

Pipearc 6010P



- User Friendly Pipe Welding Electrode
- Lower Spatter Levels and Easy Slag Removal
- Excellent Reverse Bead Formation on Butts
- Versatile “Out-of-Position” Capabilities
- Batch Numbered for On-the-Job Traceability
- Used to weld out (root, fill and cap) steel pipes such as API 5L, 5LX grades X42 to X52
- Welding of “V” butt (groove weld) joints in higher strength steels, including 5LX grades X60, X65 and X70. Recommended for root pass welding only.

Classifications:

AS/NZS 4855: (new)	B E4310 A
AS/NZS 1553.1: (old)	E4110-2
AWS/ASME-SFA A5.1:	E6010

Typical All Weld Metal Mechanical Properties:

Yield Stress	400 MPa
Tensile Strength	510 MPa
Elongation	30%
CVN Impact Values	65J av @ -20°C 40J av @ -30°C

Typical All Weld Metal Analysis:

C: 0.11% Mn: 0.46% Si: 0.15%
S: 0.011% P: 0.012%

Approvals:

Lloyds Register of Shipping	Grade 3
American Bureau of Shipping	Grade 3
Det Norske Veritas	Grade 3

The results quoted in this data sheet are obtained from the listed Shipping Societies (ABS, DNV, LRS) Conformance Tests and Procedures. Actual weld metal mechanical properties achieved with PipeArc 6010P are influenced by many factors including, base metal analysis, welding parameters / heat input used, number of weld passes and run placement etc. On the job mechanical tests may produce different results. Please consult your CIGWELD Area Manager or Customer Service for welding procedure recommendations.

Packaging and Operating Data:

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	66	45 – 85	5kg	15kg – 3 x 5kg	615602
3.2	350	39	90 – 135	5kg	15kg – 3 x 5kg	615603
4.0	350	25	135 – 180	5kg	15kg – 3 x 5kg	615604

DC+ (Direct Current Electrode Positive) polarity