

ZULFI E 6010

Brand Name & Classification

AWS/ASME SFA-5.1:E 6010
DIN 1913: E 43 43 C 4
EN 499: E 35 2 C 25

Approvals Grade

ABS
DNV
LRS 2
BV
GL

Properties

Electrode for welding of pipe lines (girth seams) using vertical down technique. It is suitable for welding root passes, hot passes, filler and cover passes. It is also suitable for root passes on high strength pipe steels

Application

Pipe steels: St 37.0 – St 44.0 – St 52.0
St 37.4 – St 44.4 – St 52.4
StE 210.7 – StE 360.7
StE 210.7 TM – StE 360.7 TM
API 5 LX steels: X42 to X56

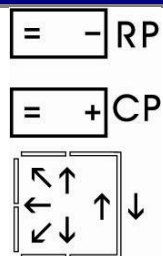
Weld Metal Analysis Typical values

Carbon: 0.10
Silicon: 0.50
Manganese: 0.60

Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>410 N/MM2	470 – 590 N/mm2	> 23 %	90 J at +20 c 50 J at - 20 c

Welding Current & Positions



Current

Dia	Length	Amperes
2.6	300	60-80
3.2	350	80-120
4.0	350	110-150
5.0	350	140-200