

CLASSIFICATION:

EN ISO 2560-A

E 42 2 Mo C21

IS 814

E 49C - A1

KEY FEATURES:

- High cellulose type coating
- Ideal for root pass and capping runs
- Best suited for vertical down stove-pipe technique
- Radiographic quality weld

APPROVALS: LRA

TYPICAL APPLICATIONS:

- Cross country pipelines subject to dynamic loading and mechanical restraint
- Best suited for site welding
- Suitable for pipe grades API 5L X42 to X60



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Mo
0.13	0.5	0.4	0.40

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	555	470	24	55
Specification		530 min	450 min	22 min	47 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 DCEP	All Positions, specifically in vertical down 
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