

Inweld 6011

AWS A5.1 E6011

Chemical Composition of Inweld 6011

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu
Balance	0.20	0.20	0.30	0.30	1.20	1.00	---	---	0.08	---

Single values are maximum unless otherwise specified.

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, and galvanized steel.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	60,000 psi
Yield Strength:	48,000 psi
Elongation:	22%

Recommended Parameters

SMAW (DCEP – Electrode+)

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Flat Amperage</u>	<u>Vertical & Overhead Amperage</u>
3/32"		50-80	40-70
1/8"		70-110	60-100
5/32"		110-160	90-140

INWELDCORPORATION.COM

Pennsylvania
3962 Portland Street
Coplay, PA 18037

North Carolina
1029 S. Marietta St.
Gastonia, NC 28054

Texas
9300 Lawndale St.
Houston, TX 77012

California
6201 Coliseum Way, Unit A
Oakland, CA 94621