



# Product Data Sheet

Prepared by	Approved by	PDS No & Rev.	Issue Date	Page
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## Coreshield 11

Self-shielded FCAW wire for mild steel and 490N/mm<sup>2</sup> class high tensile strength steel

### General

Coreshield 11 is excellent for use on single or multiple pass, lap, fillet and butt welds on mild steels in all welding position. It meets the requirements for classification E71T-11 in AWS specification A5.20, and offers smooth arc action, full slag coverage, easy slag removal, and low spatter. Bead appearance and weld edges are smooth and no shielding gas is required.

**Shielding Gas:** None

**Alloy Type:** C –Mn-Al

**Fill Type:** Self-Shield

### Classifications Weld Metal

### Approvals

ASME SFA/AWS A5.20 E71T-11  
ASME SFA/AWS A5.36 E71T-11-AZ-CS3  
JIS Z 3313 T49 T14-1NS

### Welding Parameters

Diameter	Position	Current (A) Range	Voltage (V) Range
1.2mm	Flat	95 ~ 220	15 ~ 18
	Vertical - up	95 ~ 220	15 ~ 18
1.6mm	Flat	160 ~ 275	17 ~ 19
	Vertical - up	160 ~ 275	17 ~ 19

\*DC Electrode Negative Polarity, Electrical Stick out: 13 ~ 25mm



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Chemical Composition of Weld Metal				Diffusible Hydrogen of Weld Metal		
All Weld Metal (%)						
	Min	Max	Typical			
C		0.30	0.22			
Si		0.60	0.33			
Mn		1.75	0.57			
P		0.03	0.008			
S		0.03	0.002			
Cr		0.20	0.02			
Ni		0.50	0.02			
Mo		0.30	0.01			
V		0.08	0.001			
Al		1.80	1.60			
Cu		0.35	0.013			

## Mechanical Properties of Weld Metal

Properties	All Weld Metal					
	Shielding gas : None					
	As welded			As welded		
	Min	Max	Typical	Min	Max	Typical
Yield Strength (MPa)	390		440			
Tensile Strength (MPa)	490	670	600			
Elongation (%)	22		25			
CVN Impact Value (J)						

## Standard Packaging

Diameter	Spool	Pail
1.2mm	12.5, 15kg	-
1.6mm	12.5, 15kg	-