



## CELWEL 60S

CELLULOSIC



Electrode for Welding Pipeline and Structural Fabrication

**CLASSIFICATION : ISO 2560-A**

**AWS A/SFA 5.1**

E 38 3 C 11

E 6011

### KEY FEATURES :

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

### WELDING POSITION :



**AC (65 OCV)/DCEP**

### TYPICAL APPLICATIONS :

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

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
Typical	0.12	0.5	0.2	0.01	0.01
Specification	0.2 max	1.2 max	1.0 max	-	-

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at -30°C, J</b>
Typical	As Welded	520	420	27	58
Specification		430 min	330 min	22 min	50-100

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Tin pack, Kg</b>	<b>Tin packs/Box</b>	<b>Net wt./Box, Kg.</b>
2.5 x 350	60-90	6	3	18
3.15 x 350	80-140	6	3	18
4.0 x 350	120-180	6	3	18
5.0 x 350	160-200	6	3	18