

# 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**

0.9

- 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<sup>®</sup> 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<sup>®</sup> 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 strengt (Mpa)	h Elongation A4 (%)	С	Mn	Si	S	Р	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-)								
Par	t Number	Wire diameter (mm)	Current (A) Voltage (V)		Stick Ou	Stick Out (mm)			
14	111215	1.2	120-2	240	16-	21	10-	-18	
	ypical mechai Yield strength (Mpa) ≥390 Par	<b>15kg</b> ypical mechanical propertie Yield strength (Mpa) Tensile strengt (Mpa) ≥390 490-670 Part Number 14-111215	<b>15kg Spool Spec</b> ypical mechanical properties of weld depositYield strength (Mpa)Tensile strength (Mpa)Elongation A4 (%)≥390490-670≥20RecommenPart NumberWire diameter (mm) 14-1112151.2	<b>15kg Spool Specificat</b> ypical mechanical properties of weld depositTypYield strength (Mpa)Tensile strength (Mpa)Elongation A4 (%)C≥390490-670≥200.30 maxRecommended weldirPart NumberWire diameter (mm) 14-111215Curren 1.2	ISkg Spool Specifications   ypical mechanical properties of weld deposit   Yield strength Tensile strength Elongation A4   (Mpa) 490-670 ≥20   Recommended welding parameter   Part Number Wire diameter (mm) Current (A)   14-111215 1.2 120-240	Iskg Spool Specifications   ypical mechanical properties of weld deposit   Yield strength Tensile strength Elongation A4 (%) C Mn Si   ≥390 490-670 ≥20 0.30 max 1.75 max 0.60 max   Recommended welding parameters (DC- Part Number   Part Number Wire diameter (mm) Current (A) Voltage   14-111215 1.2 120-240 16-	<b>15kg Spool Specifications</b> ypical mechanical properties of weld depositTypical chemical analysis of weldYield strength (Mpa)Elongation A4 (%)CMnSiS≥390490-670≥200.30 max1.75 max0.60 max0.03 maxRecommended welding parameters (DC-)Part NumberWire diameter (mm)Current (A)Voltage (V)14-1112151.2120-24016-21	<b>15kg Spool Specifications</b> ypical mechanical properties of weld depositYield strength (Mpa)Elongation A4 (%)Typical chemical analysis of weld deposit2390490-670≥200.30 max1.75 max0.60 max0.30 max1.75 max0.60 max0.03 max0.03 max0.03 max1.75 max0.60 max0.03 max0.03 max0.03 max0.03 max1.75 max0.60 max0.03 max0.10 max1.75 max0.60 max0.03 max0.03 max1.75 max0.60 max0.03 max1.121.21.21.2	

# 4.5kg Spool Specifications

Typical mechanical properties of weld deposit			Typical chemical analysis of weld deposit (%)					
Yield strength (Mpa)	Tensile strength (Mpa)	Elongation A4 (%)	С	Mn	Si	S	Р	AI
≥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 med	Typical mechanical properties of weld deposit			Recommended welding parameters (DC-)					
Yield strengt (Mpa)	h 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

CUSTOMER ASSISTANCE POLICY Lincoln Electric<sup>®</sup> 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<sup>®</sup> 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<sup>®</sup> 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<sup>®</sup> is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric<sup>®</sup> 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.

Powercraft T-11 MIG Wire Brochure 202111

The Lincoln Electric Company (Australia) Pty. Ltd. 35 Bryant Street Padstow NSW 2211 Australia Ph: 1300 728 720 (AU) | 0800 728 720 (NZ) www.lincolnelectric.com.au

