

# Pipeliner® 6P+

## CLASSIFICATION

AWS A5.1	E6010	A-Nr	1
ISO 2560-A	E 42 3 C 2 5	F-Nr	3
		9606 FM	1

## GENERAL DESCRIPTION

All-position cellulosic pipe electrode designed for all position pipe welding, including vertical down root pass welding  
 Designed for root pass welding of pipe up to and including X80, fill and cap pass welding up to and including X60  
 Light slag with little slag interference for easy arc control  
 Easy slag release and smooth bead appearance  
 Deep penetration with maximum dilution  
 X-ray quality welds, even out of position

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PG/3Gd



PE/4G



PH/5Gu



PJ/5Gd

## CURRENT TYPE

DC +/-

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.11	0.55	0.18	0.009	0.009

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J) -29°C/-30°C
Required: AWS A5.1 ISO 2560-A	min. 331	min. 430	min. 22	min. 27
Typical values	450	500-640 570	27	min. 47 70

## PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.4	3.2	4.0
	Length (mm)	300	350	350
Metal can	Net weight/unit (kg)	13.62	13.62	13.62

Identification Imprint: 6010

Tip Color: none

Pipeliner® 6P+ rev. C-EN25-05/1/19

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## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
<b>Pipe material</b>	
API 5LX	X42, X46, X52, X56, X60
EN 10208-2	L290 up to L415

## CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type
2.4x300	50-85	DC+/-
3.2x350	75-135	DC+/-
4.0x350	100-175	DC+/-

\*Stub end 35mm

## WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions	
	PH/5Gup	PJ/5Gdown
3.2	90A	110A
4.0	130A	150A

## REMARKS / APPLICATION ADVICE

Preheating pipe material L415 (X56-X60) required (acc. EN 1011-2).

Pipeclamps to be removed after finishing root pass, start welding hot pass (within 5 min) after root pass

Use electrodes directly from Metal cans