



## CELWEL 70P

CELLULOSIC



Electrode for Welding Cross Country Pipelines

**CLASSIFICATION : EN ISO 2560-A**

**AWS A/SFA 5.5**

E 42 2 C 21

E 7010-P1

### KEY FEATURES :

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

### WELDING POSITION :



DCEP

### 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

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

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>
Typical	0.1	0.8	0.3	0.1	0.7
Specification	0.2 max	1.2 max.	0.6 max.	0.3 max.	1.0 max.
	<b>Mo</b>	<b>V</b>	<b>S</b>	<b>P</b>	
Typical	0.1	0.05	0.02	0.02	
Specification	0.5 max.	0.1 max.	0.03 max.	0.03 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	560	450	24	40
Specification		490 min.	415 min.	22 min.	27 min.

### 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	50-70	6	3	18
3.15 x 350	80-120	6	3	18
4.0 x 350	110-160	6	3	18
5.0 x 350	160-210	6	3	18