

# LKE-6010



LINKWELD ALLOYS INC.

AWS	A5.1 E6010
EN	EN499 E 42 2 C 2 2
JIS	Z3211 D4311

## Characteristics:

LKE-6010 is a cellulose type electrode designed for all position welding. It has deep penetration, stable arc and good slag removability.

## Applications:

It is suitable for welding of pressure pipes, pressure vessel, storage tanks and boiler.

## Notes on Usage:

1. Use proper low currents are recommended.
2. Dry the electrodes at 60-70°C for 30-60 minutes.
3. Clean up the base metal to be free from contaminations.

## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.12	0.45	0.2	0.018	0.01

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL %	IV -30 °C J
431	519	25	32

## Welding position:



## Sizes and recommended current range (DC <+> )

Diameter (mm)		2.6	3.2	4.0	4.8
Length (mm)		350	350	350	350
Amps	F	60-80	80-120	110-180	140-200
	V&OH	40-80	60-120	90-160	120-180
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20