



T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
 4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

TECHNICAL SPECIFICATION SHEET

E6010 COVERED ELECTRODE

ISO 9001
 Cert. No. 31598

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

NOMINAL COMPOSITION:

Carbon	.20%	Iron	Balance
Manganese	1.20%	Silicon	1.0%
Sulfur	N.S.	Phosphorus	N.S.
Nickel	.30	Chrome	.20
Molybdenum	.30	Vanadium	.08

TYPICAL MECHANICAL PROPERTIES AS WELDED

Tensile Strength (psi)	60,000 min. psi
Yield Strength (psi)	48,000 min.
Elongation in 2"	22.0 min.

WELDING PROPERTIES:

E6010 is a versatile electrode that can give you deep penetrating weldments that can easily go through dirty, rusty, greasy oils or painted steel. 6010 is very good in the vertical and overhead position you will find slag easy to remove, and 6010 is capable of X-ray welds out of position.

*** RECOMMENDED WELDING PARAMETERS:**

<u>AMPS</u>	<u>3/32x12</u>	<u>1/8x14</u>	<u>5/32x14</u>
DCEP	40-70	75-130	90-175

- All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.

SPECIFICATION COMPLIANCE: ANSI/AWS A5.1 & ASME SFA 5.1 E6011

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

Additional information available at our web site: www.harrisproductsgroup.com

3/08 MK