



LKE-6011

LINKWELD ALLOYS INC.

AWS	A5.1 E6011
EN	EN499 E 42 2 C 1 2
JIS	Z3211 D4311

Characteristics:

LKE-6011 is a cellulose type electrode designed for all position welding. It has excellent performance in vertical and overhead positions on root pass. It has deep penetration, good slag removability, stable arc and nice bead appearance.

Applications:

It is suitable for welding of heat transfer pipes, oil tanks, ships and boiler.

Notes on Usage:

1. Don't exceed the range of proper current.
2. Dry the electrodes at 60-70°C for 30-60 minutes.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.12	0.45	0.25	0.015	0.01

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -30 °c J
429	530	28	50

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.6	3.2	4.0	4.8
Length (mm)		300	350	350	350
Amps	F	60-90	80-120	110-160	160-200
	V&OH	50-80	75-110	90-150	120-180
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20