

S-6011.D

TYPE : Cellulosic

AWS A5.1 / ASME SFA5.1 E6011
JIS Z3211 E4311
EN ISO 2560-A - E38 3 C 1 5

Applications

S-6011.D can be used for welding of thin steel sheets and pipes.

Characteristics on Usage

With good weldability in poor groove, up and vertical downward welding can be performed easily, it is suitable for all position welding of pipes.

Notes on Usage

- ① Pay attention not to use currents exceeding the recommended currents.
- ② As this electrode is prone to absorb moisture, store it with care.

Welding Position



5G Up/Down

(PF.PG)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.11	0.16	0.51	0.015	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
468 (68,000)	558 (81,000)	29.7	-30 (-22)	51 (38)

Approval

KR, ABS, LR, BV, DNV, GL, NK

Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	350 (14)	350 (14)	350 (14)
F,V-down	50~75	70~110	110~155	155~200
V-up	35~70	55~105	90~140	120~180

Diam.	Pack/Carton	Part No.
2.5mm	5kg/ 20kg	HCS601125
3.2mm	5kg/ 20kg	HCS601132
4.0mm	5kg/ 20kg	HCS601140

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