



## CELWEL 80G

CELLULOSIC



Electrode for Welding High Strength Pipelines

**CLASSIFICATION : EN ISO 2560-A**

**AWS A/SFA 5.5**

**APPROVALS :**

E 46 3 1Ni C 21

E 8010-G

LRA

### KEY FEATURES :

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

### WELDING POSITION :



**DCEP**

### 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

### 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	1.0	0.2	0.2	0.9
Specification	0.2 max.	0.6-1.2	0.05-0.3	0.1-0.3	0.75-1.0
	<b>Mo</b>	<b>V</b>	<b>S</b>	<b>P</b>	
Typical	0.05	0.05	0.01	0.01	
Specification	0.1 max.	0.1 max.	0.015 max.	0.015 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, J</b>	
					<b>-30°C</b>	<b>-45°C</b>
Typical	As Welded	610	520	22	58	42
Specification		550-670	460-565	19-24	54 min.	30-50
Specification	PWHT: 620°C for 1Hr	550-610	460-535	23-30	40 min.	40-50

### 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	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