

Ferrocrafter 11

65
OCV

DC
AC



- Cellulose Pipe Welding Electrode
- All Positional, AC / DC Capabilities
- High Penetration, Root Pass Applications
- WHITE flux colour for easy ID
- Recommended for root pass welding where the “stovepipe” or “flick” techniques can be used to achieve full root penetration
- The root, hot fill and capping pass welding of pipelines, pressure vessels, storage tanks, workshop and field construction

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%

Approvals:

Lloyds Register of Shipping	Grade 3, 3Y
American Bureau of Shipping	Grade 3
Det Norske Veritas	Grade 3

Classifications:

AS/NZS 4855: (new)	B E4311 A
AS/NZS 1553.1: (old)	E4111-2
AWS/ASME-SFA A5.1:	E6011

Packaging and Operating Data:

Electrode		Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
Size mm	Length mm					
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

AC (minimum 65 OCV) DC+ or DC- polarity.