

Hobart® 335A



AWS E6011

WELDING POSITIONS:



FEATURES:

- Quick starting
- Superior arc drive
- Excellent wetting action
- Slag detaches easily

BENEFITS:

- Easy arc striking, ideal for tacking
- Excellent penetration
- Smooth bead appearance, reduces cold lap and undercutting
- Quick clean-up

APPLICATIONS:

- Galvanized steel work
- Rail cars
- General fabrication
- Shipbuilding and structural work

TYPE OF CURRENT: AC or Direct Current Electrode Positive (DCEP)

RECOMMENDED WELDING TECHNIQUES:

- ARC LENGTH:** 1/8" to 1/4" (3.2 mm to 6.4 mm)
- FLAT:** Stay ahead of puddle and use slight whipping motion
- HORIZONTAL:** Angle electrode slightly toward top plate
- VERTICAL-UP:** Use slight whipping or weaving technique
- VERTICAL-DOWN:** Use higher amperage and faster travel, staying ahead of the puddle
- OVERHEAD:** Stay ahead of puddle and use slight whipping motion

STORAGE: Dry at room temperature, humidity below 50% should be avoided. At no time should this electrode be stored in an oven above 130°F (54°C).

RECONDITIONING: Not recommended

TYPICAL CHEMICAL VALUES*:

		AWS Spec (max)
Carbon (C)	0.12	0.20
Manganese (Mn)	0.71	1.20
Silicon (Si)	0.29	1.00
Phosphorus (P)	0.009	not specified
Sulphur (S)	0.009	not specified

TYPICAL TENSION TEST RESULTS* (As Welded):

		AWS Spec
Tensile Strength	82,000 psi (565 MPa)	60,000 psi (430 MPa) Minimum
Yield Strength	69,000 psi (478 MPa)	48,000 psi (330 MPa) Minimum
Elongation % in 4x diameter length	26%	22% Minimum

TYPICAL CHARPY V-NOTCH IM-

		AWS Spec
Avg at -20°F (-30°C)	38 ft•lbs (52 Joules)	20 ft•lbs (27 Joules) Minimum

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with AWS A5.1 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

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Diameter		Type of Current	Amperage Range		Optimum Parameters		Deposition Rate*		Deposition Efficiency*
Inches	(mm)		Min.	Max.	Amps	Volts	lbs/hr	(kg/hr)	
3/32	(2.4)	AC or DCEP	60	90	60	25.0	1.6	(0.7)	66.5%
1/8	(3.2)	AC or DCEP	80	125	100	24.0	2.6	(1.2)	67.2%
5/32	(4.0)	AC or DCEP	130	160	140	25.0	3.3	(1.5)	65.7%
3/16	(4.8)	AC or DCEP	160	190	180	25.0	3.9	(1.8)	69.1%

Reduce optimum amperage by 15% when welding out of position.

*Calculated using optimum parameters and AC polarity. Allowance made for 2" stub loss.

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**

AVAILABLE DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543 or (937) 332-5188 for International Customer Service.

Diameter		Length		5-Lb. Plastic Pak	10-Lb. Plastic Pak	50-lb. Carton	50-lb. HSC
Inches	(mm)	Inches	(mm)				
Net Pallet Weight				2000-lb. (904 kg)	2100-lb. (951 kg)	3000-lb. (1361 kg)	3000-lb. (1361 kg)
3/32	(2.4)	14	(355)	S112232-045	S112232-089	S112232-031	—
1/8	(3.2)	14	(355)	S112244-045	S112244-089	S112244-031	S112244-035
5/32	(4.0)	14	(355)	—	S112251-089	S112251-031	S112251-035
3/16	(4.8)	14	(355)	—	—	S112258-031	S112258-035

CONFORMANCES AND APPROVALS:

- AWS A5.1, E6011
- AWS A5.1M, E4311
- ASME SFA 5.1, F-3, A-1, E6011
- ABS, E6011
- CWB, E4311

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers LLC is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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