AWS A5.20 E71T-1/9 C J
EN ISO 17632-A-T42 4 P C1 1

HOBART ® 711Ni

Characteristics and Applications:

HOBART ® 711Ni is a gas-shielded flux cored wire designed for mild steel and 490N/mm^2 high tensile steel. It is suitable for all position welding. It provides stable arc, less spatter, easy slag removable, and excellent X-Ray inspection. It provides good low-temperature impact value due to 0.4%Ni in weld metal. The typical applications include shipbuilding, offshore, vessels, piping etc.

Notes on Usage:

1. Welding Heat Input must be controlled to get the required impact value, since notch toughness tends to decrease due to excessive heat input.
2. Use DCEP(DC+) polarity.
3. Use 99.8% or higher purity of CO_2 gas.
4. Keep dry during handling and storage.

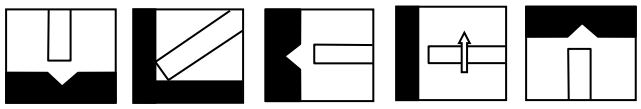
Typical Chemical Composition of Weld Metal (wt%)

	C	Mn	Si	P	S	Ni
AWS	≦0.12	≦1.75	≦0.90	≦0.03	≦0.03	≦0.5
Typical Value	0.037	1.41	0.42	0.013	0.009	0.43

Typical Mechanical Properties of Weld Metal

	Yield strength MPa (ksi)	Tensile strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf)
AWS	≧390(58)	490-670(70-95)	≧22	≧27(20) @-40°C(-40°F)
Typical Value	480(70)	560(81)	28	126(94)@ -40°C(-40°F)

Welding Position



Sizes and Recommended Operating Range (DCEP)

Stick Out:12-25(mm), Flow Rate:20-25(L/min), Inter-pass Temperature:135-165℃

Position \ Diameter (mm)	1.2
F/H/HF	160A~320A / 22V~32V
VU/OH	130A~260A / 22V~28V

* 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