

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

<b>Welding Current</b>	AC, DC+
<b>Alloy Type</b>	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 )