

RATNA 6010

Cellulosic coated electrode for pipe welding

CLASSIFICATION : AWS/SFA-5.1: E 6010
IS-814: EC 4410X

APPROVAL :

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.

APPLICATION :

- 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 CONDITION : Not recommended

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.20 max.	0.40-0.80	0.30 Max.	0.030 Max	0.030 Max

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
330-450	430-560	22-30	Minus 30 ⁰ C : 50-80 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+) Amps	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	270	1080
3.15/ 3.20 X 350	1/ 8" X 14"	90-130	160	640
4.00 X 350	5/ 32" X 14"	110-160	105	420

Customer packing on request.