

CLASSIFICATION

EN ISO 2560-A : E 42 2 C 11
AWS A5.1 : E6011

GENERAL DESCRIPTION

L-11 is an easy to strike cellulosic coated electrode. Arc welding may be done with either AC or DC current. Excellent molten pool control due to easily-removable, low-volume slag and gaseous arc shielding eliminates porosity problems in weld beads. In all positions, it enables notch-free, smooth weld beads of high penetration. It also minimizes problems that frequently occur in the welding of rusty or oily steels.

APPROVALS

GOST, SEPRO, TSE

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

| C | Si | Mn |
|------|------|------|
| 0.09 | 0.30 | 0.60 |

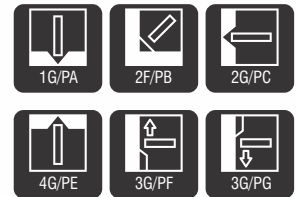
MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | |
|-------------------|-------------------------|
| Yield Strength | : 420 N/mm ² |
| Tensile Strength | : 540 N/mm ² |
| Elongation (L=5d) | : 25 % |
| Impact (ISO-V) | : 45 J (- 29°C) |

WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : AC min 50 V ; DC (+)

| Diameter [mm] | Length [mm] | Current [A] | | | Electrode Weight [g/100 pcs] | Box Weight [kg] Quantity [pcs/box] | Export Box Box Weight [kg] |
|--------------------|------------------|-------------|-----------|------------|-----------------------------------|---|---------------------------------|
| | | Root Pass | Hot Pass | Cover Pass | | | |
| 2.50 | 350 | 40 - 80 | - | - | 1680 | 5.4 / 325 | 5 |
| 3.25 | 350 | 80 - 100 | 100 - 125 | 80 - 100 | 2950 | 4.7 / 160 | 5 |
| 4.00 | 350 | 110 - 130 | 115 - 140 | 110 - 130 | 4000 | 4.4 / 110 | 5 |



APPLICATIONS AND MATERIALS TO BE WELDED

Site welding of pipe and pipelines made particularly from unalloyed structural steels; ship building; storage tanks, boiler and pressure vessel manufacturing and steel constructions are among its application areas. L-11 can be used in applications requiring high penetration. It can also be used for the root and deposit pass. As it is an easy to bend electrode, it brings great convenience to reach in difficult-to-reach areas. L-11 is an ideal electrode for welding in vertical downwards position.

| | DIN | EN |
|--|--|--|
| General Structural Steels | St 33, St 35, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4 | S185, S235, S275, S355 P235TR2 - P355T2 |
| Fine Grained Steels | StE 255 - StE 355 WStE 255 - WStE 355 | S255N - S355N P255NH - P355NH |
| Pipe Materials | StE 240-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X56 (API 5LX) | L245NB - L360NB L290MB - L360MB - |
| Boiler and Pressure Vessel Steels | 17 Mn 4 H1, H11, H111 | P295GH P235GH, P265GH, P285NH |
| Elevated Temperature Steels | St 35-8, St 45-8 | P235G1TH - P255G1TH |
| Ship Plates | A, B, C, D, E | - |
| Cast Steels | GS-38 - GS-45 | GE200, GE240, GE260 |

Liability : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.
Fumes : Consult information on Welding Safety Sheet, available upon request.

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