

KCL-11

AWS E6011
JIS D4311
KS E4311

FOR CARBON STEEL

Typical applications

Welding of steel sheets, pipes in building and shipbuilding.

Coating

High cellulose type.

Characteristics on Usage

- ① As the welding in poor groove fit up and vertical-down welding can be performed easily, it is used in all position welding of pipes.
- ② Good mechanical properties and the weld metal meets requirement X-ray.
- ③ Redry the electrode at 70~80°C for 30~60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	P	S
0.08	0.37	0.66	0.015	0.013

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (-29°C)
410 {42}	500 {51}	24	50 {5}

Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	2.6	3.2	4.0	5.0	
Length (mm)	300	350	350	350	
Amp.	F	50~80	70~110	110~150	160~200
	V&OH	40~70	60~100	90~130	140~170

Welding positions



Approved by

ABS, CWB, DNV, LR, JIS