

LINCOLN CELLULOSIC STICK ELECTRODES

MADE FOR THE TOUGHEST
PIPELINE JOBS

LINCOLN 6010 · LINCOLN 7010 · LINCOLN 8010

EN 10204
3.1 TESTED



RUGGED STICK FOR RUGGED WORK

Welding positions
(ISO/ASME)



3.1 tested batches
to provide actual weld composition
and mechanical properties



All-position welding
Excellent weldability in all
positions.



Outstanding impact
Impact tested at -30°C.



DC+ / DC- flexibility
Designed for both DC+
and DC- current.

CHOOSE THE RIGHT ELECTRODE FOR THE PIPELINE GRADE

Pipeline welding stands among the most demanding disciplines in the trade. Every weld must perform flawlessly - because the integrity of the pipeline depends on it. All the while, welders face relentless exposure to harsh environments, unpredictable conditions, and time pressures.

Engineered for extreme reliability and superior arc stability, the new **Lincoln cellulosic range of stick electrodes delivers the strength, control, and consistency** you need to stay ahead of the **toughest pipeline challenges**. From root to cap, **they are built to perform**—no matter what the job throws at you.

LINCOLN 6010

Mild Steel

- For lower-strength pipeline applications.
- Recommended for root and fill passes depending on pipe grade.

LINCOLN 7010

Low-alloy

- For demanding pipeline welding applications.
- Suitable for root and fill applications up to selected high-strength grades.

LINCOLN 8010

Low-alloy

- Designed for demanding high-strength pipeline applications.
- Suitable for fill passes on higher pipe grades.

Grade and applications

AWS		Low Strength				High Strength		
		<X60	X60	X65	X70	X80	X90	X100
LINCOLN 6010	E6010	Root Fill	Root Fill	Root	Root	Root		
LINCOLN 7010	E7010-P1		Root Fill	Root Fill	Root	Root		
LINCOLN 8010	E8010-P1 E8010-G				Fill	Fill	Root	

Output range

	2,5 x 350 mm	3,2 x 350 mm	4,0 x 350 mm	5,0 x 350 mm
LINCOLN 6010	40-80 A	60-110 A	90-140 A	-
LINCOLN 7010	-	60-110 A	90-140 A	110-170 A
LINCOLN 8010	-	60-110 A	90-140 A	110-170 A

Ordering information

Item	Diameter mm	Length mm	Weight kg	Grade pipe
LINCOLN 6010				
627257	2,5	350	9	Up to X60
627258	3,2		9,5	
627259	4,0		9,5	
LINCOLN 7010				
627262	3,2	350	9,5	Up to X65
627263	4,0			
627264	5,0			
LINCOLN 8010				
627266	3,2	350	9,5	Up to X80
627267	4,0			
627268	5,0			

Chemical composition and mechanical properties

	C	Mn	Si	Mo	Ni	Yield strength [MPa]	Tensile strength [MPa]	Elongation [%]	Impact ISO-V [J] -30°C
LINCOLN 6010	0,1	0,6	0,2			420	495	28	74
LINCOLN 7010	0,1	0,7	0,2	0,5		450	590	26	66
LINCOLN 8010	0,1	0,8	0,2	0,5	0,7	540	615	23	69



ROBUST BY DESIGN

Sealed metal cans safeguard cellulosic stick electrodes against damage and contamination, guaranteeing reliability from production to point of use.



CUSTOMER ASSISTANCE POLICY

The business of 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 enquiries 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.

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LINCOLN
ELECTRIC