

## ESAB PIPEWELD 6010R

PIPEWELD 6010R is a high cellulose coated electrode for welding of in-plant piping. The electrode is designed to provide deep and complete penetration. The weld bead obtained is smooth with a thin, fast freezing and easily removable slag giving radiographic quality weld metal.

### Specifications

<b>Classifications</b>	SFA/AWS A5.1 : E6010 IS 814 : EC4410X
<b>Approvals</b>	PDIL : E6010

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	C-Mn
<b>Coating Type</b>	Cellulosic

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	440 MPa	520 MPa	26 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As Welded	-30 °C	60 J

### Typical Weld Metal Analysis %

C	Mn	Si
0.10	0.65	0.35

### Deposition Data

Diameter	Current
2.5 x 350.0 mm	50-80 A
3.15 x 350.0 mm	80-120 A
4.0 x 350.0 mm	100-150 A