



CELWEL 80P

CELLULOSIC



Electrode for Welding higher strength Pipelines

CLASSIFICATION : EN ISO 2560-A

AWS A/SFA 5.5

E 46 3 1Ni C 21

E 8010-P1

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 % :

	C	Mn	Si	Cr	Ni
Typical	0.1	1.0	0.2	0.2	0.9
Specification	0.2 max	1.2 max	0.6 max	0.1-0.3	0.75-1.0
	Mo	V	S	P	
Typical	0.1	0.05	0.01	0.01	
Specification	0.50 max	0.1 max	0.03 max	0.03 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J	
					-30°C	-45°C
Typical	As Welded	610	520	22	58	42
Specification		550-670	460-565	19-24	54 min	30-50
Specification	PWHT: 620°C for 1 Hr	550 min	460 min	19 min	40 min	40-50

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