

ES 6010

Type Cellulosic

SMAW

E6010

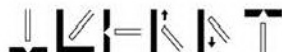
ESWECO
The Art of Welding

Description

Cellulosic-coated electrode designed for the welding of pipes and pipelines in all positions, using conventional and stovepipe techniques with AC or DC.

Current

AC, DC+



Classifications

SFA/AWS A5.1	E6010
EN 499	E 38 2 C 21

Typical all weld metal composition, %

C	Si	Mn
0.08	0.05	0.4

Typical mech. Properties all weld metal

Yield stress, MPa	410
Tensile strength, MPa	495
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
-20	60
-29	40

Approvals

ABS	Grade 3
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Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	50-70	31
3.2	350	65-120	29
4.0	350	90-180	28
5.0	350	150-240	29