



Welding Electrode for Pipeline Welding

CLASSIFICATION : EN ISO 2560-A AWS A/SFA 5.1 APPROVALS :
E 38 3 C 21 E 6010 ABS/LRA/IBR

KEY FEATURES :

- High cellulose coated
- Exhibits deep penetration and fast freezing
- All position operating characteristics
- Ideal for root pass and capping runs
- Radiographic quality weld

WELDING POSITION :



TYPICAL APPLICATIONS :

- Cross country pipelines subject to dynamic loading and mechanical restraint
- Suitable for sour gas pipes
- Suitable for steel grades ASTM A106 Gr.A/B, API 5L X42 and for root pass of X56

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.15	0.5	0.4	0.01	0.01
Specification	0.10-0.20	0.40-0.70	0.20-0.50	0.015 max.	0.02 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact , J	
					-20°C	-30°C
Typical	As Welded	525	410	26	78	52
Specification		490-580	390-460	24-30	70-90	48-70

HARDNESS, 3 LAYER: 235 BHN max

SPECIAL TESTS : HIC & SSCC (NACE)

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Tin pack, Kg	Tin packs/Box	Net wt./Box, Kg.
2.5 x 350	50-90	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