

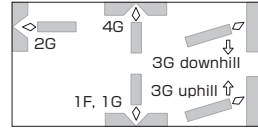
## Stick electrode

- Features:**
- Suitable for butt welding of pipes
  - Excellent usability in vertical downward welding

**Classification:** AWS A5.1 E6010

**Identification color:** 1st Yellowish green, 2nd -  
**Polarity:** DCEP

### Welding Positions:



### Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.4	300	2	20	13	300W, 100H, 330L
3.2	350	5	20	27	175W, 115H, 380L
4.0	350	5	20	40	175W, 115H, 380L
4.8	350	5	20	58	175W, 115H, 380L

### Composition (all-weld metal mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.12	0.20
<b>Si</b>	0.15	1.00
<b>Mn</b>	0.51	1.20
<b>P</b>	0.009	0.035
<b>S</b>	0.008	0.035
<b>Ni</b>	0.02	0.30
<b>Cr</b>	0.02	0.20
<b>Mo</b>	<0.01	0.30
<b>V</b>	<0.01	0.08

Note: <sup>a</sup> Single values are maximum.

### Welding parameters (A)

φ mm	1F, 1G, 2G, 3G uphill, 3G downhill, 4G
2.4	40~75
3.2	70~130
4.0	90~180
4.8	140~225

### All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	430	331min.
<b>TS (MPa)</b>	510	414min.
<b>EI on 4d (%)</b>	27	22min.
<b>IV -29°C (J)</b>	63	27min.