

TC-10

AWS A5.1 E6010
EN ISO 2560-B-E4310 A
JIS Z 3211 E4310

Characteristics and Applications:

TC-10 is designed for DC(+) welding. The welding in all position can produces stable arc, good slag release, and deep penetration. It is suitable for the welding of pressure pipes, oil tanks, and boilers.

Notes on usage:

1. Be sure to clean up the contamination on the base metal.
2. Dry the electrodes at 60~70°C for 30 minutes.
3. Use proper low currents as recommended.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Ni	Cr	Mo	V
AWS	≤0.20	≤1.20	≤1.00	-	-	≤0.30	≤0.20	≤0.30	≤0.08
EN ISO	≤0.20	≤1.20	≤1.00	-	-	≤0.30	≤0.20	≤0.30	≤0.08
Typical value	0.13	0.45	0.31	0.015	0.008	0.007	0.028	0.001	0.009

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30°C (-20°F)
AWS	≥ 330(48)	≥ 430(60)	≥ 22	≥ 27(20)
EN ISO	≥ 330(48)	≥ 430(60)	≥ 20	≥ 27(20)
Typical value	470(68)	530(77)	25	42(31)

Welding position:



Sizes and recommended current range (DC <+>):

Diameter (mm)	2.6	3.2	4.0	4.8
Length (mm)	350	350	350	350
Amps	60-80	80-130	110-170	140-200

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