

Coating type:
Cellulose

Current:



Welding positions:



E6011 is our universal electrode for all welding positions. The electrode is characterised by a deeply penetrating, easy handling, forceful, spray type arc and readily removable slag. E6011 is the ideal choice for welding through light to medium amounts of dirty, rusty, painted or galvanized materials. Typical applications include general-purpose fabrication, repair work, galvanized steel work, structural work and shipbuilding.

Base materials to be welded:

- Ships plate A-D, A(H)32-D(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2, St.33-St.52, C(K)10-C(K)35
- Boiler steel P235GH-P295GH, HI, HII, 17Mn4
- Fine grain steel P275N-P355N, S275N-S355M, StE285-StE 355, StE285-StE355TM
- Pipe steel P235T1-P355N, L210-L360NB, St37.0-St52, St45.8, X42-X52, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance

Chemical composition, wt. % weld metal – typical:

C	Mn	Si	S	P
0,105	0,30	0,092	0,010	0,015

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 380	≥ 445	≥ 25	-30°C ≥ 34

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	20,8	50-90
3,2	350	28,8	80-120
4,0	350	43,1	110-150