



# RASI E 6010

premium

PIPE WELDING  
ELECTRODES

## TECHNICAL SPECIFICATION SHEET

### CHARACTERISTICS

RASI-PW 6010 is a medium coated all position including vertical down position cellulose electrode with a forceful penetrating arc giving thin slag and flat bead. The Weld metal is highly ductile and Radiographic quality.

### APPLICATIONS

RASI PW 6010 is used for Pipe lines, storage tanks, pressure vessels, Tank Wagons, Galvanized pipes, and structural fabrications where root runs for achieving good penetration is required.

### CLASSIFICATIONS

IS : 814 E C-4310 X  
AWS : A5.1 E - 6010

### CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.12%	Silicon - 0.30%
Manganese - 0.55%	Sulfur - 0.03%
Phosphorus - 0.03%	Iron - Balance

Note: Single Values shown above are maximum

### MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm<sup>2</sup>) - 410 - 510  
Yeild Strength (N/mm<sup>2</sup>) - 330 MIN.  
Elongation (L-5d) % - 25-30.

### WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 50-80 Amps  
Ø 3.15 mm - 80-120 Amps  
Ø 4.00 mm - 120-150 Amps  
Ø 5.00 mm - 150- 200 Amps.

**\*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- [info@rasielectrodes.com](mailto:info@rasielectrodes.com)**

storage - Store in warm and dry place. If damped re dry at 100-110°C for 30 minutes.

\*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.

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