH36	10028-2 P235 G H, P265 G H, P295 G H, P355 G H
API 5LX	10113-2 S275, S355
-	10113-3 S275, S355

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD DEPOSIT WEIGHT %**

C	Mn	Si	Al	Ni	Mo
0.18	1.0	0.25	0.80		

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW	430	520	23				

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) (DC-)	spool types	kg / spool	kg / pallet
0.9			D-200 / S-300	5 / 15	
1.2			D-200 / S-300	5 / 15	
1.6			D-200 / S-300	5 / 15	
2.4			S-300	15	

**REDRYING TEMPERATURE** 150°C / 24hr

**GAS ACCORDING EN 14175:** no gas required