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ISO 9001:2008 REGISTERED
Certificate No.: 50040 & 50415

E71T-11 DATA SHEET

Pinnacle Alloys E71T-11
AWS CLASS E71T-11
CODE AND SPECIFICATION DATA:
AWS A5.20 ASME SFA 5.20; UNS W07611

DESCRIPTION:
Pinnacle Alloys E71T-11 is a carbon steel flux-cored electrode for sure without external shielding gas. It is intended for semiautomatic and automatic welding of carbon steel in a single pass and limited multipass applications. This filler material is designed to operate on straight polarity (DCEN) and operates with no external shielding gas. This electrode is well suited for welding steels from 16 gauge to ½". When thicker steels ($^{3}/_{18}$" and over) are welded, a preheat of 325-375°F is recommended.

DIAMETERS: .045", 1/16"

WELDING POSITIONS: All positions

TYPICAL DEPOSIT COMPOSITION:

	AWS Spec	Weld Metal Analysis (%)
Aluminum (Al)	1.80	1.50
Carbon (C)	0.30	0.21
Manganese (Mn)	1.75	0.30
Phosphorus (P)	0.03	0.01
Silicon (Si)	0.60	0.15
Sulfur (S)	0.03	0.01

NOTE: Single values are maximums.

TYPICAL MECHANICAL PROPERTIES:

	AWS Spec (min)	As Welded
Ultimate Tensile Strength	70,000-95,000 psi (490-670 MPa)	89,400 psi (615 MPa)
Yield Strength	58,000 psi (390 MPa)	66,500 psi (455 MPa)

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Percent Elongation in 2”	20%	23%

TYPICAL WELDING PARAMETERS:

Diameter	Position	Optimum			Amperage Range	Voltage Range
		Amperage	Voltage	WFS (ipm)		
.045”	Flat	200	17	190	190-210	16-18
	Overhead	170	17	155	160-180	16-18
	Vertical Up	170	17	155	160-180	16-18
1/16”	Flat	250	18	110	240-260	17-19
	Overhead	170	16	90	160-180	15-17
	Vertical Up	170	16	90	160-180	15-17

NOTE: Parameters are with DCEN. Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of steel being welded.

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, “Safety in Welding and Cutting,” published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys SDS sheets may be obtained on the website below.