

## Shielded Metal Arc Welding

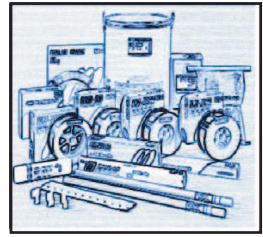
# ANU BOND - 6010(E 6010)

AWS: A 5.1, E 6010 IS: 814 EC 4310 X

Mild Steel Welding Electrodes

### **Application :**

Used in joining of cross country steel pipeline. Pressure Pipeline, 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.

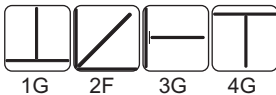
### **Chemical composition of All-Weld metal (%) as per AWS**

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

### **Mechanical properties of all-weld metal as per AWS**

UTS	Y. S.	Elongation	Impact
(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	( L=4d ) %	(CVN) AT -30 <sup>0</sup> C (J)
450 Min	370 Min	22.0 % Min	27 Joules Min

### **Welding Positions**



### **Packaging & Welding Current**

SIZE (mm)	Kg Per/ Packet	Kg Per/ Carton	Current (Amps)	In Amps
2.50 x 350	2.50 Kg	12.5 Kg	DC (+)	60-90
3.15 x 450	3 Kg	15 Kg		80-140
4.00 x 450	3 Kg	15 Kg		120-180
5.00 x 450	3 Kg	15 Kg		180-240

