

COVERED ELECTRODES FOR MILD STEEL

DESCRIPTION & APPLICATIONS :

- SC-11 is a high cellulose all-positional electrodes designed for deep penetration on root and filler layers of butt. Less spatter and good slag removability.
- Excellent on rusty or oil dust steel surface welding, but without defect of porosity or slag undercut.
- It is suitable for high pressure pipeline, storage tank or narrow groove type welding.

NOTE ON USAGE :

- Keep away heat and high humid ambient. Rebake the electrodes at 70~80°C for 30~60 minutes prior to use.
- Recommended with low current welding, when moving range of the electrodes should be controlled within 2.5 times of the electrode's diameter while welding with weave method.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S
0.142	0.26	0.23	0.015	0.009

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YP N/mm ² (Kgf/mm ²)	TS N/mm ² (Kgf/mm ²)	EL %	IV -30 °C J(Kgf-m)
428(43.7)	498(50.8)	27	50(5.1)

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	350	350
Amp.	F	80-120	110-170	150-200
	V & OH	70-110	90-150	-