DURAMAX®
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Product Data Sheet

DM6011 Premium Electrode

Classification: **E6011**

AWS A 5.1 / ASME SFA 5.1

DuraMax DM6011 is a CELLULOSIC COATED ELECTRODE FOR PIPE WELDING

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.

Typical Applications on Usage

E6011 is designed for site welding of pipes and pipelines in all positions, using stove pipe and conventional techniques particularly for root bead.

RE-DRY CONDITIONS: Not Recommended

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.20 max	0.40 - 0.80	0.30 max	0.030 max	0.030 max	0.30 max	0.20 max	0.30 max	0.08 max

All Weld Mechanical Properties

YS (N/mm²)	UTS (N/mm²)	EL % (1=4d)	CHARPY "V" NOTCH IMPACT AT
330 - 450	430 - 560	22 - 30	Minus -30°C : 50 -80 J

Sizes available and recommended currents (DC +) or AC

SIZE	3/32	1/8	5/32
AMPS	50 ~ 80	80 ~ 130	110 ~ 160

POLARITY: DCEP or AC
DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration.
AC: medium weld penetration (can be more spatter)
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930