

DESCRIPTION

PROWELD E6010 is a quick-starting, cellulosic mild steel electrode with outstanding arc stability, penetration, and wash-in. It is ideal for welding in all positions and produces an X-ray quality weld with light slag that's easy to remove. It can be used to weld the following API 5L steels: Grade A, B, X-42, X-46, X-52, X-56, and for the root pass on material up to X-80. PROWELD E6010 is an excellent choice for pipe welding, construction, shipbuilding, general purpose fabrication, maintenance welding, out-of-position X-ray welds, and vertical or overhead plate welding.

FEATURES & BENEFITS

PROWELD 6010 has the following features & benefits;

- Quick-starting efficiency
- Excellent vertical down
- Excellent arc stability & drive
- Light slag
- All-position
- Easy arc striking and increased welding efficiency
- Faster travel speeds
- Excellent welding penetration, accuracy and efficiency
- Easy weld lay-in and smooth bead appearance
- Quick and easy cleaning of weld bead
- Welds in flat, horizontal, vertical, and overhead positions

DIAMETERS

2.5MM - 3/32", 3.2MM - 1/8", 4.0MM - 5/32", 5.0MM - 3/16"

RECOMMENDED WELDING TECHNIQUES

Arc Length - Average length (1/8" to 1/4")

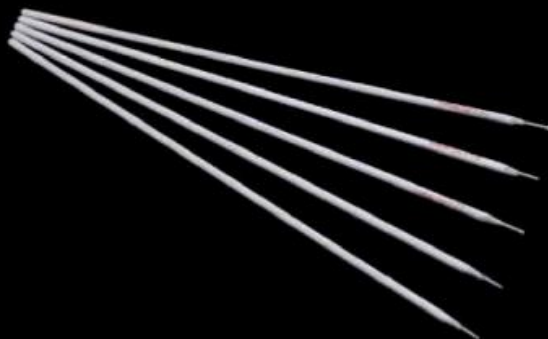
Flat - Stay ahead of puddle and use slight whipping motion

Vertical Up - Slight whipping or weaving technique

Vertical Down - Use higher amperage and faster travel, staying ahead of puddle

Overhead - Use similar technique as for vertical up, multi-pass for build-up

Pipe - Use downhill travel



DIAMOND PROWELD 6010

MILD STEEL CELLULOSIC
PIPE WELDING ELECTRODE

CLASSIFICATION

AWS A5.1/ASME SFA-5.1, F-3, A-1: E6010

CHEMICAL COMPOSITION OF WELD METAL ANALYSIS (%) (TYPICAL VALUES)

	C	Cr	Mn	Mo	Ni	Si	V
Weld Metal Analysis (%)	0.11	0.02	0.28	<0.01	0.02	0.14	0.01
AWS Spec (Max)	0.2	0.2	1.2	0.3	0.3	1	0.08

MECHANICAL PROPERTIES OF ALLWELD METAL

	As Welded	AWS Spec (min)
Ultimate Tensile Strength	73,000 psi (504 MPa)	60,000 psi (414 MPa)
Yield Strength	63,000 psi (432 MPa)	48,000 psi (331 MPa)
Percent Elongation in 2"	26%	22%
Reduction of Area	64%	Not required
CVN @ -20°F	52 ft•lbr (70 Joules)	20 ft•lbr (27 Joules)

WELDING PARAMETERS

Recommended welding parameters for the E - 6010 electrode may vary depending on the specific welding application, base material, and joint configuration. It is crucial to refer to the manufacturer's guidelines and conduct proper testing to determine the optimal parameters for your specific requirements.

STORAGE & HANDLING

To ensure the electrode's performance and longevity, please observe the following storage and handling recommendations:

- Store the electrodes in a dry environment at temperatures between 50°F to 100°F (10°C to 38°C).
- Keep the electrodes in their original packaging or a suitable container to protect them from moisture, dust, and other contaminants.
- Avoid exposure to extreme heat, humidity, or direct sunlight.
- Handle the electrodes with clean, dry gloves to prevent contamination.

Manufactured by;



SHANGHAI INDUSTRIES (PVT) LTD.

Manufacturers of Arc Welding Electrodes

Exclusively Manufactured for;



MILLWALA WELDING COMPANY PVT. LIMITED