

ELECTRODO AL CARBONO
S-6011 D

- Con una buena soldabilidad en una ranura pobre, se puede realizar fácilmente soldadura hacia arriba y vertical hacia abajo, es adecuado para todas las posiciones de soldadura de tuberías.

HYUNDAI WELDING

ELECTRODO AL CARBONO S-6011 D	
Propiedades:	Recubrimiento celulósico.
Uso en:	Aceros estructurales y cañerías.
Marca:	Hyundai
Corriente:	AC o DC
Certificación:	KR, ABS, LR, BV, DNV, GL, NK

ASSUM
Tus Metas son las Nuestras

FORMATO	CÓDIGO	EMPAQUE
3/32"	37HYD60111	5 Kg
1/8"	37HYD60112	5 Kg
5/32"	37HYD60113	5 Kg

S-6011.D

TYPE : Cellulosic

AWS A5.1 / ASME SFA5.1 E6011
JIS Z3211 E4311
EN ISO 2560-A - E38 3 C 1 5

SMAW

Applications

S-6011.D can be used for welding of thin steel sheets and pipes.

Characteristics on Usage

With good weldability in poor groove, up and vertical downward welding can be performed easily, it is suitable for all position welding of pipes.

Notes on Usage

① Pay attention not to use currents exceeding the recommended currents.
② As this electrode is prone to absorb moisture, store it with care.

Welding Position



(PF.PG)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.11	0.16	0.51	0.015	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)
468 (68,000)	558 (81,000)	29.7	-30 (-22)	51 (38)

ASSUM
Tus Metas son las Nuestras

Approval

KR, ABS, LR, BV, DNV, GL, NK

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	350 (14)	350 (14)	350 (14)
F,V-down	50~75	70~110	110~155	155~200
V-up	35~70	55~105	90~140	120~180