

## CLASSIFICATION

EN ISO 2560-A : E 42 2 C 21  
AWS A5.1 : E6010

## GENERAL DESCRIPTION

L-6010 is an easy to strike cellulosic coated electrode. Excellent molten pool control due to easily-removable, low-volume slag and gaseous arc shielding eliminates porosity problems in weld beads. In all positions, it enables weld beads of high penetration and it minimizes problems that frequently occur in the welding of rusty or oily steels.

## APPROVALS

CE, GOST, SEPRO, TSE

ABS	BV	DNV	GL	LRS	TL
3	3	3	3	3m	3

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Si	Mn
0.08	0.20	0.60

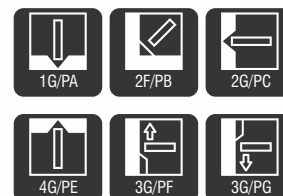
## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 420 N/mm <sup>2</sup>
Tensile Strength	: 530 N/mm <sup>2</sup>
Elongation (L=5d)	: 25 %
Impact (ISO-V)	: 45 J ( - 29°C)

## WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+)

Diameter [ mm ]	Length [ mm ]	Current [ A ]			Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
		Root Pass	Hot Pass	Cover Pass			
2.50	350	40 - 80	-	-	1590	5.2 / 325	5
3.25	350	80 - 100	100 - 125	80 - 100	2620	5.8 / 220	5
4.00	350	110 - 130	115 - 140	110 - 130	3970	5.6 / 140	5
5.00	350	-	160 - 185	140 - 160	6220	5.6 / 90	5



## APPLICATIONS AND MATERIALS TO BE WELDED

Site welding of pipe and pipelines carrying natural gas, crude petroleum or alike; ship building; storage tanks, boiler and pressure vessel manufacturing, steel and bridge constructions are among its application areas. L-6010 can be used in applications requiring high penetration . It can be used for root and deposition pass and also for pipe connections of 5LX46 grade line pipes.

	DIN	EN
<b>General Structural Steels</b>	St 33, St 35, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4	S185, S235, S275, S355 P235TR2 - P355T2
<b>Fine Grained Steels</b>	StE 255 - StE 355 WStE 255 - WStE 355	S255N - S355N P255NH - P355NH
<b>Pipe Materials</b>	StE 240-7 - StE 360-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X56 (API 5LX)	L245NB - L360NB L290MB - L360MB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4 HI, HII, HIII	P295GH P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, B, C, D, E	-
<b>Cast Steels</b>	GS-38 - GS-45	GE200, GE240, GE260

**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.

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