

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. It can also be used to weld low alloy and high resistance steels where the thickness of the sections is 1/4" or less. Sureweld 6010 is used extensively in the welding of holding tanks, freight cars, and truck chassis.

Classifications:	AWS A5.1:E6010
Industry or Segmentation:	Industrial and General Fabrication, Mobile Equipment, Ship/Barge Building

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Reduction in Area	Elongation
100% CO₂				
As Welded	427 MPa (62 ksi)	490 MPa (71 ksi)	65 %	28 %

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.10	0.36	0.20	0.01	0.01

Deposition Data

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