



EAGLE 771-11

All Position Self Shielded Flux Cored Wire

APPLICATIONS

This premium wire was developed for welding mild steel in all positions without the use of gas.

PROCEDURE

Use DC Straight [-] Polarity. Use the grinding method or remove fatigued metal using the **EAGLE 188**. Use the lowest effective amperage while maintaining a 1/2" - 5/8" stick out length. Using the stringer bead technique for maximum strength.

GENERAL CHARACTERISTICS

The **EAGLE 771-11** is an all position flux cored wire designed to produce superior weldments on mild steel. Excellent on single or multiple pass welds up to 3/8". The soft stable arc and the fast-freeze weld puddle makes out of position welding easier to control and with very little spatter.

TECHNICAL DATA

Tensile Strength: Approx. 90,000 psi
Yield Strength: Approx. 63,000 psi
Elongation: Approx. 22%

WELDING PARAMETERS

Current:	DC Straight [-] Polarity		
Sizes:	Inches	0.45	1/16
	mm	1.20	1.60
Volts:	17 - 19	18 - 20	
Amperage:	150 - 180	200 - 220	
Wire Stickout:	1/2 inch	5/8 inch	



≡ HIGH QUALITY WELDING PRODUCTS ≡

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