

ESC 6010



GENERAL PURPOSE CELLULOSIC ELECTRODE – AW A5.28/ASME SFA- AWS/ASME SFA - 5.1 E6010

Characteristics

Medium coated, cellulosic electrode, especially designed for welding of pipes and plates in all positions at low welding currents. Due to its high penetration, particularly suitable for root pass and fill passes in vertical down direction. Used in pipe-line construction, shipbuilding, storage vessels and assembly works. DCEN (-) is ideal in root passes and DCEP (+) is recommended for fill and cap passes in vertical down position.

Base Material



Typical applications

Pipe line construction



Typical Analysis in %

	%C	%Mn	%Si	%S	%P
Typical Chemical Analysis	0.10	0.50	0.20		
	%Cr	%Ni	%Mo	%Cu	%Ti

Mechanical Properties as required per AWS A5.28 ER100S-1

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation A5 %	Impact Energy J
Typical Results (all weld metal)				
As Welded	470 mpa	530 mpa	25	-30C 40 J -20C 60 J

Ordering Information

Article Number	Product	Dimension	Packaging
1141010M46	ESC 60 (E6010)	2.5x350mm(3/32X14")	8 KG (17.6 lb) HSC
1141016M46	ESC 60 (E6010)	3.25X350mm(1/8X14")	8 KG (17.6 lb) HSC
1141020M46	ESC 60 (E6010)	4.0X350mm(5/32X14")	8 KG (17.6 lb) HSC
1141028M46	ESC 60 (E6010)	5.0X350mm(3/16X14")	8 KG (17.6 lb) HSC

