

# Lincoln® 6010

## TOP FEATURES

- Used for root and hot passes as well as filling and capping up to X52 Grades
- Also used for root passes on higher-strength pipe steels, up to X80
- Excellent weldability in all positions
- Q2 lot Controlled Chemistry and Mechanical Properties

## TYPICAL APPLICATIONS

- Cross country and in-plant pipe welding
- Root pass on up to X80 grade pipe
- Hot, fill and cap pass on up to X60 grade pipe

## CLASSIFICATION

AWS A5.1	E 6010
EN ISO 2560-A	E 38 3 C 21

## CURRENT TYPE

DC+/DC-

## WELDING POSITIONS

All positions

## APPROVALS

ABS, LR, DNV, TÜV

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

C	Mn	Si
0.1	0.6	0.2

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -30°C
Typical values	AW	≥380	470-560	≥24	≥47

AW = As welded

## OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	40-80
3.2 x 350	60-110
4.0 x 350	90-140

## AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CAN	555	9.0	627257
3.2 x 350	CAN	355	9.5	627258
4.0 x 350	CAN	237	9.5	627259