

Sureweld10P PLUS



Sureweld 10P Plus is a modified version of the standard 10P electrode and can be differentiated by its gray coating. It has also been developed for the pipe welding industry but has a more consistent burn-off and a more forgiving arc burn. This provides a better bead profile and sidewall fusion with lower spatter. Sureweld 10P Plus will maintain the proper keyhole in an open root and will produce X-ray quality joints in the flat, horizontal, overhead, vertical-up, and vertical-down procedures. Sureweld 10P Plus 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
Approvals	CWB CSA W48
Industry	Civil Construction Industrial and General Fabrication Pipeline

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Coating Type	High cellulose

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	503 MPa (72.9 ksi)	599 MPa (86.9 ksi)	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-29 °C (-20 °F)	45 J (33 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.15	0.60	0.20	0.01	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 %