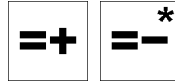


**Coating type:**

Cellulose

**Arc voltage:** 70V

**Current:**



\* Root pass!

**Tip colour:**

**Welding positions:**



**Printing:**

E 6010 / Pipeweld 6010

Pipeweld 6010 is our cellulose coated electrode recommended for all welding positions, particularly in vertical down and overhead position. The electrode is characterised by a deeply penetrating, forceful, spray type arc and readily removable slag. The majority of applications are in joining carbon steel, but performance on galvanised and some low-alloy steels is proven to be excellent. Typical applications include shipbuilding, general constructions, bridges, storage tanks, piping and pressure vessel fittings.

**Base materials to be welded:**

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355J2G3, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel P275N-P355NL2, S275N-S420N, StE285-EStE355, StE285TM-EStE355TM
- Pipe steel P235T1-P355N, L210-L415MB, St37.0-St52.4, St45.8, X42-X60, StE210.7-StE360.7TM
- Cast steel GP240R, GS45

**Applications:**

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance
- Oil & Gas Industry

**Equivalent product in alternative welding process:**

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	K 60	Hilcord 52	-	H100 / HW430	-

**Chemical composition, wt.% weld metal – typical:**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,14	0,55	0,18	≤ 0,030	≤ 0,030							

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 420	≥ 510	≥ 22	-20°C ≥ 70

**Packaging and welding data:**

Dia. Mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	350	17,7	50-80
3,2	350	25,5	80-130