

International standards	EN 499	E35 2 C 21
	AWS A 5.1	E6010
	DIN 1913	E 43 43 C 4

Approvals ---

Typical applications and characteristics Cellulose medium coated electrode for joining and repairing pipelines, especially in vertical down position. Due to its high penetration, CARBO CEL 6010 is particularly suitable for welding root layers and built up passes in the vertical down direction. Excellent weldability also on soiled surfaces containing impurities from corrosion, paint residues, priming coats, etc. High efficiency as compared to vertical up welding.

Application fields Shipbuilding, storage vessels, boilers, pipeline constructions

Operating temperature From -20° C up to +450° C

Base materials API 5 LX, X42 – X60, L240NB – L415NB, L290MB – L415MB u. ä.

Mechanical properties of all-weld metal	Tensile strength R_m	Yield strength R_{eL}	Elongation A_5	Impact strength ISO – V J	
	N/mm²	N/mm²	%	- 20°C	-30°C
(typical values)	470	530	28	60	45

Weld metal analysis	C	Si	Mn
(typical, wt. %)	0,10	0,2	0,5

Current Fill : = + for root pass welding = -

Welding positions PA, PB, PC, PD, PE, PF, PG

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 350	40 – 80	299	897	16,7	5	15
3,2 x 350	60 – 110	181	543	27,6	5	15
4,0 x 350	90 – 140	117	351	42,8	5	15
5,0 x 350	120 – 180	83	243	60,3	5	15

Rev. 001