

SELF-SHIELDED FLUX CORED WELDING WIRE

PACTCORE 11

PA	PB	PC	PD	PE	PF
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KEY FEATURES

- Self-shielded - no shielding gas required
- All-positional welding (vertical-down capable)
- Single and multi-pass applications
- Low spatter, full slag coverage, easy removal
- Excellent tolerance to poor joint fit-up
- Suited to mild and galvanised steels

DESCRIPTION & APPLICATION

PACTCORE 11 is a self-shielded flux-cored welding wire engineered for all-position fabrication and repair of mild and galvanised steels, built for jobs where shielding gas is impractical – farms, stations, workshops, and remote sites.

Typical applications include fences, gates, frames, water tanks, agricultural machinery repair, and general field maintenance on mild and galvanised steel fixtures.

CLASSIFICATION

AWS A5.20 / ASME SFA-A5.20

E71T-11

OPERATING POLARITY

DCEN (DC-)

OPERATIONAL DATA

Ø mm	Current A	Voltage V	ESO mm
0.8	90-140	14-20	10-15
0.9	100-150	14-20	10-15
1.2	120-180	16-20	15-20

**Voltage is determined by arc current and wire arc length. Arc voltage may also vary based on torch condition and machine type. The parameters listed above are intended as a practical operational guide.*

CHEMICAL ANALYSIS - DEPOSITED METAL (%)

C	Mn	Si	P	S	Al	Ni	Cr
0.09	0.89	0.46	0.016	0.011	1.47	0.13	0.02

MECHANICAL PROPERTIES

Yield strength (R _{eL})	470 MPa
Tensile strength (R _m)	560 MPa
Elongation (A ₅)	22 %

PACKAGING

SKU	Ø	Spool	Net weight
PC11-0801	0.8 mm	Plastic	1 kg
PC11-0805	0.8 mm	Plastic	5 kg
PC11-0901	0.9 mm	Plastic	1 kg
PC11-0905	0.9 mm	Plastic	5 kg
PC11-1205	1.2 mm	Plastic	5 kg

Vacuum-sealed in moisture-barrier film. Batch-specific MTC available on request.

The information contained herein is presented as typical data derived from representative batch testing per AWS A5.20. Actual results depend on base metal composition, joint preparation, welding parameters, operator skill, and other factors beyond Pacton's control. Users are responsible for verifying suitability of this product for their specific application and for qualifying welding procedures accordingly. To the extent permitted by law, Pacton disclaims all liability for product misuse, application selection, or reliance on this data. Pacton reserves the right to modify specifications without prior notice.

CONTACT
pactonwelds.com
trade@pactonwelds.com