

Rutile flux cored wire for all position with less fume emission

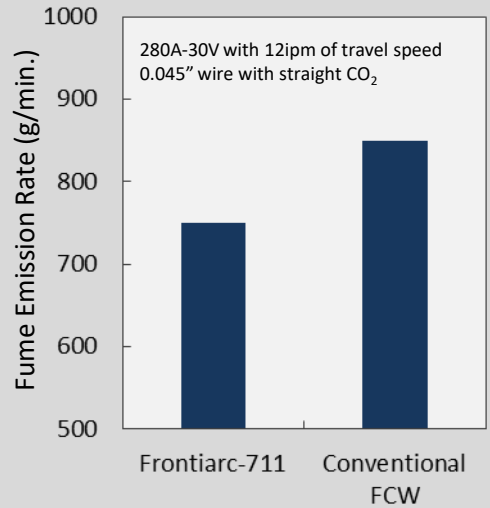
AWS A5.20 E71T-1C/M H8, 12C/M H8

CWB W48-06 E491T 9/9M H8



## Features and typical fields of application

- Frontiarc-711 is a mild steel flux cored wire for all position single pass and multi pass welding with straight CO<sub>2</sub> or 5%Ar-25%CO<sub>2</sub> mixed shielding gas.
- Its low fume emission, minimized spatter generation formula creates a clean welding environment at any welding condition.
- Frontiarc-711 is a right choice for shipbuilding, bridge construction, tanks, structural steel including seismic application and other general fabrication use with its versatile welder-friendly characteristics.



## Typical result of weld metal test per AWS A5.20 with straight CO<sub>2</sub>

C	Si	Mn	P	S	0.2% PS (ksi)	TS (ksi)	EL (%)	CVN (ft-Lbs)	
								-20F°	-0F°
0.05	0.50	1.28	0.013	0.009	72	82	29	43	72

## Diffusible Hydrogen Content per AWS A4.3

## Approvals

Frontiarc-711

5.0 mL/100g

ABS, CWB, LR, AWS D1.8

## Available Products

Wire Dia. 0.045", 0.052", 1/16"

Package 28Lbs spool, 44Lbs spool, 550Lbs Drum

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## Recommended welding conditions and deposition rate

Wire Dia.	Wire Feed Speed (in./min)	Current (A)	Arc Voltage (V)	Deposition Rate (Lbs/hr)	Wire Stick-Out (In.)
0.045"	140	120	23-26	4.0	3/4"
	200	160	25-28	6.0	
	290	200	27-30	8.0	
	330	220	27-30	9.0	
	400	250	28-30	10.5	
0.052"	120	140	24-27	3.5	3/4"
	175	180	24-27	5.5	
	265	240	26-28	8.5	
	300	260	27-29	10.0	1"
	395	300	29-31	11.5	
1/16"	100	180	24-27	4.5	3/4"
	165	240	25-28	7.0	
	190	260	26-29	8.0	1"
	250	300	29-31	10.0	
	300	340	30-32	11.5	

Table shown are approximate values that will vary depending on welding conditions (WESO, Cable length etc.).  
Arc voltage shown are for straight CO<sub>2</sub> shielding gas. For 75%Ar-25%CO<sub>2</sub> use two volts less than shown.

### DISCLAIMER

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- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



**WARNING:** This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

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