

Covered Electrodes

KCL-11

For 420MPa mild steel

Classifications

EN ISO 2560-A:2006	: E 38 2 C 12	KS D 7004	: E4311
EN ISO 2560-B:2006	: E 43 11 A	JIS Z 3211	: E4311
AWS A5.1-04	: E6011		

Description

- Covering is high cellulose type for welding of steel sheets, pipes in building or shipbuilding.
- 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.
- Good mechanical properties and the weld metal meets requirement X-ray.
- Gives high ductility root weld and easy slag removal.
- Redry the electrode at 70-80°C for 30-60 minutes prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.08	0.31	0.58	0.017	0.018	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.1	min. 330	min. 430	min. 22		≥ 27	
EN ISO 2560-A	min. 380	470-600	min. 20	≥ 47		
Example	410	500	24	60	40	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

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

Approvals

ABS	BV	GL	LR
3,E6011	3	3	3m

* Others : JIS, CE