

Fleetweld® 35

Mild Steel, Cellulosic • AWS E6011

Key Features

- ▶ Stable arc performance
- ▶ High operator appeal
- ▶ AC and DC welding

Typical Applications

- ▶ Sheet metal
- ▶ In-plant pipe welding
- ▶ Steel with moderate surface contaminants
- ▶ Welding on galvanized and specially coated steels

Conformances

AWS A5.1/A5.1M: 2004	E6011
ASME SFA-A5.1:	E6011
ABS:	E6011
Lloyd's Register:	3M
EN ISO 2560-B:	E4311 A

Welding Positions

All

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	50 lb (22.7 kg) Carton
3/32 (2.4)	14 (350)	ED028152
1/8 (3.2)	14 (350)	ED028153
5/32 (4.0)	14 (350)	ED028154
3/16 (4.8)	14 (350)	ED028155
7/32 (5.6)	18 (450)	ED032301
1/4 (6.4)	18 (450)	ED028157

MECHANICAL PROPERTIES⁽¹⁾ – As Required per AWS A5.1/A5.1M: 2004

	Yield Strength ⁽²⁾ MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) @-29°C (-20°F)
Requirements - AWS E6011	330 (48) min.	430 (60) min.	22 min.	27 (20) min.
Typical Results ⁽³⁾ - As-Welded	385-415 (56-60)	470-510 (68-74)	26-33	56-101 (42-75)

DEPOSIT COMPOSITION⁽¹⁾ – As Required per AWS A5.1/A5.1M: 2004

	%C	%Mn	%Si	%P	%S
Requirements - AWS E6011	0.20 max.	1.20 max.	1.00 max.	Not Specified	Not Specified
Typical Results ⁽³⁾ - As-Welded	0.11-0.16	0.32-0.60	0.09-0.28	0.006-0.011	0.004-0.013
	%Ni	%Cr	%Mo	%V	
Requirements - AWS E6011	0.30 max.	0.20 max.	0.30 max.	0.08 max.	
Typical Results ⁽³⁾ - As-Welded	≤ 0.06	0.01-0.04	≤ 0.02	≤ 0.01	

TYPICAL OPERATING PROCEDURES

Polarity ⁽⁴⁾	Current (Amps)					
	3/32 in (2.4 mm)	1/8 in (3.2 mm)	5/32 in (4.0 mm)	3/16 in (4.8 mm)	7/32 in (5.6 mm)	1/4 in (6.4 mm)
AC	50-85	75-120	90-160	120-200	150-260	190-300
DC±	40-75	70-110	80-145	110-180	135-235	170-270

⁽¹⁾Typical all weld metal. ⁽²⁾Measured with 0.2% offset. ⁽³⁾See test results disclaimer below. ⁽⁴⁾Preferred polarity is listed first.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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