AWS A5.20 E71T-1/9/12 C J
EN ISO 17632-A-T42 5 P C1 1 H5

HOBART® 711Pro

Rev 202601

Characteristics and Applications:

1. HOBART® 711Pro is an all-position flux-cored wire designed to be used for 490MPa high tensile steel under lower temperature application.
2. The weld metal contains about 0.40%-0.50% Ni and makes good V-notch impact toughness down to -50℃ and reliable -10℃ CTOD values under as-welded condition.
3. Typical applications of HOBART® 711Pro are wind tower structure, offshore platform and shipbuilding.

Notes on Usage:

1. Use DCEP(DC+) polarity.
2. Use 99.8% or higher purity of CO_2 as shielding gas.
3. The impact value tends to be reduced when heat input is excessive; perform with proper heat input depending on the required impact value.
4. Keep dry while in storage and delivery.

Typical Chemical Composition of Weld Metal (wt%)

	C	Mn	Si	P	S	Ni	Diffusible Hydrogen
AWS	≦0.12	≦1.75	≦0.90	≦0.03	≦0.03	≦0.5	-
Typical Value	0.028	1.28	0.22	0.007	0.007	0.46	3.8 mL/100g

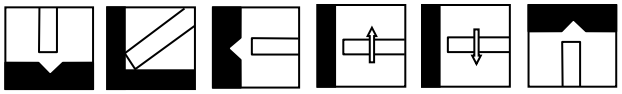
Typical Mechanical Properties of Weld Metal

	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf)	Hardness HV10
AWS	≧390(58)	490-670(70-95)	≧22	≧27(20) @-40°C(-40°F)	-
Typical Value	498(72)	551(80)	29	220(140)@ -40°C(-40°F) 180(133)@-50°C(-58°F)	187

CTOD Result of Butt Joint Coupon

Position	Base Metal	Groove Type	Temp. of Testing	δ (mm)
Vertical up	EH36, 90mm	K(60mm,30mm)	-10°C(14°F)	1.337/1.424/1.665

Welding Position



Sizes and Recommended Operating Range (DC＜+＞)

Stick Out:12-25(mm), Flow Rate:20-25(L/min), Inter-pass Temperature:135-180℃

Position \ Diameter (mm)	1.2	1.4
F HF	160A~300A / 22V~32V	160A~320A / 24V~34V
VU, OH	130A~250A / 22V~28V	140A~260A / 23V~30V

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brother Company expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results.
No data is to be construed as recommendation for any welding condition or technique not controlled by Hobart Brother Company.

HOBART FILLER METALS