

Supershield 11

Type : Self-Shielded



Conformances

AWS A5.36/ ASME SFA5.36 E71T11-AZ-CS3

(AWS A5.20/ ASME SFA5.20 E71T-11)

JIS Z3313 T49 T14-1 N A

EN ISO 17632-A-T 42 Y Z Z NO 1

CE

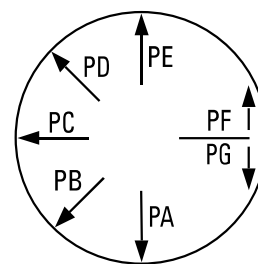
Applications

- General fabrication
- Galvanized steel
- Civil construction

Features

- All position self-shielded flux cored wire
- Single & multi-pass welding of thin plate

Welding Position



Current

DC -

Shielding Gas

No shielding gas

Diameter / Packaging

Diameter mm (in)	Spool	
	15kg (33lbs)	20kg (44lbs)
1.0 (0.040)	✓	✓
1.2 (0.045)	✓	✓
1.4 (0.052)	✓	✓
1.6 (1/16)	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.18	0.34	0.50	0.012	0.006	1.35

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)
510 (74,000)	580 (84,100)	24

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
1.6mm (1/16 in) DC+						
No shielding gas	25 (1)	2.5 (98)	130~180	14~18	0.9 (2.0)	77~81
		3.4 (134)	180~240	16~20	1.2 (2.6)	
		4.0 (157)	220~280	18~23	2.2 (4.8)	

Supershield 71GS

Type : Self-Shielded

Conformances

AWS A5.36/ ASME SFA5.36 E71TGS
 (AWS A5.20/ ASME SFA5.20 E71T-GS)
 JIS Z3313 T49 T14-1 N S
 EN ISO 17632-A-T 42 Z Z V NO 1

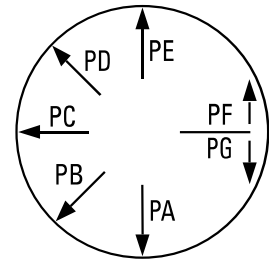
Applications

- General fabrications
- Galvanized steel
- Civil construction

Features

- All position self-shielded flux cored wire
- Single pass welding of thin plate

Welding Position



Current

DC -

Shielding Gas

No shielding gas

Diameter / Packaging

Diameter mm (in)	Spool	
	15kg (33lbs)	20kg (44lbs)
1.0 (0.040)	✓	✓
1.2 (0.045)	✓	✓
1.4 (0.052)	✓	✓
1.6 (1/16)	✓	✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.26	0.50	0.91	0.016	0.014	2.05

Typical Mechanical Properties of All-Weld Metal

	AS welded
Transverse Tensile Strength MPa(lbs/in ²) (Specimen broken in the base metal)	586 (85,000)
Longitudinal Guided Bend Test	Satisfactory

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)
1.6mm (1/16 in) DC+						
No shielding gas	25 (1)	2.4 (94)	130~180	14~18	0.9 (2.0)	76~80
		3.3 (130)	180~240	16~20	1.1 (2.4)	
		4.0 (157)	220~280	18~23	2.1 (4.6)	

SMWV

SAW

GMWV

GTAW

FCWV

Non-FERROUS

APPENDIX