

CELWEL 60

AWS A/SFA 5.1 E6010

CELLULOSIC

CLASSIFICATION:

ISO 2560-A
E 38 3 C 21

IS 814
E C 4210 X

KEY FEATURES:

- Cellulose coated electrode
- Exhibits deep penetration and fast freezing
- All position operating characteristics
- Ideal for root pass and capping runs
- Radiographic quality welding

APPROVALS: ABS/LRA/IBR/CE

TYPICAL APPLICATIONS:

- Cross country pipelines subject to dynamic loading and mechanical restraint
- Suitable for steel grades ASTM A106 Gr. A/B, API 5L X42 and for root pass of X56
- Suitable for sour gas pipes

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


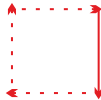
C	Mn	Si
0.15	0.5	0.2

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J
					at -30°C
Typical	As Welded	525	410	26	55
Specification		430 min	330 min	22 min	47 min

Hardness (3 Layer): 235 BHN max

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 DCEP	All Positions, specifically in vertical down 
2.5 x 350	50-90		
3.15 x 350	80-140		
4.0 x 450	120-180		
5.0 x 450	160-200		

Available in Standard carton packing of 18 kg box / tin containing 3 cartons of 6 kgs each. Also available in vacuum packing