



M-90 E6011

FEATURES

- *STANDARD IN THE PIPE WELDING INDUSTRY
- *DEEP PENETRATION
- *HIGH DUCTILITY (ROOT PASS)
- AC AND DC WELDING

APPLICATION

- *PIPELINE
- *GENERAL FABRICATION
- *SHIPBUILDING

CLASSIFICATION

- *AWS/A5.1/ASME SFA5.1 E6011

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.11	0.16	0.51	0.15	0.12			

MECHANICAL PROPERTIES

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2)	N/mm2 (lbs/in 2)	(%)	oC (oF)	J (ft lbs)
468 (68,000)	558 (81,000)	29.7	-30(-22)	51(38)

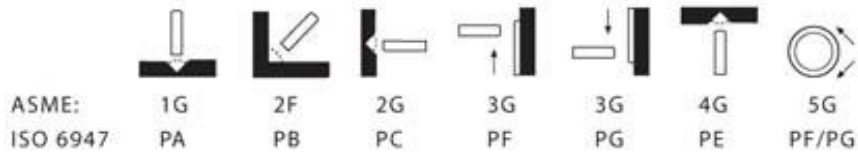
WELDING PARAMETERS

DIAMETER (mm)	2.5	3.2	4
LENGTH (mm)	350	350	350
CURRENT (amps)	50-75	75-120	90-160

CURRENT

- *AC or DC +

WELDING POSITIONS



Current

= +	~	(U _o : 50 V)
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