

Stick Electrode for Mild Steel

KT-411

Classification

AWS A 5.1/A5.1M
JIS Z3211
EN ISO 2560-A
GB T5117

E6011/E4311
E4311
E35 3 C 1 1
E4311

Coating Type: High cellulose

Applications and Features

- (1) KT-411 is a high cellulose type electrode for mild steel.
- (2) Excellent X-ray quality welds and good root pass operability.
- (3) Fast-freezing slag, light slag, easy slag removal, and deep penetration.
- (4) No slag inclusion and good porosity resistance when base metal with rust, oil and zinc primer.
- (5) Ideal for welding pipeline, shipbuilding, oil tank, and boiler.

Welding Position



Welding Instruction

Please see Appendix A

Typical Weld Metal Composition (wt%)

C	Si	Mn	P	S
0.11	0.27	0.66	0.019	0.007

Typical Weld Metal Mechanical Properties

Tensile strength	Yield strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
500	437	25	-30	55

Available Sizes and Welding Parameters (AC/DC+)

Diameter (mm)		3.2	4.0	5.0
Current (A)	F/HF	70~110	80~140	160~210
	V-up/OH	60~90	80~110	-