

## Sureweld 10P PLUS

Sureweld 10P Plus is a modified version of the standard 10P electrode and can be differentiated by its gray coating. It has also been developed for the pipe welding industry but has a more consistent burn-off and a more forgiving arc burn. This provides a better bead profile and sidewall fusion with lower spatter. Sureweld 10P Plus will maintain the proper keyhole in an open root and will produce X-ray quality joints in the flat, horizontal, overhead, vertical-up, and vertical-down procedures. Sureweld 10P Plus 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	
<b>Classifications</b>	ASME SFA 5.1 : E6010 AWS A5.1 : E6010
<b>Approvals</b>	ABS : AWS A5.1: E6010 CWB : CSA W48
<b>Industry</b>	Pipeline Industrial and General Fabrication Civil Construction

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

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Carbon Manganese

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	452 MPa ( 66 ksi )	555 MPa ( 80 ksi )	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-30 °C ( -22 °F )	65 J ( 48 ft-lb )

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
0.15	0.60	0.20	0.01	0.01

Deposition Data				
Diameter	Current	Voltage	Deposition Efficiency (%)	Deposition Rate @ 90% I max
0.0 x 305.0 mm	40-75 A	72 V		0.0 kg/h ( 0.0 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 )