

## Applications

Mills to crush clinker in cement industry, screws of crushing grains in oil industry.

## Characteristics on Usage

S-711 is highly resistant to abrasion without impacts. S-711 is an electrode depositing weld metal of austenite structure which is harder than that of S-700B.B.

- This electrode deposits weld metal of austenite structure containing Cr-Carbide.
- Machining is impossible 'as-welded' .

## Notes on Usage

- ① Preheat at 150°C(302°F) or more than that in general.
- ② Weave during welding in the width of approx. 50mm.
- ③ Avoid excessive dilution.
- ④ Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.

## Welding Position



1G 2F  
(PA) (PB)

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr
3.47	0.90	1.11	0.018	0.014	33.87

## Typical Mechanical Properties of All-Weld Metal

Preheat & Interpass Temp. °C(°F)	Hardness (HB)
≥300 (572)	610

## Approval

## I Packing

Packet 5 kg (11 lbs)  
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	400 (16)	400 (16)	400 (16)
F	110~160	160~200	200~260