Lincoln® 6010

TOP FEATURES

- Cellulosic coated MMA electrode for root and hot passes as well as filling and capping up to X60 Grade pipe
- Also for root passes on higher-strength pipe steels, up to X80 grade pipe
- Excellent weldability in all positions
- Designed for both DC+ and DC- current
- 3.1 tested batches to provide actual weld composition and mechanical properties

TYPICAL APPLICATIONS

- Pipeline

CLASSIFICATION

AWS A5.1	E 6010
EN ISO 2560-A	E 38 3 C 2 1

CURRENT TYPE

DC-; DC+

WELDING POSITIONS

All positions

APPROVALS

ABS, 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 (%) 4d	Elongation (%) 5d	Impact ISO-V (J) +20°C	Impact ISO-V (J) -30°C
AWS A5.1	AW	≥330	≥430	≥22	-	-	≥27
EN ISO 2560-A	AW	≥380	470-600	-	≥20	-	≥47
Typical values	AW	420	495	30	26	83	74

AW = As welded

- = not specified

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	MCAN	555	9.0	627257
3.2 x 350	MCAN	355	9.5	627258
4.0 x 350	MCAN	355	9.5	627259

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.