



# KE6010

Electrode for Low Carbon Steel

## Classifications:

AWS- A5.1 E6010


E5.1 M E4310

ENISO 2560-A:E35 3 B 2 2

ENISO 2560-B:E4310A

## Characteristics and Applications:

KE6010 is high cellulose type covered electrode for DC(+) welding, suitable for the welding of pipelines, pressure pipe, oil tanker and boilers.

Welding Position: 

## Typical Chemical Composition of Weld Metal:

Wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.20	1.20	1.00	0.20	0.30	0.30	-	-	0.08
Tested	0.098	0.38	0.17	0.023	0.013	0.004	0.007	0.007	0.003

## Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	Y.S.(MPa)	El(%)	CVN J/
AWS	330	430	20	-
Tested	425	515	25	25/-30

## Notes on Usage:

1. Pay attention not to exceed proper current range and available with AC and DC welding.
2. Rebake the electrode at 80 - 100°C for 30 - 60 minutes before use.
3. Clean up the contaminations on the base metal to reduce welding defect.
4. Apply proper current to get excellent X-Ray soundness and mechanical properties.

## Sizes Available and Recommended Parameters:

Diameter(mm)	2.6 x 350	3.2 x 350	4.0 x 450	5.0 x 450
Current F	55 - 85	90 - 130	130 - 180	180 - 240
(Amp) OH,V	50 - 80	90 - 120	130 - 160	

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