



# E6011

CWB to CSA W48-14  
 Classification: E4311  
 AWS/ASME A5.1 - 04 E6011

**Suitable welding positions**



**Typical applications**

Covering is high cellulose type; common applications include welding of storage tanks, pipe, pressure vessel fittings, steel sheets, piping and ship construction.

**Characteristics on usage**

- Excellent all position general construction electrode designed for both DC and AC current
- Very good electrode when welding in poor groove fit up and vertical-down, all position welding of pipe
- Slightly higher slag volume than E6010 electrodes, good bead appearance
- High ductility root weld and easy slag removal
- Produces good mechanical properties, meets X-ray requirements
- Re-dry the electrode at 70-80 °C for 30-60 minutes prior to use

**Typical chemical composition of all-weld-metal(%)**

C	Si	Mn	p	S	Cr	Ni	Mo
0.08	0.31	0.58	0.017	0.018	0.03	0.02	0.01

**Minimum typical mechanical properties of all-weld-metal**

Yield Strength		Tensile Strength		Elongation	Impact Value
410 MPa	59 ksi	500 MPa	72 ksi	24%	40J (-30 °c )

**Dimensions and recommended currents**

Vanguard Code	Diameter		Length		Amperage	
	inches	mm	inches	mm	F & HF	VU&OH
6180 2400	3/32	2.6	11.8	300	50 - 80	40 - 70
6180 3200	1/8	3.2	13.8	350	70 - 110	70 - 100
6180 4000	5/32	4.0	13.8	350	110 - 150	90 - 130
6180 5000	3/16	5.0	13.8	350	160 - 200	140 - 170

**Standard packaging**

Sleeve		Master Carton		Pallet	
4.5 Kgs	10 Lbs	22.5 Kgs	50 Lbs	1,125 Kgs	2,500 Lbs