

**ROYAL - 6010 (E 6010)**AWS : A 5.1, E 6010  
IS : 814 EC 4310 X**Applications**

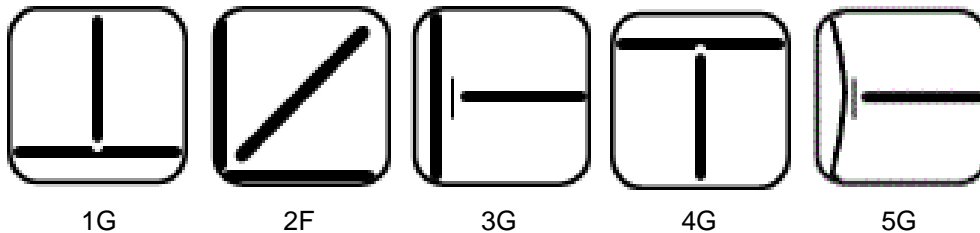
Used in joining of cross country steel pipelines. Pressure Pipelines, Storage Tanks. Structural fabrication. Field works where deep penetration is required.

**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	1.00 Max	0.03 Max	0.03 Max

**Mechanical Properties Of Weld Metal**

U.T.S. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	IMPACT ( CVN ) AT - 30° C ( J )
450 Min	370 Min	22.0 % Min	27 Joules Min

**Approvals**

E.I.L. ,IOCL ,KNPC

**Packing and Welding Current**

SIZE ( mm )	PIECES PER PACKET	PIECES PER CARTON	Current (Amps)	In Amps
2.50 x 350	300	1200	DC (+)	60 – 90
3.15 x 350	200	800		80 – 140
4.00 x 350	120	480		120 – 180
5.00 x 350	50	200		180 – 240