

PHYSICAL PROPERTIES OF E60 & E70 SERIES ELECTRODES

TYPICAL VALUES				
AWS ASTM ELECTRODE	TENSILE STRENGTH	YIELD STRENGTH	ELONGATION	RED. IN AREA MIN. %
E6010	62,000–70,000	52,000–58,000	22 to 28%	35
E6011	62,000–73,000	52,000–61,000		
E6012	68,000–78,000	55,000–65,000	17 to 22%	25

MINIMUM VALUES			
AWS ASTM ELECTRODE	TENSILE STRENGTH	YIELD STRENGTH	ELONGATION
E7010	70,000	57,000	22
E7011	70,000	57,000	22
E7015	70,000	57,000	22
E7016	70,000	57,000	22
E7020	70,000	52,000	25

WELDING AND BRAZING TEMPERATURES	
Carbon Steel Welding	2700–2790°F
Stainless Steel Welding	2490–2730°F
Cast Iron Welding	1920–2500°F
Copper Welding and Brazing	1980°F
Brazing Copper-Silicon with Phosphor-Bronze	1850–1900°F
Brazing Naval Bronze with Manganese Bronze	1600–1700°F
Silver Solder	1175–1600°F
Low Temperature Brazing	1175–1530°F
Soft Solder	200–730°F
Wrought Iron	2700–2750°F