

6010

CATEGORY SMAW Stick Electrodes

TYPE Cellulosic electrode for SMAW vertical down welding

APPLICATIONS Pipeline root welding, shipbuilding and repair, sheet piling

PROPERTIES 6010 is a cellulose coated all positional pipe welding electrode designed especially for vertical down root pass welding on D.C. negative polarity and for subsequent passes on D.C. positive polarity. Apart from its excellent welding and gap bridging characteristics 6010 offers a weld deposit with outstanding impact strength values and thus offers the benefit of more safety in field welding of pipelines.

CLASSIFICATION

AWS	A 5.1: E 6010
EN ISO	2560-A: E 38 3 C 11
DIN	8575: E 43 54 C4

SUITABLE FOR St:37.2, 44.2, 37.3, 52.3, St 37.0, 52.0, 37.4, 52.4, 35.8, 45.8 H1, H11, StE 210.7, 360.7 X42, X60, A-D

WELDING POSITIONS:



WELD DEPOSIT WEIGHT %

C	Mn	Si	Cr	Ni	Mo
0.12	0.6	0.2	-	-	-

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-30°C	-60°C	
AW	>380	470-540	>22		>47		

AW: as welded

PARAMÈTRES DE SOUDAGE / EMBALLAGE

D (mm)	Welding Parameters		Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	350	50-90			
3.2	350	80-130			
4.0	350	120-180			
5.0	350	160-210			

REDRYING TEMPERATURE not to be done