

Technical data sheet

EN131023GB

Cored welding wire**SPEEDARC T11****CLASSIFICATION**

ASME IIC SFA 5.20 / AWS A 5.20

E71T-11*

EN ISO 17632-A

T 38 Z Z NO 1*

ASME IX Qualification

QW-432 F-N° 6 QW-442 A-N° 1

*Elongation > 20% is not guaranteed

DESCRIPTION

- Self-shielded flux-cored wire
- Designed for vertical down welding of CMn steels thinner than 5 mm
- Using DC electrode negative, the wire produces a spray transfer and low spatter
- The arc is not affected by draughts or moderate wind

APPLICATIONS

SPEEDARC T11 is used for a wide range of general fabrication applications on mild and C-Mn steels in vertical down position. It is especially suited to fillet and lap joints in thin gauge mild steel sheet and for tacking and short run assembly welding.

Examples

Unalloyed construction steel

EN 10025

S185 to S355

Boiler plate

EN 10028-2

P235GH to P355GH

Fine-grained steels

EN 10113

S275 to S420

Pipe steels

EN 10208

L210 to L415

API5LX

X42, X46, X52

ISO/TR 15608: Groups 1.1 and 1.2

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Al
0.10	0.5	0.3	1.4

MINIMUM ALL-WELD MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]
490	390

TYPICAL ALL-WELD MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]
600	440

OPERATING CONDITIONS

Diameter [mm]	Stick-out [mm]	Current type	Current [A]	Voltage [V]
1.2	40 ± 10	DC-	100 - 200	19 - 27
1.6	40 ± 10		150 - 300	21 - 29
2.0	50 ± 10		200 - 400	23 - 31
2.4	70 ± 10		300 - 500	25 - 33

WELDING POSITIONS

EN ISO 6947: PA, PB, PG

ASME IX: 1F, 1G, 2F, 3F and 3G down

PACKAGING

EN ISO 544:

Diameter	≤ 1.6 mm	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	Spool S 200	Spool BS 300	Coil B 450	Drum
Weight	5 kg	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.