




# CEWELD E 6010

TYPE	Cellulosic electrode for SMAW vertical down welding. (Typ 38 3 , 6010)						
APPLICATIONS	CEWELD E 6010 was developed for down seam welding of the root, hot pass and the filler and cover layers in pipeline construction. As well as shipbuilding and repair, sheet piling						
PROPERTIES	CEWELD E 6010 is a cellulose coated all positional pipe welding electrode designed especially for vertical down root pass welding on DC- and for subsequent passes on DC+. Apart from its excellent welding and gap bridging characteristics CEWELD E 6010 offers a weld deposit with outstanding impact strength values and thus offers the benefit of more safety in field welding of pipelines.						
CLASSIFICATION	AWS	A 5.1: E 6010					
	EN ISO	2560-A: E 38 3 C 21					
	F-nr	3					
	FM	1					
SUITABLE FOR	<b>Re ≤ 360 MPa ISO 15608: 1.1, 1.2</b> S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P355T2, P235G1TH, P255G1TH L210NB-L385NB, L290MB-L385MB, Root L555NB, L555MB API Spec. 5 L: A, B, X42, X46, X52, X56, Root X60 - X80						
APPROVALS	CE						
WELDING POSITIONS							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si		Mn		P	S
	0.12	0.2		0.6		0.02	0.02
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	RT	Impact Energy (J) ISO-V	
	As Welded /	410	510	26	90	0°C	-30°C
						75	60
REDRYING TEMPERATURE	Not required						
GAS ACCORDING EN 14175							