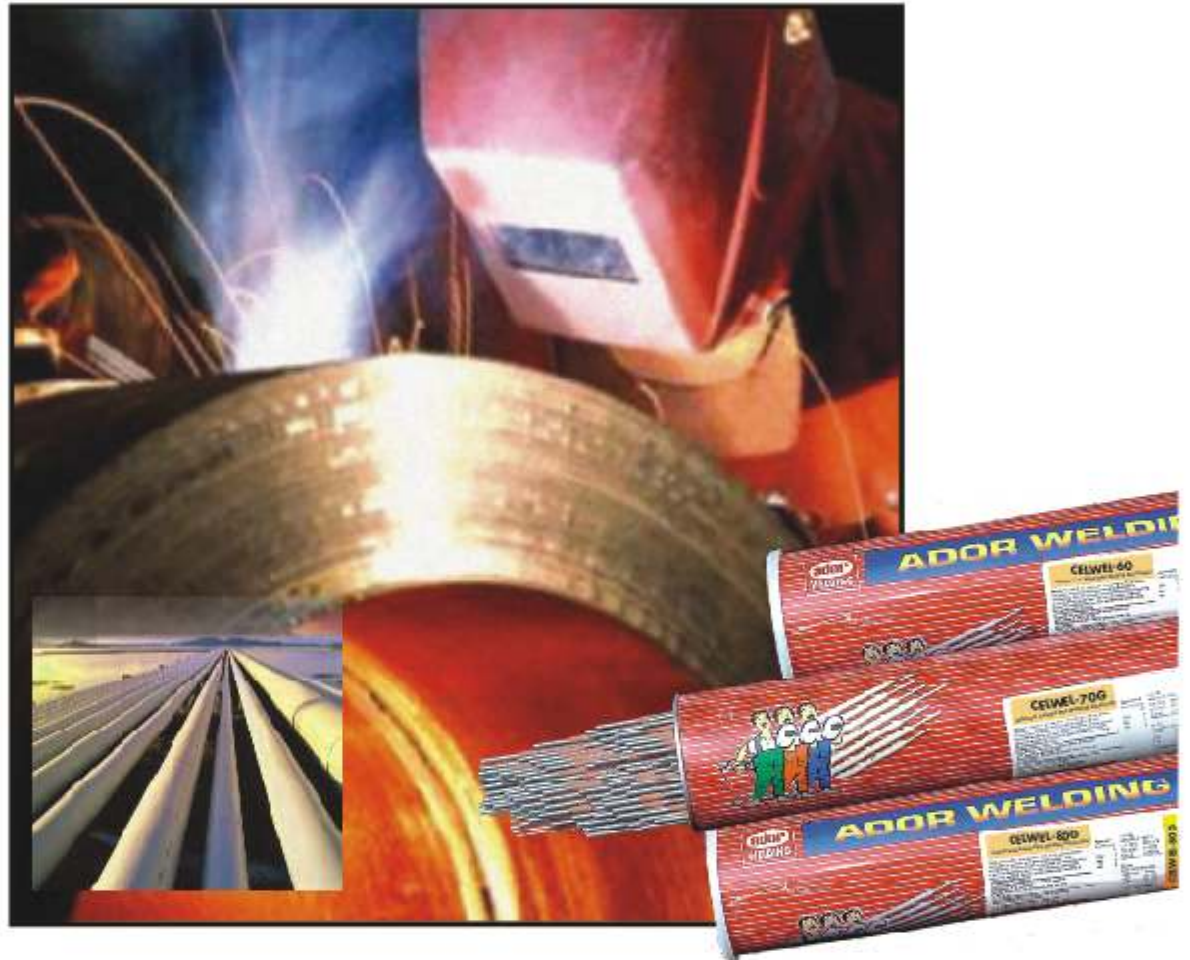


CELWEL

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
	MPa	MPa	(L=4xd)	at minus 30°C in J
AW	550-670	460-565	19-24	30-50
PWHT	550-610	445-535	23-29	40-50

(620°C / 1hr)

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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