

POWERCRAFT[®] T-11

GASLESS FLUX-CORED WIRE

For Mild and Galvanised Steel

TYPICAL APPLICATIONS

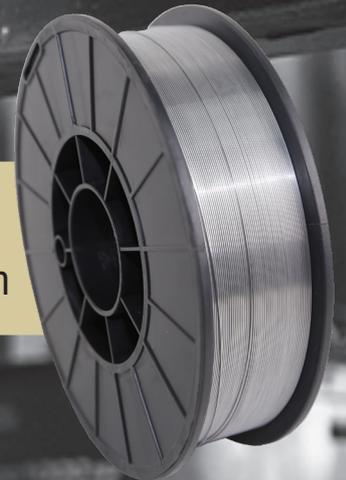
- ▶ Perfect for use on small portable MIG welding machines
- ▶ Ideal for general fabrication, rural and DIY
- ▶ Can be used in light to moderate wind conditions



1kg Spool
0.8 and 0.9mm



4.5kg Spool
0.8, 0.9 and 1.2mm



15kg Spool
1.2mm



KEY FEATURES

- ▶ No gas required
- ▶ Versatile – multi-pass and all positional
- ▶ Easy to use – low spatter and easy slag removal
- ▶ Precision layer wound enhances smooth wire feeding
- ▶ Vacuum foil-sealed for long shelf life*

* 4.5 kg and 15 kg spools

POWERCRAFT® T-11

GASLESS FLUX-CORED WIRE

For Mild and Galvanised Steel

POWERCRAFT® T-11 is an all-position self-shielded flux cored welding wire designed for thin mild and galvanised steel. The unique quality of this product is that you do not have to use a shielding gas. POWERCRAFT® T-11 produces a smooth arc with low spatter, easy slag removal, good bead appearance and multi-pass welding. It operates on DC negative polarity (DCEN). Available in 1 kg, 4.5 kg and 15 kg spools (depending on wire diameter). Conforms to AWS A5.20: E71T-11.

15kg Spool Specifications



Typical mechanical properties of weld deposit			Typical chemical analysis of weld deposit (%)					
Yield strength (Mpa)	Tensile strength (Mpa)	Elongation A4 (%)	C	Mn	Si	S	P	Al
≥390	490-670	≥20	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.80 max

Recommended welding parameters (DC-)				
Part Number	Wire diameter (mm)	Current (A)	Voltage (V)	Stick Out (mm)
14-111215	1.2	120-240	16-21	10-18

4.5kg Spool Specifications



Typical mechanical properties of weld deposit			Typical chemical analysis of weld deposit (%)					
Yield strength (Mpa)	Tensile strength (Mpa)	Elongation A4 (%)	C	Mn	Si	S	P	Al
≥390	490-670	≥20	0.30 max	1.75 max	0.60 max	0.03 max	0.03 max	1.80 max

Recommended welding parameters (DC-)				
Part Number	Wire diameter (mm)	Current (A)	Voltage (V)	Stick Out (mm)
14-110845	0.8	80-160	15-20	8-12
14-110945	0.9	100-160	15-20	8-12
14-111245	1.2	120-240	16-21	10-18

1kg Spool Specifications



Typical mechanical properties of weld deposit			Recommended welding parameters (DC-)				
Yield strength (Mpa)	Tensile strength (Mpa)	Elongation A4 (%)	Part Number	Wire diameter (mm)	Current (A)	Voltage (V)	Stick Out (mm)
≥390	490-670	≥20	14-110810	0.8	80-160	15-20	8-12
			14-110910	0.9	100-160	15-20	8-12

CUSTOMER ASSISTANCE POLICY

Lincoln Electric® business is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric® for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric® is not in a position to warrant or guarantee such advice and to the extent permitted by law assumes no liability, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has been given. The provision of information or advice does not create, expand or alter this warranty. Lincoln Electric® is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric® is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric® affect the results obtained in applying this type of fabrication methods and service requirements. Subject to Change – This information is accurate to the best of our knowledge at the time of printing.