



CELWEL 60S

CELLULOSIC

AWS A/SFA 5.1 **E6011**

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


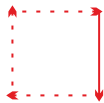
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

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

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