

TECHNICAL SHEET

NG-T11



Product name

NG T11

Class of product

Self-shielded seamless flux cored wire

Description

Self-shielded seamless flux cored wire designed for all positions welding of low and medium alloyed steels. This wire is especially useful for on-site fabrication, structural or repair welding applications, single or multipass welding. Main features: excellent weldability, also vertical-up, excellent bead appearance, low spatter levels and easily removable slag. The copper coated surface provides high resistance to rust and the seamless technology grants low moisture pick-up with low content of diffusible hydrogen levels (<H8).

Applications

General fabrications, galvanized steels, structural welding and outdoor applications.

Corresponding standards

AWS A5.20: E71T-11

EN ISO 17632-A: T46 Z Y N1

Shielding gas

No Gas

Main properties of deposited weld metal

Rm=530-660 N/mm² – Rs>460 N/mm² – A%5Æ>22

C=0.25% - Mn=1.00% - Si=0.40% - P<0.025% - S<0.025% - Al=1.50%

HDM ml/100g<8

Current

D.C. -

Welding positions

AWS 1G 2F 2G 3Gup 3Gdown 4G 5Gup 5Gdown

EN PA PB PC PF PG PE PF PG

Materials to be welded

EN10207: P253S – P265S – P275SL

EN10025-2: S235JR – S275JR – S355JR

EN10025-3: S275N – S355N – S420N – S460N

EN10025-4: S275M – S355M – S420M – S460M

EN10028-2: P235GH – P265GH – P295GH – P355GH

EN10028-3: P275NH – P355NH – P460NH

EN10028-6: P355QH – P460QH

EN10208-1: L210GA – L235GA – L245GA – L290GA – L360GA – (X42) - (X52)

EN10208-2: L245NB – L245MB – L290NB – L290MB – (X42) – L360NB – L360QB – L360MB – (X52) –

L415NB – L415QB – L415MB – (X60) – L450QB – L450MB – (X65)

The above data are subject to change without notice by Spring.

Welding parameters

Diameter (mm)	Current (A)	Voltage (V)
0.80	30-110	13-16
0.90	30-120	14-17
1.00	50-200	15-18
1.20	100-260	18-26
1.40	120-300	20-27
1.60	150-350	20-30
2.00	300-450	20-44

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