

**FINE PW 6010**AWS : A 5.1, E 6010  
IS : 814 EC 4310 X**APPLICATIONS :-**

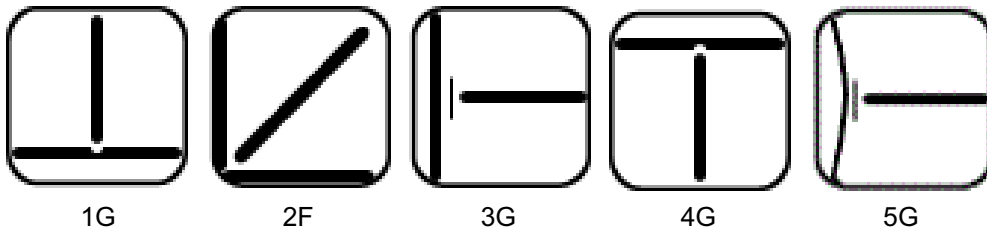
Used in joining of cross country steel pipelines. Pressure Pipelines, Storage Tanks. Structural fabrication. Field works where deep penetration

**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 :-**

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

**WELDING POSITIONS :-****CHEMICAL COMPOSITION OF WELD METAL**

C%	Mn%	Si%	S%	P%
0.20 Max	1.20 Max	1.0 Max	0.030 Max	0.030 Max

**MECHANICAL PROPERTIES OF WELD METAL**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 5d )	IMPACT (CVN) AT 0° C
450 min	370 min	22 % 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	AC 50 OCV / DC (-)	60 - 90
3.15 x 350	200	800		100 - 140
4.00 x 350	120	480		140 - 180
5.00 x 350	50	200		180 - 240