

DM6011 Premium Electrode

Classification: E6011

AWS A 5.1 / ASME SFA 5.1

DuraMax DM6011 is a CELLULOSIC COATED ELECTRODE FOR PIPE WELDING

Characteristics

High cellulose coated, potassium type electrode for pipe welding in DC(+) as well as AC current condition. forceful and spray arc, ensures deep penetration and Weld metal is of radiographic quality. Slag system that is a fast freezing , thin and easy removable.

Typical Applications on Usage

E6011 is designed for site welding of pipes and pipelines in all positions, using stove pipe and conventional techniques particularly for root bead.

RE-DRY CONDITIONS: Not Recommended

Typical Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.20 max	0.40 - 0.80	0.30 max	0.030 max	0.030 max	0.30 max	0.20 max	0.30 max	0.08 max

Typical Mechanical Properties as Welded

Tensile Strength (n/mm ²)	Yield Strength (n/mm ²)	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (J)
					@ -30 °C
430-560	330-450	22-30%	-----	-----	50-80 J

Sizes available and recommended currents (DC +)

SIZE	3/32	1/8	5/32
AMPS	50 ~ 80	90 ~ 130	110 ~ 160

POLARITY: DCEP or AC

DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration.

AC: medium weld penetration (can be more spatter)

USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions