THY-J5011-GS (E71T-GS)

SELF-SHIELDED CARBON STEEL FLUX-CORED WIRE

Equivalent to AWS A5.20 E71T-GS
GB/T 10045 T49ZT11-1NSA

APPLICATION

Single-pass welding of lightweight structures and thin sheet outdoors.

CHARACTERISTICS

THY-J5011-GS is a 500 MPa class self-shielded flux-cored wire suitable for portable home welding.

PRECAUTIONS

Use DCEN (electrode negative). Maintain a wire extension of 20 mm. Remove oil and rust from the base metal before welding to reduce the risk of porosity. Follow the general operating instructions for self-shielded flux-cored wires.

WELDING POSITIONS



MECHANICAL PROPERTIES

Items	Yield strength (MPa)	Tensile strength (MPa)
Requirements	≥390	490-670
Typical results	520	581

DEPOSITED WELD METAL CHEMICAL COMPOSITION (%)

Items	C	Mn	Si	S	P	Al
Requirements	≤0.18	≤2.0	≤0.90	≤0.030	≤0.030	≤2.0
Typical results	0.16	0.83	0.23	0.010	0.011	1.59

TYPICAL OPERATING PROCEDURES

DCEN

Diameter (mm)	0.8	0.9	1.0
Voltage (V)	14-20	14-20	16-22
Current (A)	120-180	120-180	120-200

BRIDGE WELDING MATERIALS