

AWS E6010

DESCRIPTION:

AWS E6010 is a high cellulose sodium type carbon steel welding electrode for vertical-down welding. It shows a very good performance in welding of all positions, especially vertical-down welding. The welding performance are excellent: deep penetration, fewer slag, slag easy to remove, high welding efficiency and good weld shape etc. The electrode forms double sides by one side welding.

APPLICATION:

Suitable for welding root passes, hot passes, filler and cover passes as well as for capping of general pipes and similar structures.

ATTENTION:

- Generally, welding electrodes do not need bake before welding.
- If damped, the electrodes should be baked for 0.5-1 hours at the temperature of 70-80°C before welding.

Chemical Composition of Deposited Metal: (%)

	C	Mn	Si	P	S
Standard	-	-	-	≤0.040	≤0.035
Typical	0.091	0.55	0.18	0.015	0.013

Mechanical Properties of Deposited Metal

	Tensile Strength σ_b (Mpa)	Yield Point $\sigma_{0.2}$ (Mpa)	Elongation δ_5 (%)	Akv Impact (-30°C) (J)
Standard	≥420	≥330	≥22	≥27
Typical	500	405	28	96

Recommended Current(DC*)

Diameter(mm)	Φ 2.5	Φ3.2	Φ 4.0	Φ 5.0
Length(mm)	300	350	400	400
Flat, Horizontal Current(A)	60-90	70-110	110-150	150-200
Vertical, Overhead Current(A)	50-80	60-100	100-140	140-180