

JACKSUN XCEL-11

HIGH CELLULOSIC ELECTRODE FOR PIPE WELDING

BASIC ALLOY: C, FE, MN
AWS/SFA-5.1: E6011
EN ISO 2560-A E 42 3 C 15

KEY FEATURES:

High cellulose coated, potassium type electrode for pipe welding in DC (+) as well as AC current condition. Forceful and spray arc, ensures deep penetration and Weld metal is of radiographic quality. Slag system that is a fast freezing, thin and easy removable

APPLICATIONS

- site welding of pipes and pipelines in all positions
- using stove pipe and conventional techniques particularly for root bead.

RE-DRY CONDITIONS:

- Not recommended

CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.20 max.	0.40-0.80	0.30 Max	0.030 Max	0.030 Max

MECHANICAL PROPERTIES

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
330-450	430-560	22-30	- 3C : 50-80 J

WELDING POSITION

1G/1F



2G/2F



3G UP



3G DOWN



4G



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/ AC) Amps	Kg/pkt.	Kg/Case
2.50/ 2.40	3/ 32"	50-80		
3.15/ 3.20	1/ 8"	80-130		
4.00	5/ 32"	110-160		