E6010

CWB to CSA W48-14
Classification: E431 0
AWS/ASME A5.1 - 04 E6010

Suitable welding positions

Typical applications

Covering is low hydrogen, iron powder; common of welding applications include 71 ksi (490 MPa) class high tensile strength steels found in structural steels for buildings, bridge construction, storage tank fabrication, ship building, industrial and mining machinery fabrication.

Characteristics on usage

- Excellent penetration with good fusion makes this electrode the preferred choice for pipeline welding
- High ductility root weld
- Low slag volume and easy slag removal
- Very good bead appearance
- Re-dry the electrode at 70-80°C for 30-60 minutes prior to use

Typical chemical composition of all-weld-metal(%)

C	Si	Mn	p	S	Cr	Ni	Mo
0.11	0.36	0.63	0.015	0.013	0.03	0.02	0.01

Minimum typical mechanical properties of all-weld-metal

Yield Strength		Tensile Strength		Elongation	Impact Value
420 MPa	61 ksi	500 MPa	72 ksi	29%	40J (-30°c)

Dimensions and recommended currents

Vanguard Code	Diameter		Length		Amperage	
	inches	mm	inches	mm	F &HF	VU&OH
6178 2400	3/32	2.6	13.8	350	50-80	40 - 70
6178 3200	1/8	3.2	13.8	350	70 -110	60-100
6178 4000	5/32	4.0	13.8	350	110 -150	90-130
—	3/16	5.0	13.8	350	160 - 200	140 - 170

Standard packaging

Sleeve		Master Carton		Pallet	
4.5 Kgs	10 Lbs	22.5 Kgs	50 Lbs	1,125 Kgs	2,500 Lbs