

ROYAL - 6011 (E 6011)

AWS – E 6011

Applications

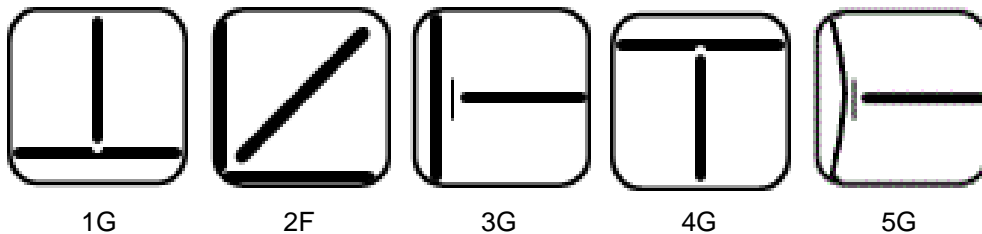
This includes general fabrication, ship building, galvanized steel, bridges, heavy equipments, rail, road, cars etc.

Characteristics on Usage

This electrodes is designed to take advantage of all position with AC or DC reverse polarity (DC +). The cellulose base coating produces deeply penetrating spray Arc. Bead is flat with thin brittle slag. Weld Metal has high tensile strength, ductility and is of X-Ray quality.

Notes On Usage

- ✍1) Pay Attention not to use currents exceeding the recommended currents.
- ✍2) As this electrode is prove to absorb moisture , store it with care .

Welding Positions**Chemical Composition Of Weld Metal**

| C% | Mn% | Si% | S% | P% |
|----------|----------|----------|-----------|-----------|
| 0.20 Max | 1.20 Max | 1.00 Max | 0.030 Max | 0.030 Max |

Mechanical Properties Of Weld Metal

| U.T.S. | Y.S. | ELONGATION | IMPACT (CVN) |
|----------------------|----------------------|--------------|------------------|
| (N/mm ²) | (N/mm ²) | (L = 4d) % | AT - 30° C (J) |
| 450 Min | 350 Min | 22 % Min | 27 Joules Min |

Approvals**Packing and Welding Current**

| SIZE (mm) | KG PER PACKET | KG PER CARTON | Current (Amps) | In Amps |
|-------------|---------------|---------------|----------------|---------|
| 2.50 x 350 | 5 | 20 | AC/ DC +ve | 55-75 |
| 3.15 x 350 | 5 | 20 | | 80-120 |
| 4.00 x 350 | 5 | 20 | | 120-160 |
| 5.00 x 350 | 5 | 20 | | 160-220 |