

# Lincoln® Pipe 6

Mild Steel, Cellulosic · AWS E6010

## KEY FEATURES

- High operator appeal and great control.
- Easy slag removal.
- Excellent performance during vertical down or up application.
- Q2 Lot® certificates showing actual deposit chemistry and mechanical properties.

## WELDING POSITIONS

All

## 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.

## CONFORMANCES

AWS A5.1 :2012 E6010

ASME SFA-5.1 E6010

ABS: E6010

## DIAMETERS / PACKAGING

Diameter		Length		Plastic tube 13.23 lb (6 kg) Master Carton 39.68 lb (18 kg)
in	(mm)	in	(mm)	
3/32	2.50	14	355	504723
1/8	3.25	14	355	504287
5/32	4.00	14	355	504288

## MECHANICAL PROPERTIES<sup>(1)</sup> – As Required per AWS A5.1 : 2012

	Yield Strength <sup>(2)</sup> Mpa (ksi)	Tensile Strength Mpa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf) @-29°C (-20°F)
Requirements AWS E6010	330 (48) mín.	430 (60) mín.	22 mín.	27 (20) mín.
Typical Results <sup>(3)</sup> - As-Welded	405 - 515 (59 - 75)	495 - 620 (72 - 90)	22 - 36	27 - 85 (20 - 63)

## DEPOSIT COMPOSITION<sup>(1)</sup> – As Required per AWS A5.1 : 2012

	%C	%Mn	%Si	%P	%S
Requirements AWS E6010	0.20 máx.	1.20 máx.	1.00 máx.	Not Specified	Not Specified
Typical Results <sup>(3)</sup> - As-Welded	0.11-0.20	0.51 - 0.77	0.15 - 0.32	0.006 - 0.016	0.005 - 0.011
	%Ni	%Cr	%Mo	%V	
Requirements AWS E6010	0.30 máx.	0.20 máx.	0.30 máx.	0.08 máx.	
Typical Results <sup>(3)</sup> - As-Welded	0.01 - 0.04	0.01 - 0.04	0.01 - 0.02	≤ 0.01	

## TYPICAL OPERATING PROCEDURES

Polarity <sup>(4)</sup>	Current (Amps)		
	3/32 in. (2.50 mm.) 1/8	1/8 in. (3.25 mm)	5/32 in. (4.00 mm.)
CD +	50 - 85	75 - 135	100 - 175
C.D - (Recommended for Root Pass)	50 - 85	75 - 135	100 - 175

(1) Typical all weld metal (2) Measured with 0.2% offset (3) See test results disclaimer (4) Preferred polarity is listed first

*Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at [www.lincolnelectric.com](http://www.lincolnelectric.com)*

*FUMES AND GASES can be hazardous to your health.*

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.*
- Keep your head out of the fumes.*
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.*
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.*

#### **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.

#### **CUSTOMER ASSISTANCE POLICY**

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed. Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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