

Classifications

EN ISO 2560-A:2006	: E 38 0 C 22	KS D 7004	: E4311
EN ISO 2560-B:2006	: E 43 10 A	JIS Z 3211	: E4310
AWS A5.1-04	: E6010		

Description

- Covering is high cellulose type for welding of pipe, shipbuildings, tanks or galvanized surfaces and steel casting repairs.
- Good penetration combined with freedom from lack of fusion makes this electrode an excellent choice for pipe welding.
- Gives high ductility root weld and easy slag removal.
- Redry the electrode at 70~80°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.11	0.36	0.63	0.015	0.013	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
AWS A5.1	min. 330	min. 430	min. 22	≥ 27		
EN ISO 2560-A	min. 380	470~600	min. 20	≥ 47		
Example	420	500	29	60	40	AW

* AW : As-Welded

Sizes available and recommended currents (DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	350	350
Amp. (A)	F V · OH	50~80 40~70	70~110 60~100	110~150 90~130	160~200 140~170

Approvals

ABS	BV	GL	LR	NK
3,E6010	3	3	3m	KMW3

* Others : JIS, CE