



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

USA 6010 Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
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ALLOY DESCRIPTION AND APPLICATION;

USA 6010 is a high cellulose coated electrode designed to provide a smooth stable arc forceful enough to achieve deep penetration into the base metal. This electrode exhibits high deposition efficiency and low spatter loss. It produces a weld puddle that wets and spreads well, yet sets up fast enough to make this electrode ideal for vertical up or vertical down welding techniques. USA 6010 electrodes produce a flat weld bead with coarse ripples and a thin easily removable slag. USA 6010 electrodes may be used in the flat, horizontal, vertical or overhead welding positions.

TYPICAL WELDING PROCEDURES; DCEP

Diameter	Amps (Flat)	Volts
3/32"	50-70	25-30
1/8"	80-120	25-30
5/32"	110-160	25-30
3/16"	150-200	25-30

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

	AWS Spec.	Weld metal		AWS Spec.	Weld metal
Carbon	0.20 max	0.10			
Manganese	1.20 max	0.47	Tensile Strength (ksi)	60 min.	70
Silicon	1.00 max	0.20	Yield Strength (ksi)	48 min.	61
Phosphorus	N/A	0.014	Elongation in 2" (%)	22% min.	30%
Sulphur	N/A	0.012	Charpy V-notch at -20°F	20 ft·lbs min.	36 ft·lbs

AVAILABLE SIZES: TE 6010 = 3/32", 1/8", 5/32", 3/16"

SPECIFICATIONS; ANSI/AWS A5.1 E6010
ASME SFA 5.1 E6010

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