



**6010**



**DESCRIPTION:** 6010 is a high cellulose coated electrode designed to provide a smooth stable arc forceful enough to achieve deep penetration into the base metal. This electrode exhibits high deposition efficiency and low spatter loss. It produces a weld puddle that wets and spreads well, yet sets up fast enough to make this electrode ideal for vertical up or vertical down welding techniques. 6010 electrodes produce a flat weld bead with coarse ripples and a thin easily removable slag. 6010 electrodes may be used in the flat, horizontal, vertical or overhead welding positions.

**APPROVALS:** Meets AWS A5.1 Class E6010.

**APPLICATIONS:** 6010 electrodes are most commonly used for out-of-position welding such as field construction, ship yards, water towers, pressure vessels, pressure pipes, steel castings, plain and galvanized steel storage tanks, etc.

**CHEMICAL COMPOSITION**

Carbon	.10
Manganese	.50
Silicon	.30
Phosphorus	.013
Sulfur	.012

**MECHANICAL PROPERTIES**

<b>Tensile Strength</b>	
72,500 PSI	500 MPA
<b>Yield Strength</b>	
60,900 PSI	420 MPA
<b>Elongation</b>	27%

**Sizes and recommended current range (DC<±>)**

Diameter (mm)	2.6	3.2	4.0	4.8
Length (mm)	350	350	350	350
Amps	60-80	80-130	110-170	140-200