

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.

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
AWS			
As Welded	480 MPa (70 ksi)	590 MPa (86 ksi)	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
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 %	Deposition Rate @ 90% I max
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)