

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).

Classifications	AWS A5.1: E6011
Industry	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Welding Current	AC or DC+
Coating Type	High cellulose

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Reduction in Area	Elongation
As Welded	462 MPa (67 ksi)	524 MPa (76 ksi)	56 %	22 %

Deposition Data

Diameter	Optimal Amps	Current	Deposition Rate	Efficiency %
2.4 mm (3/32 in.)	70 A	60-80 A	0.9 kg/h (2 lb/h)	60 %
3.2 mm (1/8 in.)	100 A	85-120 A	1.1 kg/h (2.4 lb/h)	70 %
4.0 mm (5/32 in.)	140 A	140-175 A	1.7 kg/h (3.7 lb/h)	77 %
5.0 mm (3/16 in.)	180 A	170-210 A	1.8 kg/h (4.1 lb/h)	73 %