

Inweld 6010 Deep Penetrating – Fast Freeze

Alloy E6010
AWS A5.1 E6010

DC + (reverse polarity)



Description and Applications:

A deep-penetrating, fast-freeze electrode commonly used for joining pipe, carbon steel, galvanized steel and some low alloy steels. An excellent choice for pipe welding.

Strong forceful arc allows this electrode to be used in all-positions including vertical-up, vertical-down, overhead and flat or horizontal. Performs great vertical-down.

Used in multiple-pass applications where sound welds are critical.

X-ray quality weld deposits with a coarse ripple bead. A thin friable and easily removable slag.

Typical applications include pressure pipes, pressure vessels, oil marine platforms, storage tanks, ship hulls, buildings, galvanized steel storage tanks.

Procedure:

Clean the weld area of all contaminants. Bevel heavy sections to a 60 vee.

Always use this electrode with DC+ (reverse polarity). Set your amperage to the proper range for the size electrode and the welding position you are using. A medium arc length of approximately 1/8" maintained ahead of the weld puddle will yield good wetting action and allow unwanted gases to escape. Flat and horizontal welding: hold the electrode at an angle 10-15 off 90 and use a slight back and forth whipping motion. Overhead welding: use a slight circular motion.

Vertical-down welding: use stringer beads or a slight weaving technique keeping the weld puddle in place by pointing the electrode arc up into the puddle. Be sure to choose amperage in the upper end of the recommended range. Vertical-up welding: should be done using the shelf or step method, adding layer on top of layer. Do not use the whipping motion. Use amperage setting in the lower end of the recommended range. Allow the part to air cool and remove slag with a chipping hammer and brush to a nice finish.

Recommended Parameters	Diameter	Recommended Amperage	
		(F)	(V & O)
	3/32" (2.4mm)	60-80	40-70
	1/8" (3.2mm)	80-120	70-110
	5/32" (4.0mm)	110-160	110-150
	3/16" (4.8mm)	140-190	130-170

Warning

- This product, when used for welding or cutting, produces fumes or gases which may contain chemicals known to the state of California to cause birth defects (or other reproductive harm), and in some cases cancer. (California Health & Safety Code 25249.5 et seq.)
- Read American National Standards Z49.1, "Safety in Welding Cutting and Allied Processes," from American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126; OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Government Printing Office, Washington, DC 20402.

Fumes and Gases can be hazardous to you health.

- Before use, read and understand the materials Material Safety Data Sheet (MSDS), the manufacturer's instructions and your employers safety practices.
- If MSDS is not enclosed, obtain one from your employer.
- Keep your head out of the fumes. See section 5 of the MSDS for specific fume concentration limits.
- Use enough ventilation exhaust at the arc or both to keep fumes and gases from your breathing zone and general area. If needed, use a respirator.
- No hazards exist before this product is used in arc welding. Electric Shock can kill.
- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrical parts.
- ARC Rays can injure eyes and burn skin.
- Wear welding helmet with correct filter.
- Wear correct eye, ear and body protection.
- Welding can cause fire or explosion" Do not weld near flammable material.
- Watch for fire, keep extinguisher nearby.



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