

Shielded Metal Arc Welding

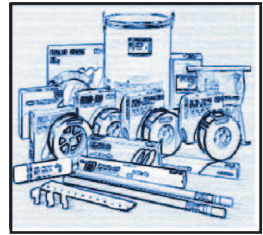
ANU BOND - 6011 (E 6011)

AWS: E 6011

Mild Steel Welding Electrodes

Application :

This includes general fabrication, ship building, galvanized steel, bridges, heavy equipments, rail, cars etc.



Characteristics on Usage :

This electrodes is designed to tack advantage of all position with AC or DC reverse polarity (DC +). The cellulose base coating produces deeply penetrating spray Arc. Bend is flat with thin brittle slag. Weld metal has high tensile strength, ductility and is of X-Ray quality.

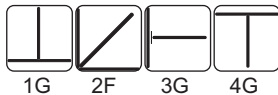
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P
0.20 Max	1.20 Max	1.00 Max	0.030 Max	0.030 Max

Mechanical properties of all-weld metal as per AWS

UTS	Y. S.	Elongation	Impact
(N/mm ²)	(N/mm ²)	(L=4d) %	(CVN) AT -30 ⁰ C (J)
450 Min	350 Min	22 % Min	27 Joules Min

Welding Positions



Packaging & Welding Current

SIZE (mm)	KG Per Packet	KG Per Carton	Current (Amps)	In Amps
2.50 x 350	2.50	12.5 Kg	AC/ DC +ve	55-75
3.15 x 450	3 Kg	15 Kg		80-120
4.00 x 450	3 Kg	15 Kg		120-160
5.00 x 450	3 Kg	15 Kg		160-220

