

PRODUCT DATA SHEET



SELFSHIELD 11

Flux Cored Self Shielded Wire

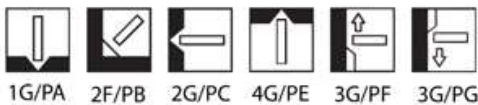
DESCRIPTION

Selfshield 11 is a general purpose self-shielded or “gasless” wire that is suitable for single and multi pass welding in all positions. A smooth soft arc provides great stability on a variety of base metals including galvanised steels. This all position wire has high operator appeal with low spatter levels, smooth arc transfer and easy slag removal. Perfect for on-site applications such as the welding of equipment parts, galvanised steels, tanks, gates, frames, sheds, prefab construction, light structures and general fabrication etc

KEY FEATURES

- Self Shielded or “Gasless” Flux Cored Wire
- All positional welding
- Easy slag removal
- Fast freezing to help assist with poor fit up
- Suitable for single pass/multi-pass applications
- Suitable for mild/galvanised steel

WELDING POSITIONS



CLASSIFICATION

- AS/NZS ISO 17632-B: T49 ZT11-1NA
- AWS A5.20: E71T-11

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	P	S	Al
0.08	0.60	0.014	0.012	0.009	1.22

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Strength (Mpa)	480
Tensile Strength (Mpa)	530
Elongation %	23

PACKING DATA

WIRE DIAMETER	PACK SIZE & TYPE	PART NUMBER
0.8mm	1kg minispool	MWFCGCF110801
0.8mm	4.5kg spool	MWFCGCF110845
0.9mm	4.5kg spool	MWFCGCF110945
1.2mm	4.5kg spool	MWFCGCF111245
1.2mm	15kg spool	MWFCGCF111215
1.6mm	15kg spool	MWFCGCF111615

OPERATIONAL INFORMATION

WIRE DIAMETER	WELDING CURRENT RANGE	ARC VOLTAGE RANGE*	TYPICAL STICKOUT
0.8mm	30-140 A	13-19V	9-12mm
0.9mm	30-155 A	14-21V	10-13mm
1.2mm	80-220 A	15-22V	13-15mm
1.6mm	180-300 A	16-24V	15-20mm

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