

SUREWELD 6011 AWS A5.1: E6011

FEATURES

Sureweld 6011 is an all-position, cellulosic type electrode designed for AC. It produces an easily controlled forceful arc with deep penetration and a high quality weld metal which will pass specification requirements for radiography.

Sureweld 6011 is used primarily for welding mild steels such as ASTM A-36, A-283, A-284, A-285, A-515, A516 and ABS Hull and boiler Steel. Typical applications include welding of buildings, piping, shipbuilding, pressure vessels and tanks. AC-DCEP (Electrode Positive)

TYPICAL MECHANICAL PROPERTIES

As Welded	
Yield Strength	67 ksi, 462 MPa
Tensile Strength	76 ksi, 524MPa
Reduction in Area	56%
Elongation in 2"	22%

CLASSIFICATIONS AND APPROVALS

- AWS A5.1: E6011
- SFA 5.1

WELD METAL ANALYSIS

C	0.10%
Mn	0.36%
Si	0.15%
P	0.012%
S	0.016%

WELDING PROCESS

- SMAW (Stick)

INDUSTRIES

- General Fabrication
- Mobile Equipment
- Barges

SUREWELD 6011

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DEPOSITION TABLE

Diameter in (mm)	Optimal Current Amps	Current Range Amps	Deposition Rate lb/hr (kg/hr)	Efficiency %
3/32 (2.4)	70	60 - 80	2 (0.9)	60
1/8 (3.2)	100	85 - 120	2.4 (1.1)	70
5/32 (4.0)	140	140 - 175	3.7 (1.7)	77
3/16 (5.0)	200	170 - 210		

PART NUMBER / PRODUCT INFORMATION

Part Number	Description	UPC
812000073	SW 6011 3/32X14X5#VALP	662303202835
812000081	SW 6011 3/32X14X44#CTN	662303202842
812000099	SW 6011 1/8X14X5#VALP	662303202859
812000107	SW 6011 1/8X14X44#CTN	662303202866
812000115	SW 6011 5/32X14X5#VALP	662303202873
812000123	SW 6011 5/32X14X44#CTN	662303202880
812000131	SW 6011 3/16x14x44#CTN	662303202897