

NOUVE® 6010

Designation

AWS/SFA-5.1: E6010

UNS No. W06010

Welding Positions



Features

- ▶ Excellent arc characteristics
- ▶ Low moisture re-absorption
- ▶ Low spatter level
- ▶ Low smoke level
- ▶ Quick and easy slag removal
- ▶ Radiography quality

Applications

Welding of ship buildings, pressure pipe, tanks with plain or galvanized surfaces and steel casting repairs.

Type of Current

Direct Current Electrode Positive (DCEP)

Recommended Welding Techniques

- GENERAL : Electrode positive, work negative (DCEP)
- ARC LENGTH : Short arc
- STORAGE : Re-dry electrodes to 70°C to 80°C for 30 minutes before use

Weld Metal Chemistry

WELD METAL ANALYSIS (%)	AWS SPEC	TYPICAL
Carbon (C)	0.20 max	0.10
Manganese (Mn)	1.20 max	0.650
Silicon (Si)	1.00 max	0.20
Phosphorous (P)	Not Specified	0.014
Sulphur (S)	Not Specified	0.012
Nickel (Ni)	0.30 max	0.023
Chromium (Cr)	0.20 max	0.017
Molybdenum (Mo)	0.30 max	≤ 0.03
Vanadium (V)	0.08 max	≤ 0.01

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Mechanical Properties (as welded)

MECHANICAL TESTS	AWS SPEC		TYPICAL	
Tensile Strength	62,367 psi (430 MPa) Minimum		68,168 psi (470 MPa)	
Yield Strength	47,863 psi (330 MPa) Minimum		52,214 psi (360 Mpa)	
Elongation % in 2"	22% Minimum		Above 23%	
Impact Energy (min)	Average Value	27J at -30°C	Single Value	41J at -30°C
			Average Value	45J at -30°C

Dimension, Current Condition & Packing Data

DIAMETER (IN)	DIAMETER (MM)	PACKAGE		CURRENT CONDITION (DC+) Amps
		INNER	OUTER	
3/32	2.5	2.5 Kg	20 Kg	60 - 90
1/8	3.15	2.5 Kg	20 Kg	80 - 110
5/32	4.0	3.5 Kg	21 Kg	110 - 150
3/16	5.0	3.5 Kg	21 Kg	150 - 180