



# 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 <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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**