

Lastek 6010

Cellulosic electrode

CLASSIFICATION

EN ISO 2560-A : E 35 2 C 2 5

AWS A5.1 : E 6010

GENERAL DESCRIPTION

Cellulosic type electrode.
For root, fill and cap layers.
Especially recommended for root passes.
Good radiography quality.

APPLICATIONS

API 5LX X42 - X56

St 37.0 - St 52.0

St 37.4 - St 52.4

StE 210.7 - StE 360.7

StE 210.7 TM - StE 360.7 TM

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.10	Si : 0.25	Mn : 0.35	P : < 0.02	S : < 0.02
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MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 410 MPa	≥ 480 MPa	≥ 20%	≥ 47 J (-20°C)

GENERAL INFORMATION

Welding positions All

Shielding gas NA

Packing 5 kg in a plastic box

Polarity AC or DC, reverse polarity (electrode positive)

Diameter (mm) 2.5 3.2 4.0 5.0

Length (mm) 350 350 350 450

Tips & tricks

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.