



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
				RT	0°C	-30°C	
As Welded	410	510	26	90	75	60	HRc

REDRYING Not required

GAS ACC. EN ISO 14175