

KT-411

Classification

AWS	A 5.1/A5.1M	E6011/E4311
JIS	Z3211	E4311
EN	2560-A	E35 0 C 1 1
GB	T5117	E4311

Type of coating : High cellulose type

Applications and Features

- (1) Designed for welding root pass of pipeline with DC and AC polarities.
- (2) Strong arc force, deep penetration, fast-freeze slag and good weldability.
- (3) Typical applications are high pressure pipes, oil tanks, boilers and outdoor welding.

Welding position



Welding Instruction

- (1) Please refer to Appendix A

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.11	0.27	0.66	0.019	0.007

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
			°C	J
N/mm ²	N/mm ²	%		
500	437	25	0	88
			-20	55

Size and Suggested Operating Range (AC or DC±)

Diameter (mm)		2.4	3.2	4.0
Current (A)	AC	40~90	65~120	115~150
	DC±	40~80	60~110	105~135