

Cellulosic Coated Electrode for Mild Steels

Classification

EN ISO 2560-A : E 42 2 C 11
 AWS A5.1 : E6011

General Description

AS S-6011 is an easy to strike cellulosic coated electrode. Arc welding may be done with either AC or DC current. Excellent molten pool control due to easily-removable, low-volume slag and gaseous arc shielding eliminates porosity problems in weld beads. In all positions, it enables notch-free, smooth weld beads of high penetration. It also minimizes problems that frequently occur in the welding of rusty or oily steels.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn
0.09	0.30	0.60

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 420 N/mm ²
Tensile Strength	: 540 N/mm ²
Elongation (L=5d)	: 25 %
Impact (ISO-V)	: 45 J (-29°C)

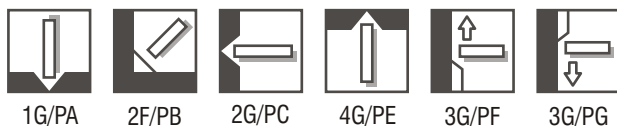
Approvals

GOST, SEPRO, TSE

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : AC min 50 V ; DC (+)

Diameter [mm]	Length [mm]	Current [A]			Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
		[Root Pass]	[Hot Pass]	[Cover Pass]			
2.50	350	40 - 80	-	-	1680	5.4 / 325	5
3.25	350	80 - 100	100 - 125	80 - 100	2950	4.7 / 160	5
4.00	350	110 - 130	115 - 140	110 - 130	4000	4.4 / 110	5



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Applications and Materials to be Welded

Site welding of pipe and pipelines made particularly from unalloyed structural steels; ship building; storage tanks, boiler and pressure vessel manufacturing and steel constructions are among its application areas. AS S-6011 can be used in applications requiring high penetration. It can also be used for the root and deposit pass. As it is an easy to bend electrode, it brings great convenience to reach in difficult-to-reach areas. AS S-6011 is an ideal electrode for welding in vertical downwards position.

	<u>DIN</u>	<u>EN</u>
General Structural Steels	St 33, St 35, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4	S185, S235, S275, S355 P235TR2 - P355T2
Fine Grained Steels	StE 255 - StE 355 WStE 255 - WStE 355	S255N - S355N P255NH - P355NH
Pipe Materials	StE 240-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X56 (API 5LX)	L245NB - L360NB L290MB - L360MB -
Boiler and Pressure Vessel Steels	17 Mn 4 H1, H11, H111	P295GH P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, C, D, E	-
Cast Steels	GS-38 - GS-45	GE200, GE240, GE260