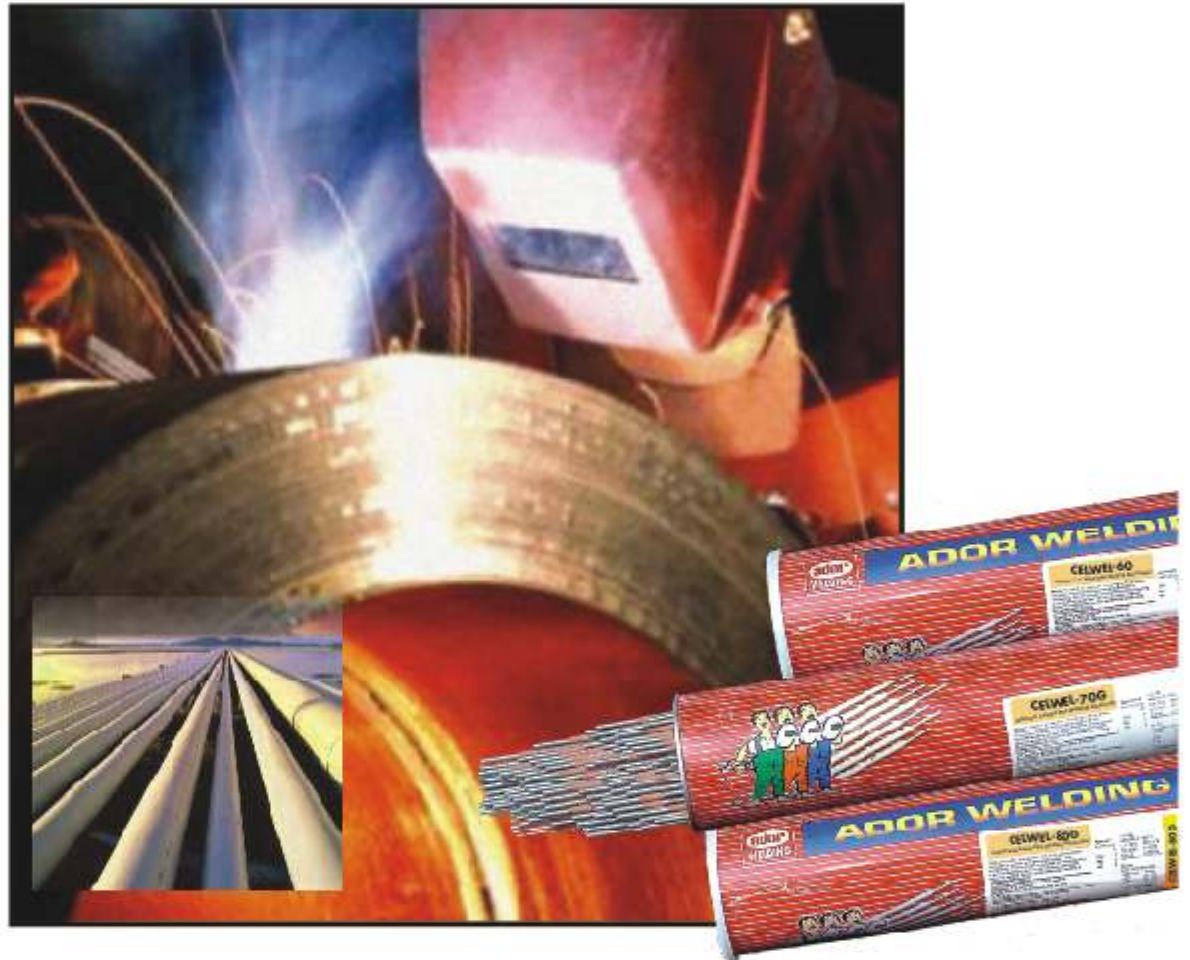


# CELWEL

World class pipeline electrodes from India's Welding Powerhouse



- All-position electrodes including vertical down.
- Ideal for cross-country pipeline welding (stove pipe welding technique or 6 GR applications).
- Deep penetrating forceful arc.
- Consistency in performance batch after batch, welder-friendly.
- Covers the entire range of API pipe grades (X42 to X70) including root filling and capping runs.
- Moisture controlled.
- Test certificates with every batch & full support for Welding Procedure Qualification
- Approved by leading agencies i.e. ABS, DNV, LRS, TOYO, PDIL etc.
- International-quality packing (TIN packed).



