



Product Data Sheet

Cellulosic Electrode

SUPER OPTIMAL 6010

- ★ High Cellulose coated, Radiographic quality weld
- ★ Excellent all position electrode.
- ★ Best suitable for pipes and pipelines welding.
- ★ Excellent mechanical properties in class.
- ★ Deep penetration and fast freezing

Classification

AWS A5.1: E 6010
EN 499 : E 38 3 C 21

DIN EN ISO 2560-A: E 38 3 C 21

Description and applications

Cellulosic coated deep penetration electrode for welding of pipes and pipelines in all positions using conventional and stove pipe techniques. It is characterized by a deeply penetrating, forceful and spray type arc. Excellent arc striking and re-striking. It is suitable for welding root passes, fill and cover passes.

Base materials

L210 - L360, X42 - X52, API Grades A25 A & B.

Typical weld Metal Chemical Composition (%)

C	Si	Mn
0.15	0.20	0.60

All weld metal Mechanical Properties (Typical)

Heat Treatment	Yield Strength R_p (N/mm ²)	Tensile Strength R_m (N/mm ²)	Elongation A_5 (%)	Charpy Impact value (ISO-V(J)-30°C)
As welded	400	470	30	50

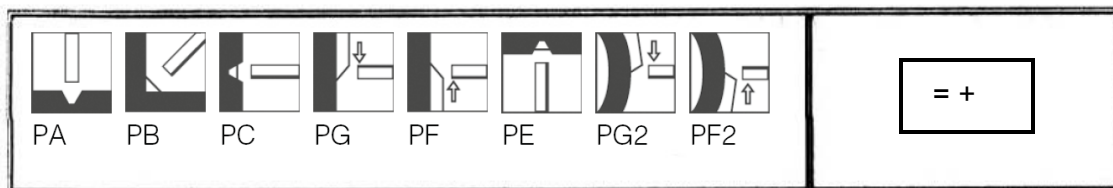
Amperes (A)

2.40/2.50mm	3.15/3.20mm	4.00mm	4.80mm
40-70	70-100	100-140	130-170

Welding instruction

Keep drying and avoid condensation. Re-drying not generally required If necessary redry at 70° for 30 minutes one time only.

Welding positions:



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