DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM6010 Premium Electrode

Classification: **E6010**

AWS A 5.1 / ASME SFA 5.1

DuraMax DM6010 is a CELLULOSIC COATED ELECTRODE FOR PIPE WELDING

Characteristics

A medium coated, cellulosic type electrode with forceful and spray arc, ensures deep penetration in all position including vertical down hand. Weld metal is of radiographic quality coupled with easy slag detachability, weld metal is ductile.

Typical Applications on Usage

1) Suitable for tank & vessels.
2) General fabrication.
3) Vehicles.
4) Railway wagons and machinery.
5) Ship building construction, light structural steel works
6) Storage tanks etc.
7) Ideally suitable for all position pipe welding and joints.

RE-DRY CONDITIONS: Not Recommended

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.20 max	0.40 - 0.80	0.30 max	0.030 max	0.030 max	0.30 max	0.20 max	0.30 max	0.08 max

All Weld Mechanical Properties

YS (N/mm^2)	UTS (N/mm^2)	EL % (1=4d)	CHARPY "V" NOTCH IMPACT AT
330 - 450	430 - 560	22 - 30	Minus -30°C : 50 -80 J

Sizes available and recommended currents (DC +)

SIZE	3/32	1/8	5/32
AMPS	50 ~ 80	90 ~ 130	110 ~ 160

POLARITY: DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration.
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930