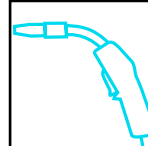


WELDING CONSUMABLES FLUX CORED ARC WELDING (FCAW) WIRES



SECTION THREE

SHIELD-COR 11



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	445 MPa
Tensile Strength	620 MPa
Elongation	22%

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.25%	Mn: 0.70%	Si: 0.40%
Al: 1.65%	S: 0.004%	P: 0.007%

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

15.0 - 20.0 mls of hydrogen / 100gms of deposited weld metal *

* - for "as manufactured" product using the recommended E.S.O. lengths.

RECOMMENDED SHIELDING GAS:

Not Required.

Actual weld metal mechanical properties achieved with Shield-Cor 11 are influenced by many factors including, base metal analysis, welding parameters / heat input used, number of weld passes and run placement etc. Please consult your nearest CIGWELD branch for welding procedure recommendations.

- ▲ Self-shielded Flux Cored wire.
- ▲ Versatile, All Positional Capabilities.
- ▲ Excellent Tolerance to Joint Misalignment or Poor Joint Fit-up.
- ▲ Smooth Rippled Fillets with Good Edge Wetting.
- ▲ Ideal for Welding Thin Section Mild and Galvanised Steels.

Classifications:

AS/NZS 2203.1: ETP-GNn-W500A. CM2.

AWS/ASME-SFA A5.20: E71T-11.

Packaging Data:

Wire Diameter (mm)	Type	Pack Weight	Pack Part No.
1.2	Spool	15kg	720923

Operating Data:

All welding conditions recommended below are for use with semi-automatic operation and DC electrode negative only.

Wire Diameter (mm)	Current Range (amps)	Voltage Range (volts)	Electrode Stickout E.S.O. (mm)	Welding Positions
1.2	150 – 200	16 – 18	15 – 20	Flat
1.2	130 – 180	16 – 18	15 – 20	HV Fillet
1.2	130 – 180	16 – 18	15 – 20	Vertical up
1.2	180 – 230	16 – 18	15 – 20	Overhead

These machine settings are a guide only. Actual voltage, welding current and E.S.O. used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

SHIELD-COR 15



TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	430 MPa
Tensile Strength	600 MPa
Elongation	21%

TYPICAL ALL WELD METAL ANALYSIS:

C: 0.25%	Mn: 0.70%	Si: 0.40%
Al: 2.10%	S: 0.004%	P: 0.007%

TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

15.0 - 20.0 mls of hydrogen / 100gms of deposited weld metal *

* - for "as manufactured" product using the recommended E.S.O. lengths.

RECOMMENDED SHIELDING GAS:

Not Required.

Actual weld metal mechanical properties achieved with Shield-Cor 15 are influenced by many factors including, base metal analysis, welding parameters / heat input used, number of weld passes and run placement etc. Please consult your nearest CIGWELD branch for welding procedure recommendations.

- ▲ Self-shielded Flux Cored wire.
- ▲ For Single Pass applications Only.
- ▲ Versatile, All Positional Capabilities.
- ▲ Excellent Tolerance to Joint Misalignment or Poor Joint Fit-up.
- ▲ Smooth Rippled Fillets with Good Edge Wetting.
- ▲ Ideal for Welding Thin Section Mild and Galvanised Steels.

Classifications:

AS/NZS 2203.1: ETPS-GNn-W500A. CM2.

AWS/ASME-SFA A5.20: E71T-GS.

Packaging Data:

Wire Diam. (mm)	Type	Pack Weight	Pack Part No.
0.8	100mm spool	0.45kg x (4/ctn)	721956
0.8	200mm Handispool	4.5kg	721923
0.9	100mm Minispool	0.45kg x (4/ctn)	721976
0.9	200mm Handispool	4.5kg	721924

Operating Data:

All welding conditions recommended below are for use with semi-automatic operation and DC electrode negative only.

Wire Diameter (mm)	Current Range (amps)	Voltage Range (volts)	Electrode Stickout E.S.O. (mm)	Welding Positions
0.8	90 – 150	14 – 16	10 – 12	Flat
0.9	110 – 180	15 – 17	12 – 15	
0.8	80 – 140	14 – 16	10 – 12	HV Fillet
0.9	100 – 175	15 – 17	12 – 15	
0.8	60 – 120	14 – 16	10 – 12	Vertical up
0.9	80 – 150	15 – 17	12 – 15	
0.8	60 – 120	14 – 16	10 – 12	Overhead
0.9	80 – 150	15 – 17	12 – 15	

These machine settings are a guide only. Actual voltage, welding current and E.S.O. used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.