# **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  $^\circ\!\mathrm{C}$  for 30 minutes.
- 3. Use proper low currents as recommended.

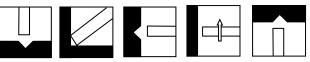
## Typical chemical composition of weld metal (wt%):

С	Mn	Si	Р	S
0.13	0.45	0.35	0.02	0.015

#### 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)
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	110-160	140-180

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