

# Pipe Welding Electrodes

## PIPEWELD 6010R

Cellulose coated electrode for SMAW of pipes

Classification AWS A5.1: E6010  
IS 814: EC4410 X

### DESCRIPTION

PIPEWELD 6010R is 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, easily removable slag, giving radiographic quality weld metal.

**APPROVALS:** NPC, PDIL & TOYO

**WELDING CURRENT:** DC+

### TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.10	YS (N/mm <sup>2</sup> )	440
Si	0.35	UTS (N/mm <sup>2</sup> )	520
Mn	0.65	Elongation (%)	26
		Impact (CVN) @ -30°C (Joules)	60

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	50-80	200	800
3.15	350	90-130	130	520
4.00	350	110-160	80	320

**PACKING:** Electrodes are packed in cartons and four of these cartons are shrink wrapped in a cardboard box. Also available in 10 kg hermetically sealed tins.