

Mild Steel Electrodes

Alloy: WW6011  
Class: E6011

Certification: AWS A5.1  
ASME SFA A5.1

Alloy: E6011

Weld Process: Shielded Manual Metal Arc Electrodes

AWS Chemical Composition Requirements

Not Specified In AWS Specifications

Deposited Chemical Composition % (Typical)

C = 0.09      Mn = 0.50      Si = 0.20  
P = 0.012      S = 0.021

Deposited All Weld Metal Properties %  
(Typical) As-Welded

Yield Strength (PSI)      60,000  
Tensile Strength (PSI)    73,500  
Elongation in 2" (%)      24  
Reduction of Area (%)    67

Deposited Charpy-V-Notch Impact Properties %  
(Typical) As-Welded

30 ft. lbs. (tested at -20°F)

Recommended Welding Parameters

<u>Diameter</u>	<u>Amperage</u>
3/32"	70 – 80
1/8"	110 – 130
5/32"	130-160

Current (AC)

Application

E6011 all position electrode is designed for AC welding. Used primarily for welding mild steels, A36, A283, A515 or A516.

