

SUREWELD 6010 AWS A5.1: E6010

FEATURES

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. It can also be used to weld low alloy and high resistance steels where the thickness of the sections is 1/4" or less.

Sureweld 6010 is used extensively in the welding of bridges, high pressure pipes, holding tanks, boilers, freight cars and truck chassis.

CLASSIFICATIONS AND APPROVALS

- AWS A5.1: E6010
- ASME SFA 5.1

WELDING PROCESS

- SMAW (Stick)

INDUSTRIES

- General Fabrication
- Mobile Equipment
- Barges

TYPICAL MECHANICAL PROPERTIES

As Welded	
Yield Strength	62 ksi, 427 MPa
Tensile Strength	71 ksi, 490 MPa
Reduction in Area	65%
Elongation in 2"	28%

WELD METAL ANALYSIS

C	0.10%
Mn	0.36%
Si	0.20%
P	0.013%
S	0.013%

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 continued

DEPOSITION TABLE				
Diameter in (mm)	Optimal Current Amps	Current Range Amps	Deposition Rate lb/hr (kg/hr)	Efficiency %
3/32 (2.4)	70	60 - 80	2 (0.9)	60
1/8 (3.2)	120	85 - 120	2.4 (1.1)	63.9
5/32 (4.0)	160	140 - 175	3 (1.4)	71.9
3/16 (5.0)	200	170 - 210	3.7 (1.7)	67

PART NUMBER / PRODUCT INFORMATION		
Part Number	Description	UPC
812000008	SW 6010 3/32X14X5#VALP	662303202767
812000016	SW 6010 3/32X14X44#CTN	662303202774
812000024	SW 6010 1/8X14X5#VALP	662303202781
812000032	SW 6010 1/8X14X44#CTN	662303202798
812000040	SW 6010 5/32X14X5#VALP	662303202804
812000057	SW 6010 5/32X14X44#CTN	662303202811
812000065	SW 6010 3/16x14x44#CTN	662303202828