

CLASSIFICATIONS

EN ISO 2560-A : E Z 46 3 Mo C 21

AWS A5.5 : E 8010 - G

DESCRIPTION

- Suitability for use in all-positions of welding high-strength low alloyed steel pipelines joining
- Suitability for use in welding all positions, particularly vertical down position
- Usability in sour gas - involving applications (acc. HIC Test NACE TM-0284)
- For root-pass welding, Weld-inn electrode WI 6010

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.14 | Si: 0.2 | Mn: 0.9 | Ni: 0.2 | Mo: 0.15

MECHANICAL PROPERTIES

Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-30°C)	Elongation (Lo=5d ₀) (%)
min. 460	550 - 650	min. 47 J	min. 20

BASE MATERIALS

- L290NB-L415NB, L290MB-L415MB, -L485MB, S235JRS1-S235J4S, X42-X70

WELDING POSITIONS



CURRENT CONDITION

D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
2010800098	2.50 x 350	3/32 x 14"	40 - 80	1635
2010800099	3.20 x 350	1/8 x 14"	65 - 125	2640
2010800100	4.00 x 350	5/32 x 14"	90 - 175	4000
2010800101	5.00 x 350	3/16 x 14"	140 - 220	6340