

Sureweld 10P



The red coated Sureweld 10P is an all-position cellulosic electrode developed for the pipe welding industry in order to improve ductility in the weld deposit while maintaining the standard welding characteristics needed for a pipe welding electrode. Sureweld 10P produces a steady, deep penetrating arc and maintains the proper keyhole in an open root. This electrode will produce X-ray quality joints in flat, horizontal, overhead, vertical-up, and vertical-down procedures. Sureweld 10P is recommended for welding API grades A25, A, B and X42 pipe and general structural, ship, barge and storage tank fabrication. It may also be used for welding root passes in higher grade pipe in some circumstances.

Classifications	AWS A5.1 : E6010 ASME SFA 5.1
Industry	Civil Construction Industrial and General Fabrication Pipeline

Welding Current	DC+
Coating Type	High cellulose

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-18 °C (0 °F)	37 J (27 ft-lb)
As Welded	-29 °C (-20 °F)	30 J (22 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.12	0.30	0.20	0.02	0.01

Deposition Data

Diameter	Optimal Amps	Current	Deposition Rate	Deposition Efficiency %
3.2 mm (1/8 in.)	100 A	80-140 A	0.9 kg/h (2.1 lb/h)	76.3 %
3.2 mm (1/8 in.)	130 A	80-140 A	1 kg/h (2.3 lb/h)	68.8 %
4.8 mm (3/16 in.)	160 A	150-210 A	1.5 kg/h (3.3 lb/h)	74.9 %
4.8 mm (3/16 in.)	190 A	150-210 A	1.6 kg/h (3.5 lb/h)	69.7 %
2.4 mm (3/32 in.)	75 A	40-75 A	0.7 kg/h (1.5 lb/h)	72 %
4.0 mm (5/32 in.)	140 A	130-175 A	1.3 kg/h (2.8 lb/h)	73.6 %
4.0 mm (5/32 in.)	170 A	130-175 A	1.3 kg/h (2.9 lb/h)	64.1 %