

PRODUCT INFORMATION

SIFTRODE 6010

EN ISO 2560 : E 42 3 C 25
AWS A5.1: E 6010

DESCRIPTION

Siftrode 6010 is a cellulosic coated electrode designed specifically for use on pipe root runs. They are suitable for use on dirty pipes, which are contaminated with rust, grease or paint.

WELDING POSITIONS



Suitable for use in all positions, but perform particularly well in the vertical-down position.

TYPICAL WELD METAL COMPOSITION

Mn	0.35 %
Si	0.25 %
C	0.1 %
P	<0.02 %
S	<0.02 %

TYPICAL MECHANICAL PROPERTIES

Elongation 5d	>20 %
Impact test Kv (-20 °C)	>47 J
Impact test Kv (-29 °C)	>27 J
Tensile strength	>480 N /mm ²
Yield strength	>410 N /mm ²

MATERIAL TO BE WELDED

Can be used on pipe root runs on St 37.0 to St 52.0, St 37.4 to St 52.4, StE 210.7 to StE 360.7, StE 210.7 TM to StE 360.7 TM & API 5 LX: X 42 to X56 materials.

AVAILABLE FORMATS

ELECTRODE RODS (MMA / SMAW)			
Dia	Part No	Kg / Pkt	Pcs/Pkt
2.5mm	RE612520V	2.0 Vac	300
3.2mm	RE613220V	2.0 Vac	190
4.0mm	RE614020V	2.0 Vac	120
2.5mm	RE612550C	5.0 Can	300
3.2mm	RE613250C	5.0 Can	190
4.0mm	RE614050C	5.0 Can	120

CURRENT RANGE	
Dia	Amps
2.5mm	70 – 90
3.2mm	90 – 140
4.0mm	130 – 180

For further information, contact Weldability Sif technical support on **0870 330 7757** or email service@weldability-sif.com



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