

Pipemaster® Pro-60



AWS E6010

WELDING POSITIONS:



FEATURES:

- Quick-starting efficiency
- All-position
- Excellent vertical down
- Excellent arc stability
- Superior arc drive
- Excellent wash-in
- Light slag

BENEFITS:

- Easy arc striking and increased welding efficiency
- Welds in flat, horizontal, vertical and overhead positions
- Faster travel speeds
- Welding accuracy and efficiency
- Excellent penetration
- Easy weld lay-in and smooth bead appearance
- Quick and easy cleaning of weld bead

APPLICATIONS:

- Construction
- Shipbuilding
- General purpose fabrication
- Maintenance
- Out-of-position X-ray welds
- Pipe and plate welding

ARC LENGTH: Average length (1/8" to 1/4")

FLAT: Stay ahead of puddle and use slight whipping motion

VERTICAL-UP: Slight whipping or weaving technique

VERTICAL-DOWN: Use higher amperage and faster travel, staying ahead of puddle

OVERHEAD: Use similar technique as for vertical-up, multi-pass for build-up

PIPE: Use downhill travel; DCEN may be used for root passes

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

STORAGE: Dry at room temperature

RECONDITIONING: Not recommended

TYPICAL WELD METAL CHEMISTRY* (Chem Pad):

Weld Metal Analysis (%)	E6010	AWS Spec
Carbon (C)	0.15	0.20
Manganese (Mn)	0.41	1.20
Silicon (Si)	0.13	1.00
Nickel (Ni)	0.04	0.30
Chromium (Cr)	0.03	0.20
Molybdenum (Mo)	0.01	0.30
Vanadium (V)	<0.01	0.08

Note: AWS specification single values are maximums.

TYPICAL MECHANICAL PROPERTIES* (As Welded):

Mechanical Tests	E6010	AWS Spec
Tensile Strength	71,000 psi (490 MPa)	60,000 psi (414 MPa)
Yield Strength	58,000 psi (403 MPa)	48,000 psi (331 MPa)
Elongation % in 2" (50 mm)	27%	22%
Reduction of Area	55%	Not required

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded):

CVN Temperatures	E6010	AWS Spec
Avg. @-20°F (-29°C)	40 ft•lbs (55 Joules)	20 ft•lbs (27 Joules)

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers LLC expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.1 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers LLC.

Pipemaster[®] Pro-60

Diameter Inches (mm)		Type of Current	Amps	Volts	Deposition Rate lbs/hr (kg/hr)		Deposition Efficiency %
1/8	(3.2)	DCEP	110	26-27	1.6	(0.7)	54
5/32	(4.0)	DCEP	140	26-28	1.9	(0.9)	55

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**

STANDARD DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543, or (937) 332-5188 for International Customer Service.

Diameter Inches (mm)	50-lb. (22.7kg) Can
Net Pallet Weight	3000-lb. (1361 kg)
1/8 (3.2)	S129144-035
5/32 (4.0)	S129151-035

CONFORMANCES AND APPROVALS:

- **AWS A5.1**, E6010, ASME SFA 5.1, F-3, A-1, E6010
- **ASME SFA 5.1**, F3, A1, E6010
- **ABS**, E6010

TECHNICAL QUESTIONS? For technical support of Hobart Filler Metals products, contact the Applications Engineering department by phone toll-free at 1-800-532-2618 or by e-mail at Applications.Engineering@hobartbrothers.com

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36th St., Miami, FL 33166 (can also be downloaded online at www.aws.org); OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Safety Data Sheets on any Hobart Brothers LLC product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers LLC is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

Pipemaster is a registered trademark of Hobart Brothers LLC, Troy, Ohio.

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