

ROYAL – 6010 (E 6010)

AWS: A 5.1, E 6010 | IS: 814 EC 4310 EN ISO 2560 A E 38 3 C 21

Applications

Used in joining of cross country steel pipelines. Pressure Pipelines, Storage Tanks. Structural fabrication. Field works where deep penetration is required.

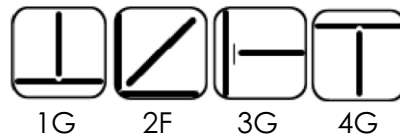
Characteristics on Usage

It is a medium coated all position cellulosic electrode, provides a deep penetration forceful arc with readily removable thin friable slag and deposits a flat bead with high melting rate. It can be used in all position particularly on multi pass welding in vertical and overhead positions, gives 100% radiographic quality of welds.

Notes On Usage

- Pay Attention not to use currents exceeding the recommended currents.
- As this electrode is prone to absorb moisture, store it with care.

Welding Positions



Approvals

E.I.L., IOCL, KNPC

MILD STEEL ELECTRODES

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.00 Max	0.03 Max	0.03 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
450 Min	370 Min	22.0 % Min	27 Joules Min

Packing and Welding Current

SIZE (mm)	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	300	1200	DC (+)	60 - 90
3.15 x 350	200	800		80 - 140
4.00 x 350	120	480		120 - 180
5.00 x 350	50	200		180 - 240