## ADOR WELDING LIMITED

Central Marketing Office

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Fax : +91 22 2596 6562 E-mail : cmo@adorians.com Website : www.adorwelding.com



## CELWEL 60

### CLASSIFICATIONS

AWS A/SFA 5.1 E 60'0 EN 499 E 42 3 C 25  
IS 814 E C 5410

### APPROVED & CERTIFIED BY

ABS Gr. 3 Toyo E 6010  
DNV Gr. 3 PDIL E 6010  
LRS Gr. 3

### CHARACTERISTICS

It gives excellent arc stability, arc smoothness and very easy slag removal. Ideal for root pass and capping runs. It has exceptional all-positional operating characteristics, especially in vertical down (stove-pipe technique), giving X-ray quality welds even for pipe welding.

### IDEAL FOR WELDING OF

Cross country pipelines subjects to dynamic loading and mechanical restraint. Suitable for joining steels like A105Gr A/B, API5L X42-X56

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	Elong.%	CVN Impacts, J	
	MPa	MPa	(L=4xd)	-20°C	-29°C
AW	430-580	380-460	24 - 29	70 - 90	48 - 56

AW : As-welded

### Weld Metal Chemistry, wt%

C - 0.06-0.20	S - 0.015 max.	Si - 0.20-0.50
Mn - 0.4-0.7	P - 0.020 max.	

### PACKING DATA

Dia., mm	5.0	4.3	3.2	2.5
Length, mm	350	350	350	350
Wt. per Tin, kgs	5.25	5.25	5.25	5.25
Tin/box	3	3	3	3
Wt. per box, kgs	15.75	15.75	15.75	15.75

## CELWEL 70G

### CLASSIFICATIONS

AWS A/SFA 5.5 E 70'0-G EN 499 E 46 3 C 25  
IS 814 E C 5410

### APPROVED & CERTIFIED BY

ABS E7010-G LRS E7010-G  
DNV E7010-G Toyo E7010-G  
KRL E7010-G

### CHARACTERISTICS

It gives excellent arc stability, arc smoothness and very easy slag removal. Ideal for root pass and capping runs. It has exceptional all-positional operating characteristics, especially in vertical down (stove-pipe technique), giving X-ray quality welds even for pipe welding.

### IDEAL FOR WELDING OF

Cross country pipelines subjects to dynamic loading and mechanical restraint. Suitable for joining pipes of API 5L X52 to X65

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	Elong.%	CVN Impacts, J	
	MPa	MPa	(L=4xd)	-20°C	-29°C
AW	530-595	450-500	22-27	40-50	30-50
PWHT	520-590	450-500	22-27	30-45	30-45

### Weld Metal Chemistry, wt%

C - 0.12 max.	S - 0.010 max.	Mo - 0.3-0.4
Mn - 0.4-0.8	P - 0.012 max.	Si - 0.1-0.3

### PACKING DATA

Dia., mm	5.0	4.3	3.2	2.5
Length, mm	350	350	350	350
Wt. Per Tin, kgs	5.25	5.25	5.25	5.25
Tin/box	3	3	3	3
Wt. per box, kgs	15.75	15.75	15.75	15.75

## CELWEL 80G

### CLASSIFICATIONS

AWS/SFA 5.5 E 80'0-G

### APPROVED & CERTIFIED BY

LRS - E 80'0 G

### CHARACTERISTICS

Cellulose coated electrode for vertical-down welding of high strength, large and medium diameter pipelines. Especially recommended for hot passes, filler and capping. The deposited welds are of radiographic quality and meet API code requirements.

### IDEAL FOR WELDING OF

High tensile pipe steels like API 5L X 60, 65 and 70. Also suitable for welding thin walled X80 pipes.

### MECHANICAL PROPERTIES- ALL WELD

Condition	UTS	YS	Elong.%	CVN Impacts, J at minus 30°C in J
	MPa	MPa	(L=4xd)	
AW	550-670	460-565	19-24	30-50
PWHT (620°C / 1hr)	550-610	445-535	23-29	40-50

### Weld Metal Chemistry, wt%

C - 0.12 max.	S - 0.010 max.	Mo - 0.30 max.
Mn - 0.8-1.30	P - 0.012 max.	Si - 0.10-0.30
V - 0.15 max.	Ni - 0.40-0.80	

### PACKING DATA

Dia., mm	5.0	4.3	3.2	2.5
Length, mm	350	350	350	350
Wt. Per Tin, kgs	5.25	5.25	5.25	5.25
Tin/box	3	3	3	3
Wt. per box, kgs	15.75	15.75	15.75	15.75

Backed by our dedicated customer care package.

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