

# 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

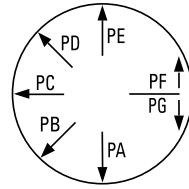
## Applications

- 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/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	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