

# Pipeweld 6010 Plus



Cellulosic-coated electrode designed for welding of pipes and pipelines in all positions using conventional and stovepipe techniques. API 5L up to X56, root pass up to X80.

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

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

<b>Welding Current</b>	DC+(-)
<b>Alloy Type</b>	Carbon Manganese
<b>Coating Type</b>	Cellulosic covering

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	480 MPa (70 ksi)	590 MPa (86 ksi)	22 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS</b>		
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	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Condition
2.5 x 350.0 mm (0.098 x 13,8 in.)	60-80 A	34 V	100	54 sec	79 %	0.7 kg/h (1,5 lb/h)
3.2 x 350.0 mm (1/8 x 13,8 in.)	75-130 A	25 V	67	57 sec	69 %	1.0 kg/h (2,2 lb/h)
4.0 x 350.0 mm (5/32 x 13,8 in.)	100-190 A	30 V	50	58 sec	63 %	1.2 kg/h (2,6 lb/h)
5.0 x 350.0 mm (0.197 x 13,8 in.)	160-240 A	28 V	29	65 sec	71 %	1.9 kg/h (4,2 lb/h)