

## Covered Electrodes

AWS E6010

# KCL-10

AWS E6011

# KCL-11

## Mild Steel

AWS E6013

# KR-3000

### Typical Applications

Used in pressure piping, ship building, tank assembly, galvanized steels and casting repairs.

Welding of steel plates and sheet, piping and ship construction.

Used for light to medium construction work for all position. Excellent operator appeal. Works well with poor fit-up applications.

### Characteristics Of Usage

1. Excellent penetration with good fusion makes this the preferred choice for pipeline welding.
2. Low slag volume results and easy slag removal with good bead appearance.

1. Excellent all position general construction electrode designed for use on both DC and AC current.
2. Slightly higher slag volume than E6010 with good bead appearance.
3. Produces good mechanical properties, meets x-ray requirements.

1. Excellent striking and restriking properties.
2. Excellent slag removal and arc transfer.
3. Excellent bead appearance without undercut.

### Weld Metal Composition

Carbon	0.10 %
Silicon	0.20 %
Manganese	0.47 %
Phosphorus	0.014 %
Sulphur	0.012 %

Carbon	0.08 %
Silicon	0.37 %
Manganese	0.66 %
Phosphorus	0.015 %
Sulphur	0.013 %

Carbon	0.07 %
Silicon	0.32 %
Manganese	0.45 %
Phosphorus	0.015 %
Sulphur	0.012 %

### Mechanical Properties

<b>Y-P (psi)</b>	60,916
<b>T-S (psi)</b>	72,519
<b>EI</b>	24 %
<b>V-Notch</b>	37 ft/lb @ -20°F

<b>Y-P (psi)</b>	59,465
<b>T-S (psi)</b>	72,519
<b>EI</b>	24 %
<b>V-Notch</b>	37 ft/lb @ -20°F

<b>Y-P (psi)</b>	62,366
<b>T-S (psi)</b>	69,618
<b>EI</b>	29 %
<b>V-Notch</b>	52 ft/lb @ -20°F

### Available Sizes / Rec. Parameters

Dia inches	Amp	
	Flat	V&OH
3/32 (2.4)	50-80	40-70
1/8 (3.2)	70-110	60-100
5/32 (4.0)	110-150	90-130
3/16 (5.0)	160-200	140-170

Dia inches	Length inches	Amp	
		Flat	V&OH
3/32 (2.4)	11.8 (300)	50-80	
1/8 (3.2)	13.8 (350)	70-110	
5/32 (4.0)	13.8 (350)	110-150	
3/16 (5.0)	13.8 (350)	160-200	

Dia inches	Length inches	Amp	
		Flat	V&OH
3/32 (2.4)	13.8 (350)	60-100	60-90
1/8 (3.2)	13.8 (350)	80-130	80-120
5/32 (4.0)	15.7 (400)	130-180	90-140
3/16 (5.0)	15.7 (400)	160-220	120-190
1/4 (6.0)	17.7 (450)	210-280	-

### Packaging

10# (5 kg) Carton

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10# (5 kg) Carton

[Detailed Packaging Information](#)

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[Detailed Packaging Information](#)

### Welding Positions

Flat, Vertical, Horizontal and Overhead

Flat, Vertical, Horizontal and Overhead

Flat, Vertical, and Overhead

### Approved

ABS, BV, CWB, LR, NK, JIS

ABS, CWB, DNV, LR, JIS

ABS, BV, CWB, DNV, GL, KR, LR, NK, JIS, KS



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