

PipeMark 610

AWS A5.1 E6010
EN ISO 2560-A-E 38 3 C 21

Characteristics and Applications:

PipeMark 610 is a cellulose electrode for both vertical-down and vertical-up welding of large diameter pipelines, excellent for root pass welding. PipeMark 610 is designed for DCEP and DCEN welding. The product can be applied to vertical-down and all position welding and features with stable arc, good slag detachability, and deep penetration. It is suitable for the welding of pressure pipes, oil tanks, and boilers.

Notes on usage:

1. Be sure to clean up the contaminations on the base metal.
2. Not allow to re-dry electrode.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S
AWS	≤ 0.20	≤ 1.20	≤ 1.00	-	-
EN ISO	≤ 0.20	≤ 1.20	≤ 1.00	-	-
Typical value	0.12	0.5	0.15	0.015	0.010

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30°C (-20°F)
AWS	≥ 330(48)	≥ 430(60)	≥ 22	≥ 27(20)
EN ISO	≥ 330(48)	≥ 430(60)	≥ 22	≥ 27(20)
Typical value	500(73)	580(84)	22	40(30)

Welding position:



Sizes and recommended current range(DC <±>):

Diameter (mm)	2.4	2.6	3.2	4.0	4.8
Length (mm)	350		350	350	350
Amps	50-70		60-100	90-140	140-200

Base Materials:

EN: S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P335T2, L210NB-L415NB, L290MB-L415MB, P235G1TH, P255G1TH. Root pass up to L555NB, L555MB

API 5 L: A, B, X42, X46, X52, X56. Root pass up to X80.

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