

## FERROCRAFT 11

65  
OCVDC  
AC

- ▲ Cellulose Pipe Welding Electrode.
- ▲ All Positional, AC / DC Capabilities.
- ▲ High Penetration, Root Pass Applications.
- ▲ WHITE flux colour for easy I.D.

## Classifications:

AS/NZS 1553.1: E4111-2.  
AWS/ASME-SFA A5.1: E6011.

## Description and Applications:

Ferrocraft 11 is a cellulose electrode suitable for high penetration welding applications using both AC and DC power sources.

The deep penetration and fast freezing weld metal of Ferrocraft 11 make it ideal for the all positional (including vertical up/down and overhead) root pass welding of full penetration joints. A small iron powder addition to the Ferrocraft 11 flux coating gives it improved arc stability and smoother arc transfer.

Ferrocraft 11 is recommended for root pass welding where the 'stovepipe' or 'flick' techniques can be used to achieve full root penetration. Typical applications include the root, hot, fill and capping pass welding of pipelines, pressure vessels, storage tanks, workshop and field constructions.

## APPROVALS:

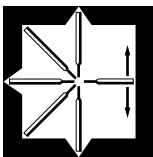
Lloyds Register of Shipping	Grade 3, 3Y.
American Bureau of Shipping	Grade 3.
Det Norske Veritas	Grade 3.
American Bureau of Shipping	AWS A5.1 E6011.

## TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	415 MPa
Tensile Strength	500 MPa
Elongation	28%
CVN Impact Values	90J av @ -20°C.

## TYPICAL ALL WELD METAL ANALYSIS:

C: 0.12%	Mn: 0.47%	Si: 0.10%
S: 0.007%	P: 0.011%	



All positional - welding

## Packaging and Operating Data:

AC (minimum 65 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	62	65-85	5kg	15kg - 3 x 5kg	611132
3.2	380	33	95-125	5kg	15kg - 3 x 5kg	611133
4.0	380	22	130-160	5kg	15kg - 3 x 5kg	611134