

Mild Steel Electrodes

Alloy: WW6010
Class: E6010

Certification: AWS A5.1
ASME SFA A5.1

Alloy: E6010

Weld Process: Shielded Manual Metal Arc Electrodes

AWS Chemical Composition Requirements

Not Specified In AWS Specifications

Deposited Chemical Composition % (Typical)

C = 0.08 Mn = 0.50 Si = 0.20

Deposited All Weld Metal Properties %

(Typical) As-Welded

Yield Strength (PSI) 60,000
Tensile Strength (PSI) 68,200
Elongation in 2" (%) 26%

Deposited Charpy-V-Notch Impact Properties %

(Typical) As-Welded

33 ft. lbs. (tested at -5°F)

Recommended Welding Parameters

<u>Diameter</u>	<u>Amperage</u>
3/32"	40 – 80
1/8"	70 – 130
5/32"	100-180

Current (DCRP)

Application

E6010 is an all position electrode including vertical down hand.
Use on pipe or general welding on large diameter pipe.

