

Sureweld 6011

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).

Specifications	
Classifications	ASME SFA 5.1 : E6011 AWS A5.1 : E6011
Industry	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Welding Current	AC, DC+
Alloy Type	Carbon Manganese

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	465 MPa (67 ksi)	557 MPa (81 ksi)	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-30 °C (-22 °F)	43 J (32 ft-lb)

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
0.10	0.36	0.15	0.012	0.012

Deposition Data			
Diameter	Current	Deposition Efficiency (%)	Deposition Rate @ 90% I max
2.4 x 356.0 mm (3/32 x 14.0 in.)	60-80 A	61.0 %	0.59 kg/h (1.3 lbs/h)
3.2 x 356.0 mm (1/8 x 14.0 in.)	85-120 A	70.7 %	1.04 kg/h (2.3 lbs/h)
4.0 x 356.0 mm (5/32 x 14.0 in.)	140-175 A	77.0 %	1.68 kg/h (3.7 lbs/h)
4.8 x 356.0 mm (3/16 x 14.0 in.)	170-210 A	74.2 %	2.27 kg/h (5.0 lbs/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	170-210 A	73 %	1.8 kg/h (4.0 lbs/h)