

# Product Data Sheet

MILD STEEL ELECTRODE

**BRAND NAME** VJ 6010

**AWS/ASME Class** E6010

**SPECIFICATION** SFA 5.1



## Features and Applications :

VJ 6010 is a high-cellulosic sodium electrode designed for deep penetration and radiographic-quality welds in all positions, including vertical down. Its forceful, spray-type arc ensures excellent root penetration, making it ideal for pipelines, storage tanks, pressure vessels, structural steels, shipbuilding, bridges, and buildings.

## CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.07
Mn	1.00
Si	0.40
S	0.02
P	0.02

## MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	420
UTS (MPa)	500
El (%)	25
Charpy V at -30°C (J)	70

## DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (kg)
	Min	Max	
Dia x Length			Qty / Pkt
2.50 x 350	40	70	3.5
3.15 x 350	70	110	3.5
4.00 x 350	110	160	3.5
5.00 x 350	160	210	3.5

## CURRENT : DC (+)

## WELDING POSITION:

