

SUPERSHIELD 711

Flux Cored Welding Wire for High Tensile Steel

CHEMICAL COMPOSITION (%) ACCORDING TO AWS:

C	Si	Mn	P	S
0.04	0.55	1.25	0.015	0.011

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

YS (N/mm ²)	TS (N/mm ²)	EL (%)	I. V (J)	
			0°C	-20°C
520	580	29	70	55



APPLICATIONS & CHARACTERISTICS

It is suitable to weld high tensile steel of 490Mpa with excellent mechanical properties. Typical applications such as ship building, bridges, offshore structures and industrial machinery and general fabrication of steel structures.

Supershield 711 is titania (rutile) type flux cored wire for all – position welding. It provides stable arc, less spattering, good bead appearance, better slag removal. Low fumes and good impact strength at sub-zero temperature also.

WELDING POSITIONS

PA, PB, PF, PC, PE

WIRE DIAMETERS AVAILABLE & RECOMMENDED CURRENT RANGE.

Wire dia. (mm)		1.2	1.6
Flat H-Fillet	Amp. (A)	150 ~ 320	180 ~ 450
	Volt. (V)	22 ~ 34	25 ~ 38
V-up	Amp. (A)	140 ~ 250	180 ~ 280
	Volt. (V)	22 ~ 30	24 ~ 32
V-down	Amp. (A)	200 ~ 300	240 ~ 320
	Volt. (V)	22 ~ 34	25 ~ 36
Over Head	(Optimum Condition)		
	Volt. (V)	210 ~ 230	230 ~ 250
	Amp. (A)	22 ~ 26	24 ~ 30

Polarity & Shield Gas
CO₂ : 100% CO₂
DCEP (DC +)

STANDARD PACKAGING : 15 KG PLASTIC SPOOL



AWS : A5.20-07 E 71T-1C
ASME : SFA 5.20 E71T-1

SMOOTHARC 7018

Stick Welding Electrode for Mild Steel

APPLICATIONS & CHARACTERISTICS

SMOOTHARC 7018 is a low hydrogen Iron Powder type electrode for the welding of High tensile steel in ship building, bridges, building and storage tank and support structure of pressure vessel, etc. The welding can be done with excellent bead appearance, good X-ray quality and good impact strength and it has low hydrogen content and therefore it avoids hydrogen induced crack.



NOTE ON USAGE

- Redry the electrodes at 300 ~ 400°C for 1~2 hrs prior to use.
- Keep the arc as short as possible.

WELDING POSITIONS

PA, PB, PF, PC, PE

TYPICAL CHEMICAL COMPOSITION OR ALL WELD METAL (%):

C	Mn	Si	P	S
0.07	0.87	0.61	0.015	0.011

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

YS N/mm ²	TS N/mm ²	EL%	IV	J
480	570	30	0°C	-30°C
			221	70

ELECTRODE SIZES AND RECOMMENDED CURRENT RANGE

POLARITY : AC OR DC +

Dia (mm)		2.6	3.2	4.0	5.0
Length (mm)		350	350	400	400
Amps.	Flat	-	-	450	450
	V & OH	60~100	90~130	130~180	180~240
		50~80	85~120	110~160	150~180

AWS A5.1-04 : E7018
JIS Z 3211 : E 4918

STANDARD PACKAGING :

2.6 mm Dia }
3.2 mm Dia } 5kg / PKT
4.0 mm Dia }
5.0 mm Dia }

