

PRODUCT DATA SHEET

Pipemaster Pro-60



Pipemaster Pro-60 is a quick-starting, cellulosic mild steel electrode that provides outstanding arc stability, penetration and wash-in. It is ideal for welding in all positions and produces an X-ray quality weld with light slag that is easy to remove. Pipemaster Pro-60 can be used to weld the following API 5L steels: Grade A, B, X-42, X-46, X-52, X-56 and for the root pass on material up to X-80. It features enhanced weldability and increased mechanical properties.

Classifications

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

Approvals

American Bureau of Shipping Grade 3,3Y

Lloyds Register of Shipping Grade 3,3Y,No

Typical Chemical Analysis (All weld metal)

% Carbon	0,08	% Silicon	0,15
% Manganese	0,45		

Typical Mechanical Properties (All weld metal in the as welded condition)

Yield Strength	413 MPa
Tensile Strength	496 MPa
% Elongation on 5d	27
Charpy V-Notch at -29°C	68 J

Typical Current Values and Deposition Data (AC 50 OCV min or DC+/-)

Diameter (mm)	Current (A)	Deposition Rates (kg/hr)
2,4	40 - 70	0,6
3,2	65 - 130	0,7
4,0	90 - 175	0,9
4,8	140 - 225	1,2

Packing Data

Diameter (mm)	Hermetically Sealed Steel Can (kg)	Item Number
2,4	22,7	W075172
3,2	22,7	W075173
4,0	22,7	W075174
4,8	22,7	W075175

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