

RATNA 6011

Cellulosic coated electrode for pipe welding

CLASSIFICATION : AWS/SFA-5.1: E 6011
IS-814: EC 4316X

APPROVAL :

CHARACTERISTICS : High cellulose coated, potassium type electrode for pipe welding in DC(+) as well as AC current condition. forceful and spray arc, ensures deep penetration and Weld metal is of radiographic quality. Slag system that is a fast freezing , thin and easy removable.

APPLICATION : 6011 is designed for site welding of pipes and pipelines in all positions, using stove pipe and conventional techniques particularly for root bead.

RE-DRY CONDITION : Not recommended

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.20 max.	0.40-0.80	0.30 Max.	0.030 Max	0.030 Max

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (1=4d)	CHARPY "V" NOTCH IMPACT AT
330-450	430-560	22-30	Minus 30 ⁰ C : 50-80 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+) Amps	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	270	1080
3.15/ 3.20 X 350	1/ 8" X 14"	80-130	160	640
4.00 X 350	5/ 32" X 14"	110-160	105	420

Customer packing on request.