



S. R. Industries

STAR ARC E6011

E6011 is a mild-steel, all position electrode designed primarily for use on AC power sources. It produces a strong arc force for deep penetration and a fine spray transfer that enhances operator appeal. Fast freezing or rapid solidification of the metal allows welding in the vertical and overhead position. Its light slag eliminates slag holes that are prevalent on some applications with other electrodes.

Typical Applications : General purpose fabrication, galvanized steel work, structural work, shipbuilding

AWS Class : E6011	Classification: AWS A5.1/A5.1M:2004
Alloy: E6011	ASME SFA A5.1
Welding Position : F, V, OH, H	Current : AC-DCEP
Tensile Strength, kpsi:	60 min
Yield Strength, kpsi:	48 min
Elongation in 2" (%):	22 min

Typical Wire Chemistry as per AWS A5.1 (single values are maximum)

C	Mn	Si	P	S	Ni	Cr	Mo	V	Combined Limit for Mn+Ni+Cr+Mo+V
0.20	1.20	1.00	*NS	*NS	0.30	0.20	0.30	0.08	*NS

Not Specified

Typical Welding Parameters				
Diameter		Process	Volt	Amps (Flat)
in	(mm)			
3/32	(2.4)	SMAW	25-30	65-90
1/8	(3.2)	SMAW	25-30	80-120
5/32	(4.0)	SMAW	25-30	130-170
3/16	(4.8)	SMAW	25-30	150-210

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