

CELWEL 80G

AWS A/SFA 5.5 E8010-G

CELLULOSIC

CLASSIFICATION:

EN ISO 2560-A
E 46 3 1Ni C 21

IS 814

-

KEY FEATURES:

- Cellulose type coating
- Ideal for root pass and capping runs
- Recommended for hot passes
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Vertical down welding of high strength, medium and large diameter pipelines
- Suitable for high tensile pipe steels like API 5L X60, X65 and X70
- Welding of thin API 5L X80 pipes



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.1	1.0	0.2	0.1	0.6

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	610	520	22	60
Specification		550 min	460 min	19 min	47 min

PARAMETERS - PACKING DATA:

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