



## **Product Data Sheet**

**SUPER OPTIMAL 6010** 

## Cellulosic Electrodes

- ★ Excellent all position electrode.
- ★ Best suitable for pipes and pipelines welding.
- ★ Excellent mechanical properties in class.

Classification	AWS A5.1 EN 499	l: :	E 60 <sup>°</sup> E 38	10 3 C 21		EN	ISO 2560-A: 1	E 38 3 C 21
Description and applications	Cellulosic coated deep penetration electrode for welding of pipes and pipelines in all positions using conventional and stove pipe techniques. It is characterized by a deeply penetrating, forceful and spray type arc. Excellent arc striking and re-striking. It is suitable for welding root passes, fill and cover passes.							
Base materials	L210 - L360, X42 - X52, API Grades A25 A & B.							
Typical weld metal	С	S	Si	Mn				
Chemical Composition (%)	0.10	0.2	20	0.60				
All weld metal mechanical properties (typical)	Heat Treatme	ent	To St R <sub>m</sub> (	ensile rength (N/mm²)	Yield Strength R <sub>m</sub> (N/mm <sup>2</sup> )	Elongation A₅%	Impact Energy ISO- V(J) -30°C	
() () ()	As welde	ed		470	400	30	47	
Storage and <i>Redrying :</i>	Keep dry and avoid condensation. Re-drying not generally required. If necessary : 70°C for 30 minutes one time only.							
Welding recommendations:	= +							

Welding positions:



Current conditions:

Diameter (mm)	Length (mm)	Current (A)
2.40 /2.50	350	40-70
3.15 /3.20	350	70-100
4.00	350	100-140
4.80	350	130-170