

CLASSIFICATIONS

EN ISO 2560-A : E 38 3 C 21

AWS A5.1 : E 6010

DESCRIPTION

- Suitability for use in welding large-diameter pipelines for crude oil, natural gas, and water as well as in root-pass welding or surfacing of ships, tanks, boilers, and steel constructions
- Usability in sour gas - involving applications (acc. HIC Test NACE TM-0284)
- Deep penetration obtained in welding at all positions
- Most suitability for welding at vertical down position

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.12 | Si: 0.2 | Mn: 0.6

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-30°C)	Elongation (L _o =5d _o) (%)
min. 380	470-540	min. 47 J	min. 22

BASE MATERIALS

- S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P235T1-P355T1, P235T2-P355T2, L210-L360NB, L290MB-L360MB, S235JR51-S235J2S2, P235G1TH, P255G1TH, X42-X56, for root pass X60-X80.

WELDING POSITIONS



CURRENT CONDITION

D.C.(+) / D.C. (-) for root pass

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
2010800086	2.50 x 350	3/32 x 14"	40 - 80	1670
2010800087	3.20 x 350	1/8 x 14"	65 - 125	2720
2010800088	4.00 x 350	5/32 x 14"	90 - 175	4110
2010800089	5.00 x 350	3/16 x 14"	140-220	6210