

DUAL SHIELD II 711X

MILD STEEL
FLUX CORED WIRES

Tech Data Sheet



TYPICAL MECHANICAL PROPERTIES

Shielding Gas	AS WELDED	
	CO ₂	
Yield Strength, ksi (MPa)	78	540
Tensile Strength, ksi (MPa)	86	595
% Elongation (in 2", 51mm)	29	

TYPICAL CHARPY V-NOTCH IMPACT PROPERTIES

Shielding Gas	CO ₂	
	FT.-LBS.	(J)
Testing Temperature		
0°F (-18°C)	96	130
-20°F (-29°C)	79	107
-40°F (-40°C)	36	49

TYPICAL UNDILUTED WELD METAL ANALYSIS (%)

Shielding Gas	CO ₂
Carbon	0.04
Manganese	1.4
Silicon	0.4
Phosphorus	0.012
Sulfur	0.010

TYPICAL WELDING RANGE - Vertical up

Wire Feed Speed	Low	High
.045"	150	425
.052"	160	365
1/16"	110	240
Volts		
.045"	19.5	26.5
.052"	20.5	26.0
1/16"	21.5	26.0
Amps		
.045"	110	230
.052"	150	250
1/16"	135	242
Deposition (lbs/Hr)		
.045"	7.4	
.052"	8.7	
1/16"	8.8	

Typical Welding Parameters on reverse side of the sheet.

Applications

Civil Construction
Shipbuilding
Rail Road Car
Light Equipment
Heavy Equipment
General Fabrication

Welding Process

FCAW

Classifications/Approvals

AWS A5.20; E71T-1CJ/
T-9CJ/T-12CJ

ASME SFA 5.20

A.B.S.

Certified by C.W.B.- CSA W48

www.dualshieldx.com

GREAT THINGS HAPPEN WHEN YOU PUT US TO WORK.

801 Wilson Ave., Hanover, PA 17331 • 1.800.ESAB.123 • www.esabna.com



ESAB® ESAB Welding
& Cutting Products

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TYPICAL WELDING PARAMETERS

WFS	Gas: CO ₂ 0.045"		WFS	Gas: CO ₂ 0.052"		WFS	Gas: CO ₂ 1/16"	
	VOLT	AMP		VOLT	AMP		VOLT	AMP
150	19.5	110	160	20.5	150	110	21.5	135
178	20.2	122	181	21.1	160	123	21.9	146
205	20.9	134	201	21.6	170	136	22.4	156
233	21.6	146	222	22.2	180	149	22.8	167
260	22.3	158	242	22.7	190	162	23.3	178
288	23.0	170	263	23.3	200	175	23.7	188
315	23.7	182	283	23.8	210	188	24.2	199
343	24.4	194	304	24.4	220	201	24.6	210
370	25.1	206	324	24.9	230	214	25.1	221
398	25.8	218	345	25.5	240	227	25.5	231
425	26.5	230	365	26.0	250	240	26.0	242
Out-of-position welding applications								

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