

ArcStar 711

AWS A5.20 E71T-1C
EN758 T 42 2 P C 1 H10

Characteristics and Applications:

ArcStar 711 is a gas-shielded flux cored wire designed for mild steel and 490N/mm² high tensile steel. It is suitable for all position welding, especially straight up weld ability. It provides stable arc, less spatter, easy slag removable, and excellent X-Ray inspection. The typical applications include shipbuilding, vessels, piping etc.

Notes on Usage:

- (1) Use (DC+) polarity.
- (2) Use 100%CO₂, 20~25 l/min shielding gas.
- (3) Welding heat input must be controlled in order to get required impact value, since notch toughness tends to decrease due to excessive heat input.
- (4) Keep dry during handling and storage.

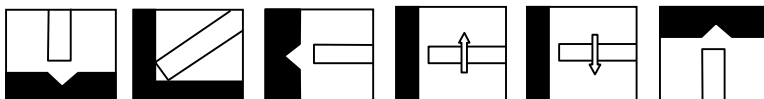
Typical chemical composition of weld metal(wt%)

	C	Mn	Si	P	S
100%CO ₂	0.04	1.35	0.30	0.017	0.007

Typical mechanical properties of weld metal

	YS (MPa)	TS (MPa)	EL %	CVN -20°C J
100%CO ₂	530	571	30	70

Welding position



Sizes and recommended current range (DC <+>)

Stick out: 15-20 (mm), gas flow rate: 20-25 (l/min)

Welding Parameters	Wire Dia.(mm)	1.2
F, HF		160A~300A, 22V~34V
VU, OH		150A~220A, 21V~26V
VD		250A~300A, 26V~34V
H		200A~260A, 23V~28V

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