

EASYARC™ ID6011



General Applications

- Made especially for welding carbon steel using AC.
- Sheet metal lap and fillet welds.
- “Fast-Fill” joints with poor fit-up.
- General purpose welding in all positions.
- Pipeline welding where x-ray quality is required.

“Fast-Freeze” Characteristics

- Good deposit rates and deep penetration.
- Smooth and stable arc even at low currents.
- All position operation. Most widely used downhill or in the flat position.
- Excellent “Fast-Freeze” characteristics of 2.5mm through 4.0mm sizes of E6011 are excellent for sheet metal welding.
- Exceptionally good for vertical and overhead work.

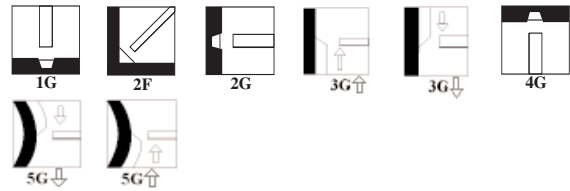
Polarity

AC or DC

Classifications

AWS A5.1: E6011

Welding Positions



Approvals

ABS: Grade 3
 Lloyds: 2M, 2YM
 BKI: Class 2
 GL: Class 2

CHEMICAL COMPOSITION (W%), TYPICAL ALL WELD METAL

%C	%Mn	%Si
0.12	0.60	0.20

MECHANICAL PROPERTIES

Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact Iso-V (j) -30°C
Requirements	330	430	22	27
Test Results	442	480	30	72

PACKAGING AND AVAILABLE DIAMETERS

	Diameter (mm)	Length (mm)	Weight Set (kg)		
			Inner Box	Master	Pallet
Easyarc™ ID6011	2.5	350	5	20	1900
	3.2	350	5	20	2000
	4.0	350	5	20	2000

WELDING PARAMETERS

Diameter (mm)	Current (A)
2.5	50 - 90
3.2	80 - 130
4.0	120 - 180
5.0	140 - 220

WELDING TECHNIQUES

Flat. Permit the tip of the electrode to touch the work lightly or hold a short arc. Tip the electrode forward in the direction of travel and move fast enough to stay ahead of the molten pool. Use currents in the middle and higher portion of the range.

Vertical. For best penetration, welding is usually done vertical up, though vertical down is used for cross-country pipeline welding because it is faster for pipe under 16mm wall thickness. For vertical up, use a stringer bead for the first pass applied with a whipping technique for fillet welds or a circular motion for Vee-butt joints. Apply succeeding passes with a weave, pausing slightly at the edges to ensure penetration and to wash in without undercut. Use currents in the lower portion of the range. For vertical down welding use currents towards the top end of the range. Full details of these high-speed techniques are contained in Bulletin M640, "Welding Pressure Pipe Lines".

Overhead and Horizontal Butt. These welds are best made with a series of stringer beads, using a technique similar to that described for vertical welding.

Sheet Metal Edge and Butt. Use DC, electrode negative; hold a comparatively long arc length. Lean the electrode forward in the direction of travel and move as rapidly as possible while maintaining good fusion. Welding is fastest when done 45 degrees downhill. Use currents in the middle of the range.

CUSTOMER ASSISTANCE POLICY

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