

TC-10

AWS A5.1 E6010
EN499 E 42 2 C 22

Characteristics and Applications:

TC-10 is designed for DC(+) welding. The welding in all position can be done with 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 contaminations on the base metal.
2. Dry the electrodes at 60°C for 30-60 minutes.
3. Use low currents.

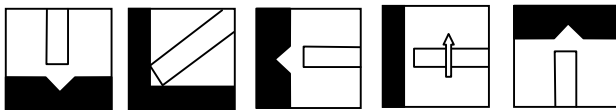
Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.12	0.50	0.30	0.015	0.01

Typical mechanical properties of weld metal

YS (MPa)	TS (MPa)	EL %	CVN, J	
			0°C	-30°C
420	500	25	64	47

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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