

SC 6010

Mild steel electrode

Classification

AWS A5.1: E 6010

EN ISO 2560-A: E 38 3 C 21

EN 499 : E 38 3 C 21

Description and applications

Cellulosic coated deep penetration electrode for welding of pipes and pipelines in all positions using conventional and stove pipe techniques. It is characterized by a deeply penetrating, forceful and spray type arc. Excellent arc striking and re-striking. It is suitable for welding root passes, fill and cover passes.

- Excellent all position electrode.
- Best suitable for pipes and pipelines welding.
- Excellent mechanical properties in class.

Base materials

L210 - L360, X42 - X52, API Grades A25 A & B.

All weld metal mechanical properties (typical)

Heat Treatment	Tensile strength Rm (N/mm ²)	Yield strength Rm (N/mm ²)	Elongation A5 (%)	Impact energy ISO- V (J) RT -30°C
As welded	470	400	30	47

Typical weld metal chemical composition (%)

C	Si	Mn
0.10	0.20	0.60

Storage and redrying

Keep dry and avoid condensation. Re-drying not generally required. If necessary : 70°C for 30 minutes one time only.

Current conditions

Diameter (mm)	Length (mm)	Current (A)
2.40 /2.50	350	40-70
3.15 /3.20	350	70-100
4.00	350	100-140
4.80	350	130-170

Welding recommendations



Welding positions

