

Pipeliner® 6P+**CLASSIFICATION**

AWS A5.1 : E6010
 ISO 2560-A : E 42 3 C 25

GENERAL DESCRIPTION

All-position cellulosic pipe electrode designed for all position pipe welding, including vertical down root pass welding
 Designed for root pass welding of pipe up to and including X80, fill and cap pass welding up to and including X60
 Light slag with little slag interference for easy arc control
 Easy slag release and smooth bead appearance
 Deep penetration with maximum dilution
 X-ray quality welds, even out of position

WELDING POSITIONS**CURRENT TYPE**

DC +/-

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

C	Mn	Si	P	S
0.11	0.55	0.18	0.009	0.009

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
				-29°C	-30°C
Required: AWS A5.1 ISO 2560-A Typical values	min. 331 min. 420 420-524	min. 414 500-640 503-594	min. 22 min. 20 24-33	27	47
AW				51-85	

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5	3.2	4.0
	Length (mm)	350	350	350
Unit: metal can	Net weight/unit (kg)	4.7	4.5	4.5

Identification Imprint: 6010 Tip Color: none

Pipeliner®6P+: rev. EN 22

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
 Fumes: Material Safety Data Sheets (MSDS) are available on our website.

Pipelin[®] 6P+

MATERIALS TO BE WELDED

Steel grades/Code	Type
Pipe material	
API 5LX	X42, X46, X52, X56, X60

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time	Energy	Dep. rate	Weight/ 1000 pcs (kg)	Electrodes/ kg weld- metal B	kg electrodes/ kg weldmetal 1/N
			(S)*	- per electrode at max. current - E(kJ)	H(kg/h)			
2.5x350	40-70	DC+/-						
3.2x350	65-130	DC+/-						
4.0x350	90-175	DC+/-						
5.0x350	140-225	DC+/-						

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions	
	PF/5Gup	PG/5Gdown
3.2	90A	110A
4.0	130A	150A
5.0	150A	165A

REMARKS / APPLICATION ADVICE

Preheating pipe material L360 (X52) required (acc. EN 1011-1).

Pipeclamps to be removed after finishing root pass, start welding hot pass (within 5 min) after root pass

Use electrodes directly from metal cans