



XTR Select 6011

A5.1 E6011

Features & Applications:

Ideally suited for difficult maintenance repairs. Easily welds steels that have been galvanized, painted, rusted, or otherwise contaminated in service. Easy to use out of position. Adverse conditions mild steel electrode. Excels on rusty, greasy, poor fitting joints in all positions. The slag is very easy to remove.

- Can bridge gaps as wide as 3/8 inch (9 mm)
- Excellent for out of position work

Chemistry:

	Typical	AWS Spec. Single values are max.
Carbon (C)	0.150	0.200
Manganese (Mn)	0.770	1.200
Silicon (Si)	0.390	1.000
Nickel (Ni)	0.070	0.300
Chromium (Cr)	0.100	0.200
Molybdenum (Mo)	0.020	0.300
Vanadium (V)	0.010	0.080
Combined (Mn+Ni+Cr+Mo+V)	-	ns



Mechanical Properties: (All weld metal analysis, Typical Weight %)

	Typical	AWS Spec. Single values are min.
Tensile Strength	80,000	60,000 psi
Yield Strength	72,000	48,000 psi
Elongation in 2" (%)	28	22
Charpy V-Notch	70J: -20°C	15 ft-lbs. @ -20°F
Diffusible Hydrogen (mL/100g weld metal)	nr	nr



Coating High Cellulose Potassium
Flux Coating, Color Tan/Grey

Welding Positions:

F, V, OH, H

Operating Parameters: Coated Electrode/Rod (SMAW), DC Reverse (+), Straight (-), or AC

Formula: 1100

Procedures & results may vary with any change in position, equipment being used, base metal and base metal cleanliness.

Diameter	Amperage Range	Weldmetal Electrode	Electrodes per lb. (kg) of Weldmetal	Arc Time of Deposition min/lb. (kg)	Electrodes (Rods) per Lb. Packaged
1/16 (1.6mm)	nr	--	--	--	--
3/32 (2.4mm)	50-75	.27oz (7g)	45 (100)	37 (81)	31
1/8 (3.2mm)	70-110	.56oz (15g)	25 (56)	25 (56)	18
5/32 (4.0mm)	100-160	.9oz (25g)	17 (38)	20 (45)	11
3/16 (4.8mm)	120-200	1.35oz (38g)	12 (26)	15 (34)	8
1/4 (6.4mm)	nr	--	--	--	--



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