

CELWEL 60S

AWS A/SFA 5.1 **E6011**

CELLULOSIC

CLASSIFICATION:

ISO 2560-A
E 38 3 C 11

IS 814
E C 4216 X

KEY FEATURES:

- Cellulose type medium coated
- High melting speed
- All position operating characteristics
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Pipelines, Pressure vessels
- Shipbuilding, Storage tanks
- Structural fabrication, Truck frames
- Bridges, Maintenance welding
- Suitable for steel grades API 5L X42 and X46


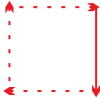
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.12	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, J
Typical	As Welded	520	420	27	55
Specification		430 min	330 min	22 min	47 min

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 450 5.0 x 450	Amperage, A 60-90 80-140 120-180 160-200	 AC (70 OCV)/DCEP	All Positions, specifically in vertical down 
---	---	---	---

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

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Automig 70 S - 3	Tigfil 70 S - 2 SPL	Automig FC 71 T - 5	Automelt B20 Plus	Automelt EH 12K
Automig 70 S - 6 (Ar - CO ₂)	Tigfil 70 - 3		Automelt B41	Automelt EH 10K
	Tigfil 70 S - 6		Automelt B41	Automelt EH 14K