Pipemaster® Pro-60

AWS A5.1: E6010

WELDING POSITIONS:

FEATURES:	BENEFITS
• Quick-starting efficiency	• Easy arc striking and increased welding efficiency
• All Position	• Welds in flat, horizontal, vertical, and overhead positions
• Excellent vertical down	• Faster travel speeds
• Excellent arc stability	• Welding accuracy and efficiency
• Superior arc drive	• Excellent penetration
• Excellent wash-in	• Easy weld lay-in and smooth bead appearance
• Light slag	• 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 with either DCEP or DCEN for root pass welding
TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)
STORAGE: Product should be stored dry at room temperature
RECONDITIONING: Not Recommended

TYPICAL WELD METAL CHEMICAL COMPOSITION* (Chem Pad):

Weld Metal Analysis (%)		AWS Spec (max)
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		AWS Spec.
Tensile Strength	71,000 psi (490 MPa)	60,000 psi (414 MPa) Min.
Yield Strength	58,000 psi (403 MPa)	48,000 psi (331 MPa) Min.
Elongation % in 2" (50 mm)	27%	33% Minimum
Reduction of Area	55%	Not Required

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

CVN Temperatures		AWS Spec.
Avg. @ -20°F (-30°C)	40 ft-lbs (55 Joules)	20 ft-lbs (27 Joules) Minimum

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TYPICAL OPERATING PARAMETERS*:

Diameter		Type of Current	Amps	Volts	Deposition Rate		Deposition Efficiency
Inches	(mm)				lbs/hr	(kg/hr)	
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 the steel being welded.**

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

Diameter		50-lb. (22.7 kg) Hermetically Sealed Can
Inches	(mm)	
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**, 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 36 St, Miami, FL 33166-6672 (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 Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

Revision Date: 220225 (Replaces 210728)

HOBART FILLER METALS