

6011

WELDING ROD FOR LOW CARBON STEEL. EASY APPLICATION AND GOOD PENETRATION IN ALL WELDING POSITIONS

CLASSIFICATION A.W.S: E-6011

IDENTIFICATION: WHITE COATING

APPLICATIONS: Its powerful arc and great penetration make 6011 suitable for good quality welds in any position. It can be used in all applications recommended for E-6011 class electrodes. The arc starts easily and it is very stable. The resulting welds are clean, highly resistant and ductile. Vilchis 6011 is used to weld mild steel plates, profiles and parts in bridges and structures. In shipbuilding, it is used as a general purpose welding rod to weld pipelines and pressure vessels, tanks, boilers, machinery and a number of different parts in either thick or thin plating.

CHARACTERISTICS AND PROCEDURE: In horizontal welds, keep the arc short and do not let the welding rod tip contact the weld pool. Clean each weld seam carefully and start welding a centimeter before the undercut to fill it up; then move on.

Avoid welding very close joints. Best results are obtained with standard gaps.

Operation is simple in all positions. Remember to keep the arc short. Tilt the electrode to 70° in the same direction as the weld. .

Horizontal fillet welds are made with the welding rod tilted between 30° and 45° to the plate and a 70° tilt in the same direction as the weld. Make straight, thin weld beads while keeping the amount of molten metal to the minimum. Swing the welding rod from one side to the other.

Vilchis 6011 is a cellulosic type welding rod to weld in all positions with AC but it works just as well with DC reverse polarity.

TENSILE RESISTANCE:	4,650 - 5,090 KG./CM2 (66,150 A 72,400 PSI)
ELASTIC LIMIT:	3,850 - 4,550 KG./CM2 (54,750 A 64,700 PSI)
ELONGATION IN 5 cm:	22 - 26%
BRINELL HARDNESS:	160 - 180
POSITIONS:	ALL
CURRENT:	AC and DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn		S	Si	3.25 mm - 1/8"	90-130
0.10	0.47	0.03	0.03	0.25	4.0 mm - 5/32"	120-180
					5.0 mm - 3/16"	160-220