

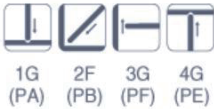
## E6011

AWS A5.1 E6011  
ISO2560-A E38 0 C 1 1  
GB/T5117 E4311

### Description:

Cellulose type electrodes for all positional welding with excellent vertical down welding performance and stronger arc force and deeper penetration. Suitable for butt welding, fillet welding and lap welding of plant chimney, transformer tanks, ships and external low carbon steel sheet structures of vehicle etc.

### Welding Position:



### Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	490
Yield strength(MPa):	400
Elongation (%):	28
Impact values( $\geq 47$ )/(-30°C):	100

### Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.077	0.73	0.016	0.017	0.15	0.024	0.016	0.002	0.009

### Welding Current: (AC/DC+)

Diameter(mm)	2,5	3,2	4,0	5,0
Current/A F/H	60-90	70-110	110-150	150-200
Current/A V/OH	50-80	60-100	100-140	140-180

### Note:

1. The electrode get damp easily, please stock it in dry environment.
2. Please bake the electrodes 30-60 minutes in 70°C before using if they are becoming damp.