

AK E6010

GB/T 5117 E4310

AWS A5.1 E6010

EN ISO 2560-A:E 353 C 2 1

Description: AK-E6010 is a high cellulose sodium electrode with vertical down Welding property; the welding current is DC reverse. Apply to all positional girth welding of carbon steel pipelines; the bottom welding joint can be one side welding both sides formation.

Application: Suitable for the girth welding of kinds of carbon steel pipelines.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	V
Requirement	0.20	1.0	1.2	0.035	0.040	0.30	0.30	0.20	0.08
Actual Result	0.083	0.13	0.71	0.017	0.017	0.024	0.007	0.011	0.008

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥430	≥ 330	≥ 17	≥27J(-30℃)
Actual Result	479	390	28	100

Recommended welding parameters:

Diameter/ mm		2.5	3.2	4.0
Welding current /A	F/ H	60-90	70- 110	110- 150
	V/OH	50-80	60- 100	100- 140