



6011

DESCRIPTION: 6011 electrodes have the same characteristics as 6010; however unlike the 6010, this electrode may be used with small AC welders as well as DC types. 6011 high cellulose coated electrodes provide excellent arc stability, increased ductility, high deposition efficiency and low spatter. This electrode combines a strong arc force with fast solidification of weld metal, thereby permitting vertical or overhead as well as flat and horizontal welding positions. 6011 is especially suited for welding where poor groove fit-up and rusty or oily steel is present.

SPECIFICATIONS: ANSI/AWS A5.1 & ASME SFA 5.1 E6011

NOMINAL COMPOSITION OF WELD METAL:

Carbon	.08 %	Manganese	.45%
Silicon	.18 %	Iron	Balance
Phosphorus	.014 %	Sulfur	.015 %

TYPICAL MECHANICAL PROPERTIES AS WELDED:

Tensile Strength	72,000 psi	Yield Strength	up to 66,100 psi
Elongation % in 2"	29.6		

*** RECOMMENDED WELDING PARAMETERS:**

		<u>3/32 X 12</u>	<u>1/8 X 14</u>	<u>5/32 x 14</u>
AMPS	Flat	50-80	70-110	110-160
	Vertical/overhead	40-70	60-100	90-140

* All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.