

## 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 positions 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.

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

<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	-30 °C ( -22 °F )	40 J ( 30 ft-lb )
As Welded	-20 °C ( -4 °F )	50 J ( 37 ft-lb )

### Typical Weld Metal Analysis %

C	Mn	Si
0.11	0.44	0.13

### Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Number of electrodes/kg weld metal	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 350.0 mm ( 0.098 x 13.8 in. )	60-80 A	34 V	79 %	100	54 sec	0.7 kg/h ( 1.5 lbs/h )
3.2 x 350.0 mm ( 1/8 x 13.8 in. )	75-130 A	25 V	69 %	67	57 sec	1.0 kg/h ( 2.2 lbs/h )
4.0 x 350.0 mm ( 5/32 x 13.8 in. )	100-190 A	30 V	63 %	50	58 sec	1.2 kg/h ( 2.6 lbs/h )
5.0 x 350.0 mm ( 0.197 x 13.8 in. )	160-240 A	28 V	71 %	29	65 sec	1.9 kg/h ( 4.2 lbs/h )