



Selectarc C6010

Cellulose Electrode
High resistance

Classification

AWS A5.1 : E6010

ISO 2560-A : E 42 2 C 2 5

Description & Applications

Cellulose coated electrode specially for pipe welding in vertical downhand position. Very thin slag and easy to remove. Particularly recommended for root passes. Very good behaviour on bad prepared joints (rust, painting...).

Main applications: Used for metal constructions, for piping systems, tanks, blacksmithing, craft works.

Base materials

Construction steels for general use, Tube steels, Ship steels:

| | | |
|-----------------|-----------------------------------|--|
| EN- Designation | S185 – S355 P235 – P355 | L210 – L360 |
| Ship steels | Quality A and B | |
| ASTM | A285 grade C A442 grade 55, 60 | A414 grade C, D, E, F A515 grade 55, 60, 65 |

Typical Weld Metal Composition (%)

| C | Si | Mn | Cr | Ni | Mo | P | S |
|------|-----|------|------|------|------|--------|--------|
| 0.12 | 0.2 | 0.45 | 0.20 | 0.30 | 0.30 | <0.025 | <0.025 |

All Weld Metal Mechanical Properties

| R _e (MPa) | R _m (MPa) | A ₅ (%) | KV (J) |
|------------------------|------------------------|----------------------|----------|
| 430 | 530 | 26 | -20°C 70 |

Welding Current & Instructions

| | | | | |
|-----------|------------|---------|---------|---------|
| Electrode | ØxL (mm) | 2,5x350 | 3,2x350 | 4,0x350 |
| Current | (A) | 70 | 110 | 150 |

Direct current (= -) pole on the electrode in the root pass, then + pole for the following passes.

