



Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925

# USA 6011 Coated Electrode

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



### ALLOY DESCRIPTION AND APPLICATION;

USA 6011 electrodes have the same characteristics as USA 6010; however unlike the USA 6010, this electrode may be used with small AC welders as well as DC types. USA 6011 high cellulose coated electrodes provide excellent arc stability, increased ductility, high deposition efficiency and low spatter. This electrode combines a strong arc force with fast solidification of weld metal, thereby permitting vertical or overhead as well as flat and horizontal welding positions. USA 6011 is especially suited for welding where poor groove fit-up and rusty or oily steel is present.

### TYPICAL WELDING PROCEDURES; DCEP

Diameter	Amps (Flat)	Volts
3/32"	65-90	25-30
1/8"	80-120	25-30
5/32"	130-170	25-30
3/16"	150-210	25-30

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

### TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

	AWS Spec.	Weld metal		AWS Spec.	Weld metal
Carbon	0.20 max	0.10			
Manganese	1.20 max	0.58	Tensile Strength (ksi)	60 min.	72
Silicon	1.00 max	0.37	Yield Strength (ksi)	48 min.	63
Phosphorus	N/A	0.015	Elongation in 2"(%)	22% min.	29.2%
Sulphur	N/A	0.013	Charpy V-notch at -20°F	20 ft·lbs min.	36 ft·lbs

**AVAILABLE SIZES:** TE 6011 = 3/32", 1/8", 5/32", 3/16"

**SPECIFICATIONS;** ANSI/AWS A5.1 E6011  
ASME SFA 5.1 E6011

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