



PIPE MAGIC 6010

Cellulosic Electrodes

Classification

AWS A5.1: E 6010 - EN ISO 2560-A: E 38 3 C 21

EN 499 : E 38 3 C 21

Features

- High Cellulosic coated, Radiographic quality weld
- Excellent all position electrode.
- Best suitable for pipes and pipelines welding.
- Excellent mechanical properties in class.
- Deep penetration and fast freezing

Applications

- Cellulosic coated deep penetration electrode for welding of pipes and pipelines in all positions using conventional and stove pipe techniques. It is characterized by a deeply penetrating, forceful and spray type arc. Excellent arc striking and re-striking. It is suitable for welding root passes, fill and cover passes.
- Manufacturing - Architectural and Structural Metals, Mining, Agricultural, Motor Vehicles, Aerospace, Shipbuilding
- Construction - Residential, Commercial, Bridges, Dams, Utilities
- Or any other industry where welders may work

Usage Instructions

- Step 1: Prepare the metal to be welded. Attach clamps to hold your metal pieces together, if needed and attach ground clamp to the larger piece of stock that is being welded. Turn on your welding machine and select the correct amperage range for the work you are attempting.
- Step 2: Insert or clamp electrode to electrode holder. Hold the electrode holder in your dominant hand by the insulated handle, with the rod in a position so that striking the tip of it against the plate you are welding will be as natural a movement as possible.
- Step 3: Select the point where you wish to begin your weld. Strike the electrode against the surface of the metal, pulling it back slightly when you see an electric arc occur. Travel across the path of your weld with the electrode keeping a consistent arc, moving at a consistent speed, and in line with the path you want to weld. Keep the arc established as you move along the weld you are making and move the electrode in a sweeping motion to create a wider bead.

Technical Specifications

Base materials: L210 - L360, X42 - X52, API Grades A25 A & B

Typical weld metal	C	Si	Mn
Chemical Composition (%)	0.15	0.20	0.60

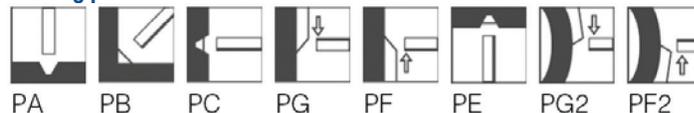
All weld metal mechanical properties (typical)

Heat Treatment	Tensile Strength R_m (N/mm ²)	Yield Strength R_m (N/mm ²)	Elongation A ₅ %	Impact Energy ISOV(J) -30°C
As welded	470	400	30	50

Storage: Keep dry and avoid condensation

Welding recommendations: = +

Welding positions:



Current conditions:

Diameter (mm)	Length (mm)	Current (A)
2.40 /2.50	350	40-70
3.15 /3.20	350	70-100
4.00	350	100-140
4.80	350	130-170