

S-6010.D

Type : Cellulosic



Conformances

AWS A5.1/ ASME SFA5.1 E6010
 JIS Z3211 E4310
 EN ISO 2560-A-E38 0 C 2 1
 KR 2
 ABS 2, AWS A5.1 E6010
 LR 2
 BV 2
 DNV-GL 2
 NK KMW2
 TÜV EN ISO 2560-A-E 38 0 C 2 1
 DB EN ISO 2560-A-E 38 0 C 2 1
 CWB CSA W48 E4310
 CE

Applications

- Pipe line
- General fabrication

Features

- Standard in the pipe welding industry
- Deep penetration
- High ductility (root pass)

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.10	0.17	0.42	0.015	0.017

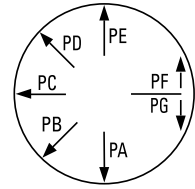
Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
447 (64,900)	517 (75,000)	32.3	-30 (-22)	62 (46)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	50~75	75~125	90~165	140~220
V-up, OH	50~75	75~125	90~165	140~220

Welding Position



Current

DC +

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX