

SUNWELD 6010

Mild Steel Electrode



CLASSIFICATION

IS 814-04 : EC 4410X
AWS/A 5.1 : E 6010

CHARACTERISTICS

SUNWELD 6010 is a cellulosic coated all position electrode designed for pipe welding. Characterized by deeply penetrating forceful, spray type arc and giving thin brittle slag. Suitable for using in both conventional and stove pipe techniques. Weld metal possesses excellent mechanical properties and is a radiographic quality welds.

APPLICATIONS

Pressure vessels, tanks, low and high pressure pipe lines, root pass and filler passes in cross country pipe lines and specially suited for pressure pipe lines which cannot be welded from inside.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.010	0.55	0.35	0.020	0.025

MECHANICAL PROPERTIES OF ALL WELD METAL (TYPICAL) (AS PER IS 814-04)

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d)	Reduction in Area	Impact (CVN) at 0° C
401.0 N/mm ²	50 N/mm ²	27%	64.20%	72 Joules avg

PACKING DATA:

Size (mm)	Length (mm)	Current (Amp) AC OVC 50 or DC (+/-)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard Box
2.50	350	50-80	5 Kg	20 Kg
3.15	350	90-130	5 Kg	20 Kg
4.00	350	110-160	5 Kg	20 Kg

RECOMMENDATIONS:

Clean the joint faces to remove oil, grease or any foreign matter. Keep the arc as short as possible.