

Pipeweld 6010 Plus SMAW

Type Cellulosic

E 38 2 C 21

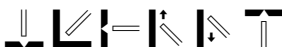
Description

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

Recovery

Welding current

AC, DC+



Classifications

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

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 | 3 |
| LR | 3 |

Welding parameters

| Diameter, mm | Length, mm | Welding current, A | Arc voltage, V | N. Kg weld metal/kg electrodes | B. No. of electrodes/kg weld metal | H. Kg weld metal/hour arc time | T. Burn-off time, s/ electrode |
|--------------|------------|--------------------|----------------|-----------------------------------|---------------------------------------|-----------------------------------|-----------------------------------|
| 2.5 | 350 | 50-70 | 31.5 | 0.69 | 91 | 0.71 | 55 |
| 3.2 | 350 | 65-120 | 29 | 0.71 | 54 | 0.9 | 76 |
| 4.0 | 350 | 90-180 | 28 | 0.72 | 36 | 1.3 | 78 |
| 5.0 | 350 | 150-240 | 29 | 0.71 | 23 | 1.58 | 98 |