



T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
 4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

TECHNICAL SPECIFICATION SHEET

E6011 COVERED ELECTRODE

ISO 9001
 Cert. No. 31598

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

NOMINAL COMPOSITION:

Carbon	.08%	Iron	Balance
Manganese	.45%	Silicon	.18%
Sulfur	0.015%	Phosphorus	.014%

TYPICAL MECHANICAL PROPERTIES AS WELDED

Tensile Strength (psi)	72,900 psi
Yeild Strength (psi)	up to 66,100
Elongation in 2"	29.6

WELDING PROPERTIES:

E6011 is a versatile, deep penetrating, all position steel electrode for welding of steels such as; structural, ship building/repair, rail cars, piping, pressure vessel fitting, boilers, galvanized steel, and general fabrication. The coating produces a forceful, spray type arc resulting in excellent mechanical properties which operates with AC or DCEP.

*** RECOMMENDED WELDING PARAMETERS:**

<u>AMPS</u>	<u>3/32x12</u>	<u>1/8x14</u>	<u>5/32x14</u>
Flat	50-80	70-110	110-160
Vertical/overhead	40-70	60-100	90-140

* All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.

SPECIFICATION COMPLIANCE: ANSI/AWS A5.1 &ASME SFA 5.1 E6011

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WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

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