

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.

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
As Welded	480 MPa (69.6 ksi)	590 MPa (85.6 ksi)	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-20 °C (-4 °F)	50 J (36.9 ft-lb)
As Welded	-30 °C (-22 °F)	40 J (29.5 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si
0.11	0.44	0.13

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm (3/32 x 14 in.)	60-80 A	34 V	0.79	100	54 sec	0.7 kg/h (1.54 lb/h)
3.2 x 350 mm (1/8 x 14 in.)	75-130 A	25 V	0.69	67	57 sec	1.0 kg/h (2.20 lb/h)
4.0 x 350 mm (5/32 x 14 in.)	100-190 A	30 V	0.63	50	58 sec	1.2 kg/h (2.64 lb/h)
5.0 x 350 mm (3/16 x 14 in.)	160-240 A	28 V	0.71	29	65 sec	1.9 kg/h (4.19 lb/h)