

# 6010 PRODUCT DATA SHEET

## CELLULOSIC ELECTRODE

- High Cellulose 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

Classification      AWS A5.1 : E6010      EN 499: E 38 3 C 21      DIN EN ISO 2560-A: E 38 3 C 21

### Description and 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.

### Base materials

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

### Typical Weld Metal Chemical Composition(%)

| C    | Si   | Mn   |
|------|------|------|
| 0.15 | 0.20 | 0.60 |

### All weld metal Mechanical Properties (Typical)

| Heat Treatment | Tensile Strength<br>$R_m(N/mm^2)$ | Yield Strength<br>$R_p(N/mm^2)$ | Elongation<br>$A_5(\%)$ | Charpy Impact Value<br>ISO-V (J)-30°C |
|----------------|-----------------------------------|---------------------------------|-------------------------|---------------------------------------|
| As Welded      | 470                               | 400                             | 30                      | 50                                    |

### Amperes (A)

| 2.40/2.50mm | 3.15/3.20mm | 4.00mm  | 4.80mm  |
|-------------|-------------|---------|---------|
| 40-70       | 70-100      | 100-140 | 130-170 |

### Welding Instruction

Keep drying and avoid condensation. Re-drying not generally required. If necessary re-dry at 70°C for 30 minutes one time only.

### Welding Positions

