

SME 6010

Stick Electrodes (SMAW)

Mild Steel

Classifications:

AWS A/SFA 5.1 : E 6010

EN ISO 2560-A : E 38 3 C 21

Identification : Brand Printed

Characteristics:

1. All Position operating characteristics.
2. High cellulose coated.
3. Ideal for root pass and capping runs.
4. Exhibits deep penetration and fast freezing.
5. Radiographic quality weld.



Applications:

1. Pipelines subject to dynamic loading and mechanical restraint.
2. Suitable for sour gas pipes.
3. Suitable for steel grades ASTM A106 Gr. A/B, API 5L X 42 and for root pass of X56.

Weld Metal Chemistry (wt%):

	C	Mn	Si	S	P
Typical	0.15	0.5	0.4	0.01	0.01
Specification	0.10-0.20	0.40-0.70	0.20-0.50	0.015 max	0.02 max

Mechanical Properties of All Weld Metals:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C -30°C	
Typical	As Welded	525	410	26	78	52
Specification		490 - 580	390 - 465	24 - 30	70-90	48-70

Packing Details:

Size (Ø / Length) mm	2.5 x 350	3.2 x 350	4.0 x 350	5.0 x 350
Current (amps)	50 - 90	80 - 140	100 - 160	140 - 200