



Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard: AWS A5.1 AWS A5.1M	Chemical Composition %									
		C	Mn	Si	Cr	Ni	Mo	V	S	P
Grade E6011	Spec	≤0.20	≤1.2	≤1.0	≤0.2	≤0.3	≤0.3	≤0.08	---	---
	Typical	0.075	1.12	0.48	0.03	0.012	0.006	0.015	0.009	0.019
Specification (MM)	1.6、2.0、2.4、3.2、4.0、5.0				X ray detection grade: II					
Package	5 kgs/plastic bag in a color box, 20kgs/carton, 1 ton in a pallet									
Mechanical Properties		Tensile Strength Mpa			Yield Strength Mpa		Elongation %		KV2(J) -30℃	
	Specification	≥ 430			≥ 330		≥ 22		≥ 27	
	Typical	580			490		32		150	
Diameter (MM)	2.0	2.5			3.2		4.0		5.0	
Length (MM)	300	300			350		400		400	
Current (A)	40~70	40~80			75~125		110~170		140~215	
Specification	It is a kind of carbon steel electrode with iron powder low-hydrogen potassium type coating. The deposition efficiency can be improved due to the iron powder in the coating.									
Application	1. The electrodes must be baked under 300~350℃ for an hour before welding and used as soon as baking is completed. 2. The stains on the weldments, such as rust, etc, must be cleared away before welding. 3. When welding, short arc must be used and stringer bead is suitable. 4. Used for welding carbon steel and low-alloy steel structures, such as 16Mn, etc.									

