



# ESC 60



General purpose cellulosic electrode - **AWS/ASME SFA - 5.1 E6010**

### Key Benefits

- Medium coated, cellulosic electrode, especially designed for welding of pipes and plates in all positions at low welding currents.
- Due to its high penetration, particularly suitable for root pass and fill passes in vertical down direction.
- Used in pipe-line construction, shipbuilding, storage vessels and assembly works.
- DCEN (-) is ideal in root passes and DCEP (+) is recommended for fill and cap passes in vertical down position.

### Welding Positions



### Typical application

- Pipeline construction

### Typical Analysis in %

<b>Requirements – AWS E6010</b> Typical Chemical Composition	%C	%Mn	%Si	%S	%P
	0.10	0.50	0.20		
<b>Requirements - AWS E6010</b> Typical Chemical Composition	%Cr	%Ni	%Mo	%Cu	%Ti

### Mechanical Properties

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Impact Energy J
<b>Typical Results (all weld metal)</b> As Welded	470 MPa	530 MPa	25	-30°C → 40J -20°C → 60J

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## Ordering Information

Product Number	Product/AWS Specification	Dimension mm/inches	Single Tube Weight kg/lb
1141010M46	ESC 60 (E6010)	2.50 x 350 mm (3/32" x 14")	8.0 kg (17.6 lb)
1141016M46	ESC 60 (E6010)	3.25 x 350 mm (1/8" x 14")	8.0 kg (17.6 lb)
1141020M46	ESC 60 (E6010)	4.00 x 350 mm (5/32" x 14")	8.0 kg (17.6 lb)
1141028M46	ESC 60 (E6010)	5.00 x 350 mm (3/16" x 14")	8.0 kg (17.6 lb)

