

S-6011.D

Type : Cellulosic

Conformances

AWS A5.1/ ASME SFA5.1 E6011
JIS Z3211 E4311
EN ISO 2560-A-E38 0 C 1 1
KR 2
ABS 2
LR 2
BV 2
DNV-GL 2
NK KMW2

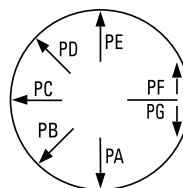
Applications

- Pipe line
- General fabrication
- Shipbuilding

Features

- Standard in the pipe welding industry
- Deep penetration
- High ductility (root pass)
- AC and DC welding

Welding Position



Current

AC or DC +

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	

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/in²)	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
468 (68,000)	558 (81,000)	29.7	-30 (-22)	51 (38)

Typical Welding Parameters / Amp.(A)

Diameter 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 & HF	50~75	75~125	90~165	140~220
V-up, OH	50~75	75~125	90~165	140~220