

CELWEL 70P

AWS A/SFA 5.5 E7010-P1

CELLULOSIC

CLASSIFICATION:

EN ISO 2560-A
E 42 2 C 21

IS 814

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KEY FEATURES:

- Cellulose type coating
- Ideal for root pass and capping runs
- All position welding characteristics
- Welding with Stove-pipe technique
- Radiographic quality weld

APPROVALS: - CE

TYPICAL APPLICATIONS:

- Cross country pipelines subject to dynamic loading and mechanical restraint
- Joining ASTM SA-283 Gr.A/B/C/D, API 5L X42, X46, X52, X56, X60 and X65



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Mo
0.1	0.8	0.3	0.4

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at-30°C, J
Typical	As Welded	560	450	24	40
Specification		490 min.	415 min	22 min	27 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	 DCEP	All Positions, specifically in vertical down 
2.5 x 350	50-70		
3.15 x 350	80-120		
4.0 x 450	110-160		
5.0 x 450	160-210		

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