



PRODUCT DATA SHEET

WCD 7031 HIGH CELLULOSE ARC WELDING ELECTRODES

AUSTARC 11



- ▶ High Cellulose Coating
- ▶ All Positional/High Penetration
- ▶ Ideal for Site Welding, Full Root Penetration

Identification

Coating - Brown

Tip - Brown

Imprint - WIA 4311A

Classifications

AS/NZS 1553.1 E4111 Grade 3 (Superseded)

AWS A5.1 E6011

AS/NZS 4855 ISO 2560B E4311A*

*New classification replaces AS/NZS 1553.1

Description & Applications

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 * (amps)	ARC VOLTAGE RANGE (volts)**
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 are typical and are only to be used as a guide.

Approvals

LRS 3M

ABS 3

Typical All Weld Metal Chemical Analysis

C	Mn	Si	Fe
0.13	0.5	0.1	Bal

Typical All Weld Metal Mechanical Properties

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

In as welded condition.

Packaging Data

ELECTRODE SIZE (mm)	PACKAGING (KG)		APPROX NO OF RODS PER KG	PART NUMBER
	Packet	Carton		
2.5	2.5	12.5	66	1125
3.2	5	15	33	1132
4.0	5	15	21	1140
5.0	5	15	14	1150

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

Issue AB

15/04/2008

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