

Sureweld 6010

Sureweld 6010 is an all-position, quick solidifying cellulosic type electrode with minimal spatter and excellent arc control. It offers deep penetration and easy removal of slag which allows single and multiple pass welds of x-ray quality. Sureweld 6010 adapts exceptionally well to vertical and overhead projects on all mild steels. Sureweld 6010 is used extensively in the welding of holding tanks, freight cars, and truck chassis.

Specifications	
Classifications	ASME SFA 5.1 : E6010 AWS A5.1 : E6010
Approvals	ABS
Industry	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	Carbon Manganese

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	427 MPa (62 ksi)	490 MPa (71 ksi)	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-30 °C (-22 °F)	57 J (42 ft-lb)

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
0.10	0.36	0.20	0.01	0.01

Deposition Data			
Diameter	Current	Deposition Efficiency (%)	Deposition Rate @ 90% I max
2.4 x 356.0 mm (3/32 x 14.0 in.)	60-80 A	72.0 %	0.68 kg/h (1.5 lbs/h)
3.2 x 356.0 mm (1/8 x 14.0 in.)	85-130 A	72.1 %	1.01 kg/h (2.2 lbs/h)
4.0 x 356.0 mm (5/32 x 14.0 in.)	140-175 A	71.9 %	1.29 kg/h (2.8 lbs/h)
4.8 x 356.0 mm (3/16 x 14.0 in.)	170-210 A	69.7 %	1.59 kg/h (3.5 lbs/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	170-210 A	67 %	1.7 kg/h (3.7 lbs/h)