

6011 PRODUCT DATA SHEET

CELLULOSIC ELECTRODE

- Excellent all position electrode
- Best suitable for pipes and pipelines welding
- Excellent mechanical properties in class

Classification AWS A5.1 : E6011 EN 499: E 38 3 C 11 EN ISO 2560-A: E 38 3 C 11

Description and Applications

Cellulosic coated deep penetration electrode for the welding girth seams of pipelines. It is characterized by a deeply penetrating, forceful and spray type arc. Suitable for root passes, fill and cover passes. Excellent arc striking and re-striking.

Base materials

L210 - L360, X42 - X52, API Grades A25 A & B

Typical Weld Metal Chemical Composition(%)

C	Si	Mn
0.10	0.20	0.60

All weld metal Mechanical Properties (Typical)

Heat Treatment	Tensile Strength $R_m(N/mm^2)$	Yield Strength $R_p(N/mm^2)$	Elongation $A_5(\%)$	Impact Energy ISO-V (J) -30°C
As Welded	≥470	≥400	≥28	≥47

Amperes (A)

2.40/2.50mm	3.15/3.20mm	4.00mm	4.80mm
40-70	70-100	100-140	130-170

Welding Instruction

Keep drying and avoid condensation. Re-drying not generally required. If necessary: 70°C for 30 minutes one time only.

Welding Positions

