

# Inweld 6011 Deep Penetration – AC Current

Alloy E6011  
AWS A5.1 E6011

AC/DC + (reverse polarity)



## Description and Applications:

All-Position, Multiple-Pass Mild Steel Electrode with a strong arc force and fast solidification of weld metal. Designed to provide the deepest penetrating welds while using small AC welding machines as well as DC types. High Deposition efficiency and non-porous welds even over rusty or oily steel or where there is a problem of poor groove fit-up. Great electrode to use with minimal preparation. Common uses include many general structures such as car and truck frames, farm implements, tractors, trailer frames, storage tanks, galvanized steel.

## Procedure:

A clean weld area will always yield the best results. You can use a small AC machine or a DC machine (electrode + reverse polarity). However if a DC machine is used the arc penetration will be less than that of a 6010 electrode. Set the amperage to the proper range for the size electrode and the welding position you are using. A medium arc length of approximately 1/8" maintained ahead of the weld puddle will yield good wetting action and allow unwanted gases to escape. Flat and horizontal welding: hold the electrode at an angle 10-15 off 90 and use a slight back and forth whipping motion. Overhead welding: use a slight circular motion. Vertical-down welding: use stringer beads or a slight weaving technique keeping the weld puddle in place by pointing the electrode arc up into the puddle. Be sure to choose an amperage in the upper end of the recommended range. Vertical-up welding: should be done using the shelf or step method, adding layer on top of layer. Do not use the whipping motion. Use an amperage setting in the lower end of the recommended range. Allow the part to air cool and remove slag with a chipping hammer and brush to a nice finish.

Recommended Parameters	Diameter	Recommended Amperage	
		(F)	(V & O)
Tensile Strength is 69,000 psi	3/32" (2.4mm)	65-100	50-75
	1/8" (3.2mm)	80-120	70-110
	5/32" (4.0mm)	130-170	110-150
	3/16" (4.8mm)	170-210	130-170

## Warning

- This product, when used for welding or cutting, produces fumes or gases which may contain chemicals known to the state of California to cause birth defects (or other reproductive harm), and in some cases cancer. (California Health & Safety Code 25249.5 et seq.)
- Read American National Standards Z49.1, "Safety in Welding Cutting and Allied Processes," from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126; OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Government Printing Office, Washington, DC 20402.

## Fumes and Gases can be hazardous to you health.

- Before use, read and understand the materials Material Safety Data Sheet (MSDS), the manufacturer's instructions and your employers safety practices.
- If MSDS is not enclosed, obtain one from your employer.
- Keep your head out of the fumes. See section 5 of the MSDS for specific fume concentration limits.
- Use enough ventilation exhaust at the arc or both to keep fumes and gases from your breathing zone and general area. If needed, use a respirator.
- No hazards exist before this product is used in arc welding. Electric Shock can kill.
- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrical parts.
- ARC Rays can injure eyes and burn skin.
- Wear welding helmet with correct filter.
- Wear correct eye, ear and body protection.
- Welding can cause fire or explosion" Do not weld near flammable material.
- Watch for fire, keep extinguisher nearby.

