



Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925

USA 6010P Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

USA 6010P with its fast freeze are recommended for pipe welding and many overhead and vertical welding positions on carbon steels. This deep penetrating rod has a forceful, spray type arc needed for applications such as square edge butt welds, galvanized, greasy, painted or poorly cleaned base metals and many other welding repairs. The weld bead has a thin light slag that produces a relatively flat smooth bead ripple.

TYPICAL WELDING PROCEDURES; DCEP

Diameter	Amps (Flat)	Volts
3/32"	40-75	25-30
1/8"	65-125	25-30
5/32"	100-180	25-30
3/16"	140-130	25-30

Use a light whipping or weaving motion staying ahead of the puddle

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

	AWS Spec.	6010P		AWS Spec
Carbon	0.20 max.	0.11		
Manganese	1.20 max.	0.60	Elongation in 2"(%)	22% min.
Silicon	1.00 max.	0.21	Yield Strength (psi)	48,000 min.
Phosphorus	N/A	0.015	Tensile Strength (psi)	60,000 min.
Sulphur	N/A	0.006	Charpy V-notch at -20°F	20 ft-lbs min.
Nickel	0.30 max.	0.028		
Chromium	0.20 max.	0.017		
Molybdenum	0.30 max.	0.034		
Vanadium	0.08 max.	0.010		

AVAILABLE SIZES: TE 6010P = 3/32", 1/8", 5/32", 3/16"

SPECIFICATIONS; ANSI/AWS A5.1 E6010
ASME SFA 5.1 E6010

EAST COAST
7010-G Reames Rd
Charlotte, NC 28216
Tel (888) 522-8296
Fax (704)598-6673

GULF COAST
4855 Alpine Drive #190
Stafford, TX 77477
Tel (877) 711-9274
Fax (281)313-6332

WEST COAST
8535 Utica Ave
Rancho Cucamonga, CA 91730
Tel(800)830-9033
Fax (909)291-4586



7-2008 DC

Warehouse Distribution Center – Dayton, Ohio

Head Office – Puyallup, Washington

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