

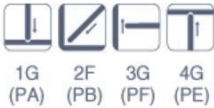
E6010

AWS A5.1 E6010
ISO2560-A E38 0 C 2 1
GB/T5117 E4310

Description:

E6010 is a high cellulose sodium electrode with excellent vertical down welding performance and stronger arc force and deeper penetration. Usually use for butt welding of steel pipes.

Welding Position:



Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

Typical Mechanical Properties:

Tensile strength(MPa):	571
Yield strength(MPa):	447
Elongation (%):	28
Impact values(≥ 27)/(-30°C):	76

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0.083	0.71	0.017	0.017	0.13	0.024	0.011	0.007	0.008

Welding Current: (DC+)

Diameter(mm)	2.5	3.2	4.0	5.0
Current/A	F/H 60-90	70-110	110-150	150-200
Current/A	V/OH 50-80	60-100	100-140	140-180

Note:

1. The electrodes get damp easily, please store them in dry environment.
2. Please bake the electrodes 30-60 minutes in 70°C before using if they are damp.