PIPEWELD 6010 PLUS



Cellulosic-coated electrode designed for welding of pipes and pipelines in all positions using conventional and stovepipe techniques. Deep penetration in all positons especially vertical down. Suitable for welding pipe steels API 5L up to X56, root pass up to X80. Even though DC+ is advised and easier to control, DC- can be used for root run.

Specifications	
Classifications	SFA/AWS A5.1 : E6010 EN ISO 2560-A : E 38 2 C 21
Approvals	FBTS : E 6010

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+(-)
Alloy Type	Carbon Manganese
Coating Type	Cellulosic covering

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	480 MPa (70 ksi)	590 MPa (86 ksi)	22 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	-20 °C (-4 °F)	50 J (37 ft-lb)
As Welded	-30 °C (-22 °F)	40 J (30 ft-lb)

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
0.11	0.44	0.13

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.5 x 350 mm (0.098 x 13.8 in.)	60-80 A	34 V	79 %	54 sec	0.7 kg/h (1.5 lbs/h)
3.2 x 350 mm (1/8 x 13.8 in.)	75-130 A	25 V	69 %	57 sec	1.0 kg/h (2.2 lbs/h)
4.0 x 350 mm (5/32 x 13.8 in.)	100-190 A	30 V	63 %	58 sec	1.2 kg/h (2.6 lbs/h)
5.0 x 350 mm (0.197 x 13.8 in.)	160-240 A	28 V	71 %	65 sec	1.9 kg/h (4.2 lbs/h)