

Sureweld 10P

The red coated Sureweld 10P is an all-position cellulosic electrode developed for the pipe welding industry in order to improve ductility in the weld deposit while maintaining the standard welding characteristics needed for a pipe welding electrode. Sureweld 10P produces a steady, deep penetrating arc and maintains the proper keyhole in an open root. This electrode will produce X-ray quality joints in flat, horizontal, overhead, vertical-up, and vertical-down procedures. Sureweld 10P is recommended for welding API grades A25, A, B and X42 pipe and general structural, ship, barge and storage tank fabrication. It may also be used for welding root passes in higher grade pipe in some circumstances.

Specifications	
Classifications	ASME SFA 5.1 : E6010 AWS A5.1 : E6010
Approvals	ABS : E6010
Industry	Pipeline Industrial and General Fabrication Civil Construction

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	465 MPa (67 ksi)	550 MPa (80 ksi)	29 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-20 °C (-4 °F)	58 J (43 ft-lb)
As Welded	-30 °C (-22 °F)	39 J (29 ft-lb)

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
0.12	0.30	0.20	0.02	0.01

Deposition Data			
Diameter	Current	Deposition Efficiency (%)	Deposition Rate @ 90% I max
2.4 x 304.8 mm (3/32 x 12.0 in.)	40-75 A	72 %	0.7 kg/h (1.5 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	80-140 A	76.3 %	0.9 kg/h (2.0 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	130-175 A	73.6 %	1.3 kg/h (2.9 lbs/h)
4.8 x 350.0 mm (3/16 x 13.8 in.)	150-210 A	74.9 %	1.5 kg/h (3.3 lbs/h)