

CLASSIFICATIONS

EN ISO 2560-A : E 42 3 C 21

AWS A5.5 : E 7010-P1

DESCRIPTION

- Suitability for use in welding large-diameter high-strength steel pipelines and especially use in hot, filler and cap passes.
- Deep penetration, especially (obtained) at vertical-down position.
- For root-pass welding, Weld-inn electrode WI 6010

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.15 | Si: 0.2 | Mn: 1.0

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-30°C)	Elongation (L ₀ =5d ₀) (%)
min. 420	500 - 640	min. 47 J	min. 22

BASE MATERIALS

- S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P355T2, L210-L415NB, L290MB-L415MB, S235JR51-S235J4S, P235G1TH, P255G1TH, X42-X60

WELDING POSITIONS



CURRENT CONDITION

D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
2010800094	2.50 x 350	3/32 x 14"	40 - 80	1700
2010800095	3.20 x 350	1/8 x 14"	65 - 125	2735
2010800096	4.00 x 350	5/32 x 14"	90 - 175	3990
2010800097	5.00 x 350	3/16 x 14"	140 - 220	6135