

SMAW Electrodes

G11

AWS A5.1M E4311 / A5.1 E6011
JIS Z 3211 E4311
ISO 2560-A-E 35 3 C

Product Features:

- High cellulose type covered electrode for mild steel.
- High arc penetration and concentration.
- Fast solidification of weld metal, good for all positions in limited space and especially on vertical and overhead position.

Applications:

- Suitable for moderate thickness steel work one side butt joint root pass.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.13	0.22	0.48	0.024	0.010	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-30°C) J
423	509	26	56

Size (mm) & recommended welding parameters (A) DC+

Diameter / Length	3.2/350	4.0/350	4.8/350	5.0/350
Flat position	75~110	120~160	150~200	160~210
Vertical / overhead position	60~90	105~145	120~170	130~180

Note:

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