B-10 FAMILIARC™

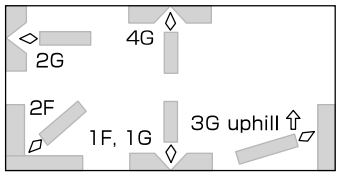
Stick electrode

Features:
- Suitable for butt and fillet welding of thin and thick plates (up to 20mm)
- Better usability

Classification: AWS A5.1 E6019

Redrying Conditions: 70~100℃x0.5~1h
Identification color: 1st Green
Polarity: AC, DCEP, DCEN

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	19	170W, 100H, 380L
3.2	350	5	20	30	170W, 105H, 380L
4.0	400	5	20	56	170W, 95H, 430L
5.0	400	5	20	84	170W, 95H, 430L
6.0	450	5	20	136	170W, 90H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.10	0.20
Si	0.09	1.00
Mn	0.39	1.20
P	0.016	0.035
S	0.008	0.035
Ni	0.01	0.30
Cr	0.02	0.20
Mo	<0.01	0.30
V	<0.01	0.08

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	40~70
3.2	80~130	60~110
4.0	120~180	100~150
5.0	170~250	130~200
6.0	230~300	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	400	331min.
TS (MPa)	450	414min.
El on 4d (%)	30	22min.
IV -18℃ (J)	68	27min.