

SmoothCor™ 11

Description

SmoothCor 11 is a self-shielded, flux cored wire that performs exceptionally well in the downhand, vertical-up and overhead positions. The wire has been designed for those applications where the use of shielding gas is inappropriate and where impact toughness is not of prime concern. SmoothCor 11 is intended for semi-automatic and automatic welding of mild and galvanised steels in single pass and limited multiple pass applications.

SmoothCor 11 operates on DC electrode negative and welds with a very smooth running, spray type transfer which minimises burn-through and facilitates welding joints with gaps or poor fit up. Spatter is exceptionally low and together with the very wide operating window, good feedability and easy arc starting characteristics assures excellent operator appeal.

Application

SmoothCor 11 is well suited for butt, lap and fillet welds on mild and galvanised steels from 1.5mm through to 12mm. The versatility of SmoothCor 11 makes it an excellent selection for assembly and maintenance welding in all positions.

Welding Positions



Specifications

Flux Type Rutile

Classification:

AWS/ASME-SFA A5.20 E71T-11
AS/NZS ISO 17632 B-T 49 Z T11-1 N A-H15

Welding Current DC-

Recommended Shielding Gases: Not required

Chemical Composition, wt% - All-Weld Metal

Typical C	Si	Mn	P	S	Al
0.21	0.15	0.30	0.010	0.010	1.50

Mechanical Properties – All-Weld Metal

	Typical (as welded)
Yield strength	460 MPa
Tensile strength	620 MPa
Elongation	23%

Packaging Data

	0.9	1.2	1.6	2.0
Diameter (mm)				
Part No.	101109	101112	101116	101120
Type	Spool	Spool	Spool	Spool
Weight (kg)	4.5	15	15	15

Welding Parameters

Welding Position - Flat and Horizontal, Vertical and Overhead

Operating Range

Diameter (mm)	0.9	1.2	1.6	2.0
Current Range (amps)	60-220	80-240	130-300	180-350
Voltage Range (volts)	14-19	15-20	15-20	16-22
Electrode Stick-out (mm)	10-13	10-19	13-19	19-24

Optimum

Welding Position - Optimum Flat and Horizontal

Diameter (mm)	0.9	1.2	1.6	2.0
Wire Feed Speed (m/min)	5.7	4.8	2.8	1.9
Current (amps)	170	200	250	300
Voltage (volts)	16	17	18	18
Electrode Stick-out (mm)	10-13	10-19	13-19	19-24

Optimum

Welding Position - Optimum Vertical and Overhead

Diameter (mm)	0.9	1.2	1.6	2.0
Wire Feed Speed (m/min)	4.0	3.9	2.3	-
Current (amps)	125	170	170	-
Voltage (volts)	17	17	16	-
Electrode Stick-out (mm)	10-13	10-19	10-19	-

Distributed by

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