

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
- When root pass welding, negative polarity is recommended
- Excellent weldability in all positions

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/GL	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

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2,5x350	40-80
3,2x350	60-110
4,0x350	90-140
5,0x350	110-170

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Pieces / unit	Weight (kg)	Item number
2.5x350	CAN	555	9.0	627257
3.2x350	CAN	355	9.5	627258
4.0x350	CAN	237	9.5	627259
5.0x350	CAN	158	9.5	627260

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.