

## Features & Applications:

XTR Select E6010 is a high cellulose type electrode designed for pipeline welding in all positions. It has an easy control deep penetrating arc with very low spatter levels and easy slag removal. It is also ideally suited for difficult maintenance repairs. Easily welds steels that have been galvanized, painted, rusted, or otherwise contaminated in service. Misaligned parts or difficult to access areas are also easily remedied with this electrode.

- Adverse conditions mild steel electrode. Excels on rusty, greasy, poor fitting joints in all positions
- Can weld through 1/2 inch (12mm) of surface contamination without porosity
- Can bridge gaps as wide as 3/8 inch (9mm)
- Electrode can be bent without flux chipping
- Slag can be welded over without removal

## Chemistry:

	Typical	AWS Spec.	Single values are max.
Carbon (C)	0.090	0.200	
Manganese (Mn)	0.590	1.200	
Silicon (Si)	1.000	1.000	
Nickel (Ni)	0.300	0.300	
Chromium (Cr)	0.200	0.200	
Molybdenum (Mo)	0.300	0.300	
Vanadium (V)	0.060	0.080	



## Mechanical Properties: (All weld metal analysis, Typical Weight %)

	Typical	AWS Spec.	Single values are min.
Tensile Strength	88,000	60,000 psi	
Yield Strength	80,000	48,000 psi	
Elongation in 2" (%)	28	22	
Charpy V-Notch	70J: -20°C	15 ft-lbs. @ -20°F	
Diffusible Hydrogen (mL/100g weld metal)	nr	nr	



Coating High Cellulose Sodium  
Flux Coating, Color Grey

## Welding Positions:

F, V, OH, H

## Operating Parameters: Coated Electrode/Rod (SMAW), DC Reverse (+)

### Formula: 1063

Procedures & results may vary with any change in position, equipment being used, base metal and base metal cleanliness.

Diameter	Amperage Range	Weldmetal Electrode	Electrodes per lb. (kg) of Weldmetal	Arc Time of Deposition min/lb. (kg)	Electrodes (Rods) per Lb. Packaged
1/16 (1.6mm)	nr	--	--	--	--
3/32 (2.4mm)	25-75	.27oz (7g)	45 (100)	37 (81)	31
1/8 (3.2mm)	35-125	.56oz (15g)	25 (56)	25 (56)	18
5/32 (4.0mm)	50-160	.9oz (25g)	17 (38)	20 (45)	11
3/16 (4.8mm)	75-200	1.35oz (38g)	12 (26)	15 (34)	8
1/4 (6.4mm)	nr	--	--	--	--



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Ver. 11.8.2021