



CEWELD E 6010

TYPE	Cellulosic electrode for SMAW vertical down welding. (Typ 38 3 , 6010)							
APPLICATIONS	CEWELD® E 6010 was developed for down seam welding of the root, hot pass and the filler and cover layers in pipeline construction. As well as shipbuilding and repair, sheet piling							
PROPERTIES	CEWELD® E 6010 is a cellulose coated all positional pipe welding electrode designed especially for vertical down root pass welding on DC- and for subsequent passes on DC+. Apart from its excellent welding and gap bridging characteristics CEWELD® E 6010 offers a weld deposit with outstanding impact strength values and thus offers the benefit of more safety in field welding of pipelines.							
CLASSIFICATION	AWS	A 5.1: E 6010						
	EN ISO	2560-A: E 38 3 C 21						
	F-nr	3						
	FM	1						
SUITABLE FOR	Rp< 380 MPa (52 ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 380MPa) 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, A, B, D, E, A 32-E 36 ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52 (~X60-X80)							
APPROVALS	CE							
WELDING POSITIONS								
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S			
	0.12	0.2	0.6	0.02	0.02			
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness
	As Welded	410	510	26	RT	0°C	-30°C	HRc
					90	75	60	
REDRYING	Not required							
GAS ACC. EN ISO 14175								