



SELF-SHIELD 11GS

SELF-SHIELDED FLUX-CORED WIRE
AWS E71T-GS

050428 (replaces 040601)

SELF-SHIELD 11GS offers extremely high operator appeal in applications involving thin gauge galvanized or carbon steels. Arc action is smooth and stable, excellent at low welding currents. DCEN (straight polarity) operation facilitates the welding of sections as thin as 18 gauge with little tendency for burn-through. Good wetting action makes SELF-SHIELD 11GS well-suited for the lap and butt joint welds encountered in body panel and sheet metal duct work. With vertical down welding, bead geometry and appearance are excellent; spatter levels are low. SELF-SHIELD 11GS is very well-suited for use in portable welding systems, as the small diameters perform well on portable 110-volt input welding machines. It is recommended only for single-pass welding and can be used in all positions using no shielding gas.

PRODUCT CHARACTERISTICS:

- Uses DCEN (straight polarity), minimizing burn-through
- Designed specifically for welding thin gauge galvanized steels
- Single-pass weldments on galvanized and carbon steel sheet metal, from 18 gauge up to 3/16".
- Very smooth arc, minimal spatter when applied to carbon steel

SPECIFICATIONS:

E71T-GS per AWS A5.20, ASME SFA 5.20
CWB E4801T-GS-CH

SHIELDING GAS:

None

WELDING POSITION:

All positions

STANDARD DIAMETERS:

.030", .035", .045", 1/16"

WELD TEST PARAMETERS:

SELF-SHIELD 11GS .045" diameter electrode was welded at 200 amps (190 IPM), DCEN, and 17 volts with 1/2" electrical stick-out. One weld bead was made in the flat position; the assembly was turned over and a second weld bead was deposited in the flat position on the opposite side of the assembly.

TYPICAL MECHANICAL PROPERTIES*:

Transverse Tensile Strength 83,000 psi (572 MPa), base metal fracture

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are obtained when welded and tested in accordance with AWS A5.20 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

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RECOMMENDED OPERATING PARAMETERS:

Diameter Electrical Stickout (ES) Position	Arc Voltage (volts)	Current DCEN (-) (amps)	Approx. Wire Feed Speed (in/min)	Deposition Rate (lbs/hr)
.030" 3/8" ± 1/2" Flat and Horizontal	16 18 19	25 125 200	55 225 565	0.3 to 5.4
.030" 3/8" to 1/2"	14 15	25 100	80 170	0.3 to
.035" 3/8" ± 1/2" Flat and Horizontal	13 18 19	50 150 225	65 250 465	0.6 to 6.3
.035" 3/8" ± 1/2"	13 18	75 150	52 250	0.6 to
.045" 3/8" ± 3/4" Flat and Horizontal	15 17 19	75 200 250	65 190 290	1.1 to 6.0
.045" 3/8" ± 3/4"	16 17	100 175	80 160	1.5 to
1/16" 1/2" ± 3/4" Flat and Horizontal	16 17 20	125 230 300	60 120 180	1.1 to 7.2
1/16" 1/2" ± 3/4" Vertical and Overhead	15 16 19	125 176 250	63 96 159	1.5 to 4.7

Bold: Optimum parameters for welder appeal.

Notice:

Actual use of the product may produce varying results due to conditions and welding techniques over which Corex has no control, including, but not limited to, plate chemistry, weldment design, fabrication methods, electrode size, welding procedure, service requirements and environment. The purchaser is solely responsible for determining the suitability of Corex products for the purchaser's own use. Any prior representations shall not be binding. Corex disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

Caution:

Consumers should be thoroughly familiar with the safety precautions shown on the Warning Label posted on each shipment in and in American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJeune Road, Miami, FL 33126, and OSHA Safety and Health Standards 29 CFR 1910, available from the U.S. Department of Labor, Washington, D.C. 20210.