

VALIANT

VALIANTWELD - 6010

AWS : A5.1 : E 6010

Valiantweld -6010 is a light coated, cellulosic DC(+) electrode. Ideally suited for welding in all position including vertical down. The weld metal Possesses good mechanical properties. Ideal for stove pipe technique & faster welding. Welds are of radiographic quality.

CHEMICAL COMPOSITION

C	Mn	Si
0.07	0.50	0.20

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	YS (Kg/mm ²)	EI (L = 4D)%	CVN Impac strength at (Joules)
48.2	39.6 EI	27.5	20°C -70, 30°C - 50

WELDING PARAMETERS

	Size (mm)	Current (Amp.)
DC (+)	5.00 X 350	170-210
	4.00 X 350	130-170
	3.15 X 350	90-130
	2.50 X 350	60-90

APPLICATION

Typical application include welding of pipes,tubes, ducts etc.

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