

International standards	EN 499	E42 2 C 25
	AWS A 5.1	E6010

Approvals ---

Typical applications and characteristics Cellulose coated electrode for joining and repairing pipelines, especially in vertical down position. CARBO 6010 is particularly suitable for welding root layers.

Excellent weldability also on soiled surfaces containing impurities from corrosion, paint residues, priming coats, etc.

High efficiency as compared to vertical up welding.

Operating temperature From -20° C up to +450° C

Base materials API 5 LX, X42 – X60, L240NB – L415NB, L290MB – L415MB u. ä.

Mechanical properties of all-weld metal	Tensile strength R_m N/mm²	Yield strength R_{eL} N/mm²	Elongation A_5 %	Impact strength ISO – V J - 20°C
(typical values)	570	> 420	> 22	> 47

Weld metal analysis (typical, wt. %)	C	Si	Mn
	0,15	0,2	0,6

Current = + for root pass welding -

Welding positions PA, PB, PC, PG, PE, PF, PG

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 350	40 – 80	275	825	14,5	4,0	12,0
3,2 x 350	60 – 110	175	525	28,0	4,9	14,7
4,0 x 350	90 – 140	125	375	41,6	5,2	15,6