

Overview

Special Low-Alloy Maintenance Rod

A maintenance-engineered electrode for the maintenance welder's problems. Designed with strength, elongation and special fluxing properties to be a great general-purpose alloy for everyday general maintenance application for mild and low alloy steels. Unique controlled hydrogen coating prevents cracking.



311 Electrode



311M-FC MIG Wire

Features/Benefits

- All-position, easy-to-use electrode
- Tough, yet fully machinable
- Superior moisture-resistant coating
- Excellent results on free machining or high sulfur steels
- Easy deslagging
- High elongation for tough jobs

Applications

- Agricultural equipment repairs
- Block racks and trays
- Structural beams and supports
- Carbon steel plate and pipe
- Truck body and frame
- Pipes and flanges
- Channels and tubes
- Shaft buildup

Method of Application

DC reverse polarity

Identification

Printed gray electrode

Directions for Use

Maintain close arc or contact technique on horizontal fillets. On heavy section joining, bevel or chamfer a "V" groove for a safe, strong, lasting weld.

Technical Specifications

Tensile Strength: To 78,000 PSI (538 MPa)
Yield Strength: 65,000 PSI (448 MPa)
Elongation: To 30%

Technical Specifications

Reverse polarity will produce deeper penetration, while straight polarity will promote flat, less penetrating deposits. Some difficulty with arc stability may be experienced on low open-circuit voltage "buzz-box" type machines. If a DC machine is not available, use 338 Electrode.
For 311M-FC typical operating parameters refer to Product Information Report – Typical Operating Parameters.