BOSSWELD TECHNOLOGY

BT-11 GASLESS MIG WELDING WIRE

KEY FACTS

- A premium grade Gasless mild steel MIG wire
- A5.20 E71T-11
- Smooth Arc action DC-
- Vacuum foil sealed pack
- No shielding gas required
- Suitable for single and multiple pass applications

DESCRIPTION

71T-11 is a self-shielding flux cored wire designed for single or multi pass welding having a smooth spraytype 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. Operates with no external shielding gas.

The arc transfer is quite smooth and exceptionally low in spatter. The soft arc minimizes burn through on thin materials and in instances of poor fit up. A fast freezing slag facilitates welding in all positions.

CLASSIFICATIONS, APPROVALS, CONFORMANCES

ANSI/AWS A5.20 E71T-11, E4916, E4918

ASME SFA A5.20 E71T-11

RECOMMENDED SHIELDING GAS

No shielding gas required

WELDING POSITIONS

All positional

PA PB PC PD PE PF PG

APPLICATIONS

71T-11 is ideal for those applications where the use of shielding gas is inappropriate and where charpy vnotch toughness is not of prime concern. This flux cored wire is well suited for butt, lap, and fillet welds on steels from 16 gauge through 1/2".

When welding on steels from 3/8" to 1/2" thick, a preheat of 325-375°F is strongly recommended. The .045" flux cored wire is not usually welded on steels greater than 3/8" thick, normally the 1/16" diameter electrode (or larger) is selected for these applications.

TYPICAL WIRE ANALYSIS

C Carbon	**Mn** Manganese	**Si** Silicon
< 0.2	< 1.0	< 0.5
P Phosphorus	**S** Sulphur	**Ai** Aluminium
< 0.02	< 0.02	< 1.50

TYPICAL WELD MECHANICAL PROPERTIES

Elongation	> 22%

PACKAGING & ORDERING INFORMATION

Size	Packet	Part Number
0.8mm	5kg	200360
0.9mm	5kg	200361

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary fro model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products; this is entirely up to the user's ability.