

AK E6011

Description: AK-E6011 is a cellulose- type electrode for all positional welding with high efficiency and a goodlooking appearance. The arc length should be proper and the electrode swing should not be too much to get good operation performance. It is not suitable for multi-pass or covers welding.

Application: Suitable for butt welding, fillet welding, and lap weldings of sheet steel structures, like plant chimneys, transformer tanks, ships, and external-low carbon steel sheet structure vehicles, etc.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	V
Requirement	0.02	1.0	1.2	0.035	0.040	0.30	0.30	0.20	0.08
Actual Result	0.083	0.13	0.71	0.017	0.017	0.024	0.007	0.011	0.008

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥430	≥ 330	≥ 17	≥27J(-30℃)
Actual Result	490	400	28	100

Recommended welding parameters:

Diameter/ mm		2.5	3.2	4.0
Welding current /A	F/ H	60-90	70- 110	110- 150
	V/OH	50-80	60- 100	100- 140