



PRODUCT DATA SHEET

CELLULOSE ELECTRODES

WCD 6100

Austarc 11



SUMMARY

- > High Cellulose Coating
- > All Positional/High Penetration
- > Ideal for Site Welding

IDENTIFICATION

Coating - White **Tip** - Brown **Imprint** - WIA 4311A

CLASSIFICATION

- > AS/NZS 4855-B - E43 11 A
- > AWS A5.1: E6011

DESCRIPTION AND APPLICATION

Austarc 11 is a high cellulose electrode developed for all positional welding on both AC and DC power supplies.

Features include: Forceful, deep penetrating arc with fast freezing slag. Particularly suited for vertical and incline pipe welding where complete root penetration is required. The thin brittle slag is easily removed.

Austarc 11 is recommended for specific applications including pipeline welding and storage tank construction where either the "Stove Pipe" or "Flick" techniques can be used to obtain full root penetration in critical structural joints.

OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELDING CURRENT RANGE *(A)	ARC VOLTAGE RANGE **(V)
2.5	300	60 - 95	20
3.2	380	90 - 125	21
4.0	380	115 - 175	22
5.0	450	160 - 220	23

*Recommended for DC +/- or AC (minimum 70 OCV) operation.
 **Voltage is determined by arc current and electrode arc length.
 Arc voltage shown is typical and is only to be used as a guide.

SHIPPING APPROVAL

LR 3M ABS 3

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	P	S	Fe
0.12	0.82	0.20	0.012	0.008	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Yield Stress	416 MPa
Tensile Strength	510 MPa
Elongation	32%
CVN Impact Values	70J @ -30°C

PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING (KG)		APPROX. NO. OF RODS PER KG	PART NO.
	PACKET	CARTON		
2.5	2.5	12.5	66	1125
3.2	5.0	15	33	1132
4.0	5.0	15	21	1140
5.0	5.0	15	14	1150

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