

# Supershield 11

TYPE : Self-Shielded

AWS A5.20 /ASME SFA 5.20 E71T-11  
JIS Z3313 T49 T14-1 N A  
EN ISO 17632-A-T 42 Z Z Z N 1

## Applications

Supershield 11 is used where light structurals, short assembly welds, other general fabrications and galvanized steel fixtures, gate etc.

## Characteristics on Usage

Supershield 11 is an all position self-shielded flux cored wire designed for single & multi-pass welding of thin mild and medium tensile steels not exceeding 510MPa.

## Notes on Usage

① Do not use shielding gas.

## Welding Position



1G 2F 3G 4G  
(PA) (PB) (PF) (PE)

## Current

DC -

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.19	0.35	0.60	0.011	0.006	1.20

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)
520 (75,400)	590 (85,600)	21

## Approval

## I Packing

Dia. (mm)	1.0	1.2	1.4	1.6	Spool(kg)	15	20
(in)	.039	.045	.052	1/16	(lbs)	33	44

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.0 (.039)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F	80~200	160 ~ 220	170 ~ 250	180 ~ 280
V-up, OH	55~120	120~ 180	140 ~ 200	160 ~ 220