

SMAW Electrodes

G10

AWS A5.1M E4310 / A5.1 E6010
JIS Z 3211 E4310
ISO 2560-A-E 35 3 C

Product Features:

- High cellulose type covered electrode for DC use.
- High arc penetration and concentration.
- Easy slag removal.
- Fast solidification of weld metal, good for narrow groove root pass.

Applications:

- Suitable for moderate thickness steel work one side butt joint high pressure piping root pass.

Typical chemical composition of all weld metal (wt%)

C	Si	Mn	P	S	Fe
0.09	0.37	0.52	0.014	0.006	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-30°C) J
385	477	28	56

Size (mm) & recommended welding parameters (A) DC+

Diameter / Length	2.6/300	3.2/350	4.0/350	5.0/350
Flat position	60~80	75~110	120~160	160~210
Vertical / overhead position	50~75	60~90	105~145	130~180

Note:

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