

6010

WELDING ROD FOR LOW CARBON STEEL. IT IS SUITABLE TO WELD IN ALL POSITIONS, SPECIALLY WHEREVER GREAT PENETRATION IS REQUIRED.

CLASSIFICATION A.W.S: E-6010

IDENTIFICATION: RED COATING

APPLICATIONS: 6010 is widely used to weld pipes and in general welding jobs involving steel plates, profiles and parts. Together with its outstanding operation qualities, it provides high penetration in either vertical or overhead welding. It is widely used in the production of high pressure vessels, in steam, fuel and water pipelines, in all kinds of machinery, in the repair of cast steel parts, railway parts, etc. To sum it up, it is suitable for all those jobs where a great deal of safety, high penetration and resistance--characteristic of 6010-- are required. This is a universal electrode for mild steel, suitable for welding in all positions with DC.

CHARACTERISTICS AND PROCEDURE: Its powerful arc provides 6010 characteristic high penetration. For horizontal welding, keep the arc short but do not let the welding rod tip contact the weld pool.

Clean each weld seam carefully and start welding a centimeter before the undercut to fill it up completely and then move on. Avoid welding very tight joints. Best results are obtained with a standard gap in the joint.

Operation is quite simple in all positions. Keep the arc short. Tilt the welding rod at 70° in the same direction as the weld.

Horizontal fillet welds are made with the welding rod tilted between 30 and 45° with respect to the horizontal plane and a 70° tilt in the same direction as the weld. In overhead welding, make thin straight beads and keep the amount of molten metal to the minimum while swinging the electrode from side to side.

TENSILE RESISTANCE:	4650-5000 KGM/CM2 (66150 A 71100 PSI)
ELASTIC LIMIT:	3850-4250 KG/CM2 (54750 A 60450 PSI)
ELONGATION IN 5 cm:	22 - 25%
BRINELL HARDNESS:	160-180
POSITIONS:	ALL
CURRENT:	DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	P	S	Si		
0.10	0.47	0.03	0.03	0.32	3.25 mm - 1/8"	90-130
					4.0 mm - 5/32"	120-180
					5.0 mm - 3/16"	160-220