

## Sureweld 6010



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. Sureweld 6010 is used extensively in the welding of holding tanks, freight cars, and truck chassis.

<b>Classifications</b>	AWS A5.1: E6010
<b>Approvals</b>	ABS
<b>Industry</b>	Industrial and General Fabrication Mobile Equipment Ship/Barge Building

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

<b>Welding Current</b>	DC+,
<b>Coating Type</b>	High cellulose,

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Reduction in Area	Elongation
<b>100% CO<sub>2</sub></b>				
As Welded	427 MPa (62 ksi)	490 MPa (71 ksi)	65 %	28 %

### Typical Wire Composition %

C	Mn	Si	S	P
0.10	0.36	0.20	0.01	0.01

### Deposition Data

Diameter	Current	Deposition Rate	Efficiency %
3.2 mm (1/8 in.)	85-120 A	1.1 kg/h (2.4 lb/h)	63.9 %
5.0 mm (3/16 in.)	170-210 A	1.7 kg/h (3.7 lb/h)	67 %
2.4 mm (3/32 in.)	60-80 A	0.9 kg/h (2 lb/h)	60 %
4.0 mm (5/32 in.)	140-175 A	1.4 kg/h (3 lb/h)	71.9 %