

# FLEETWELD® 180

Mild Steel, Cellulosic ▪ AWS E6011

## KEY FEATURES

- Performs on low amperages and OCV
- Easy to strike arc
- AC polarity welding

## TYPICAL APPLICATIONS

- Welding on galvanized and specially coated steels
- Small AC welders
- Sheet metal
- Edge, corner and butt joints

## CONFORMANCES

AWS A5: E6011  
CWB/CSA: E4311

## WELDING POSITIONS

All

## DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	1 lb (0.5 kg) Plastic Tube 6 lb (2.7 kg) Master Carton	5 lb (2.3 kg) Plastic Tube 20 lb (9.1 kg) Master Carton*	50 lb (22.7 kg) Easy Open Can
3/32 (2.4)	12 (300)	ED031152, ED033494*	ED033496	ED010110
1/8 (3.2)	14 (350)	ED031722, ED033495*	ED033497	ED010105
5/32 (4.0)	14 (350)			ED010114

\* NOTE: Retail Small Packaging (RSP). All RSP products carry AWS compliance. Unlike the standard products, RSP products have no other agencies approvals.

## MECHANICAL PROPERTIES<sup>(1)</sup> – As Required per AWS A5.1

	Yield Strength <sup>(2)</sup> MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft·lbf) @-29°C (-20°F)
Requirements - AWS E6011	330 (48) min	430 (60) min	22 min	27 (20) min
Typical Results <sup>(3)</sup> - As-Welded	460-490 (67-71)	570-590 (83-86)	22-32	35-72 (26-53)

## DEPOSIT COMPOSITION<sup>(1)</sup> – As Required per AWS A5.1

	%C	%Mn	%Si	%P	%S
Requirements - AWS E6011	0.20 max	1.20 max	1.00 max	Not Specified	Not Specified
Typical Results <sup>(3)</sup> - As-Welded	0.13-0.20	0.44-0.71	0.23-0.45	0.009-0.014	0.005-0.008
	%Ni	%Cr	%Mo	%V	
Requirements - AWS E6011	0.30 max	0.20 max	0.30 max	0.08 max	
Typical Results <sup>(3)</sup> - As-Welded	≤ 0.03	≤ 0.03	≤ 0.01	≤ 0.01	

## TYPICAL OPERATING PROCEDURES

Polarity <sup>(4)</sup>	Current (Amps)		
	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)
AC	40-90	65-120	115-150
DC±	40-80	60-110	105-135

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>Measured with 0.2% offset. <sup>(3)</sup>See test results disclaimer <sup>(4)</sup>Preferred polarity is listed first.