

# S-6010.D

TYPE : Cellulosic

AWS A5.1 / ASME SFA5.1 E6010  
JIS Z3211 E4310  
EN ISO 2560-A - E38 3 C 2 5

## Applications

S-6010.D can be used for welding of pipes, storage tanks, pressure vessels, cast steel repairs, machines and heavy construction works.

## Characteristics on Usage

S-6010.D is a high cellulose type electrode for welding in all positions including vertical-down using DC(+).

S-6010.D exhibits deep penetration and fast freezing.

## Notes on Usage

- ① Pay attention not to use currents exceeding the recommended currents.
- ② As this electrode is prone to absorb moisture, store it with care.

## Welding Position



5G Up/Down

(PF.PG)

## Current

DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.10	0.17	0.42	0.015	0.017

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
447 (64,900)	517 (75,000)	32.3	-30 (-22)	62 (46)

## Approval

KR, ABS, LR, BV, DNV, GL, NK, CWB

## Packing

Packet 5 kg (11 lbs)  
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	350 (14)	350 (14)	350 (14)
F,V-down	50~75	70~110	110~155	155~200
V-up	40~70	55~105	90~140	120~180