

Fleetweld® 5P+

SMAW

CLASSIFICATION

AWS A5.1	E6010	A-Nr	1
ISO 2560-A	E 42 3 C 2 5	F-Nr	3
		9606 FM	1

GENERAL DESCRIPTION

Cellulosic coated electrode for pipe and general welding
 Gives high ductility root welds
 Very deep penetration ensures sound root pass
 Easy striking, easy slag release
 High volume of generated gas eliminates porosity
 Reduces problems from dirt and oil on surface

WELDING POSITIONS (ISO/ASME)



PH/5Gu



PJ/5Gd

CURRENT TYPE

DC +

APPROVALS

ABS

+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si
0.20	0.56	0.17

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)
					-29°C/-30°C
Required: AWS A5.1	AW	min. 330	min. 430	min. 22	min. 27
ISO 2560-A		min. 420	500-640	min. 20	min. 47
Typical values		471	586	24	56

PACKAGING AND AVAILABLE SIZES

	Diameter (mm) Length (mm)	2.5	3.2	4.0	5.0
			350	350	350
Linc Can™	Pieces / unit	304	180	130	83
	Net weight/unit (kg)	5.1	4.7	5.1	5.1

Identification Imprint: 6010/FW5P+ Tip Color: none

Fleetweld® 5P+: rev. C-EN29-01/02/16

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
 Fumes: Safety Data Sheets (SDS) are available on our website.

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
Pipe material	
EN 10208-1	L 210, L 240
EN 10208-2	L 240 , L 290, L 360
EN 10216-1 / 10217-1	P 235, P 275, P 355
API 5LX	X42, X46, X52
Gaz de France	X42, X46, X52

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CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Weight/ 1000 pcs (kg)
2.5x350	40-70	DC+	15.8
3.2x350	65-130	DC+	26.2
4.0x350	90-175	DC+	40.0
5.0x350	140-225	DC+	62.5

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions	
	PH/5G up	PJ/5G down
2.5	55A	65A
3.2	90A	110A
4.0	130A	150A
5.0	150A	165A

REMARKS / APPLICATION ADVICE

Preheating pipe material L360 (X52) required (acc. EN 1011-1)

Pipeclamps to be removed after finishing root pass, start welding hot pass (within 5 min) after root pass

Use electrodes directly from metal Metal cans