



CELWEL 70G

CELLULOSIC



Electrode for Welding of High Strength Pipelines

CLASSIFICATION : EN ISO 2560-A

AWS A/SFA 5.5

APPROVALS :

E 42 2 Mo C 21

E 7010-G

LRA

KEY FEATURES :

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

WELDING POSITION :



DCEP

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Mo	S	P
Typical	0.1	0.5	0.2	0.35	0.01	0.01
Specification	0.12 max	0.40-0.80	0.10-0.30	0.30-0.40	0.015 max.	0.015 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact , J	
					-20°C	-30°C
Typical	As Welded	555	470	24	44	38
Specification		530-595	450-500	22-27	40-50	30-50
Specification	PWHT: 620°C for 1Hr	490	415	22 min	35-45	30-40

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Tin pack, Kg	Tin packs/Box	Net wt./Box, Kg.
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