KOBE-6010 FAMILIARC™

Stick electrode

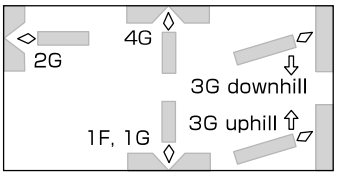
Features:
- Suitable for butt welding of pipes
- Excellent usability in vertical downward welding

Classification: AWS A5.1 E6010

Identification color: 1st Yellowish green

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.4	300	2	20	13	300W, 100H, 330L
3.2	350	5	20	27	175W, 115H, 380L
4.0	350	5	20	40	175W, 115H, 380L
4.8	350	5	20	58	175W, 115H, 380L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.12	0.20
Si	0.15	1.00
Mn	0.51	1.20
P	0.009	0.035
S	0.008	0.035
Ni	0.02	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, 2G, 3G uphill, 3G downhill, 4G
2.4	40~75
3.2	70~130
4.0	90~180
4.8	140~225

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	430	331min.
TS (MPa)	510	414min.
El on 4d (%)	27	22min.
IV -29℃ (J)	63	27min.