

# ESAB PIPEWELD 6010R



ESAB PIPEWELD 6010R is a high cellulose coated electrode for welding of pipes. 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.

<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

Current Range	
Diameter	Current
2.5 x 350 mm	50-80 A
3.15 x 350 mm	80-120 A
4.0 x 350 mm	100-150 A