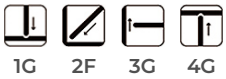
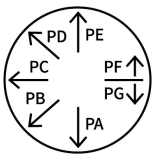
S-6011.D

Classification

AWS A5.1/ASME SFA-5.1 E6011
JIS Z 3211 E4311
EN ISO 2560-A E38 0 C 1 1
KS D7004 E4311

Welding Positions





Features

- Standard in the pipe welding industry
- Deep penetration
- High ductility (root pass)
- AC and DC welding
- Pipe welding positions 5G-Up and 5G-Down are applicable

Polarity

AC or DC +

Application Areas

- Pipeline
- General fabrication
- Shipbuilding

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Approvals

ABS	BV	DNV	KR	LR	NK
✓	✓	✓	✓	✓	✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S
0.09	0.30	0.45	0.015	0.008

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
428(62)	513(74)	26	-30(-20)	47(35)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	300(12)	50-75	50-75	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	75-125	75-125	
4.0(5/32)	350(14)	90-165	90-165	
5.0(3/16)	350(15)	140-221	140-220	