



## CELLUTHERME-80Mo

### CODIFICATION:

AWS : SFA 5.5 E8010-G  
EN ISO : 2560-B E 5510 G A

### CHARACTERISTICS AND APPLICATIONS:

Cellutherme-80Mo electrodes have been designed primarily for welding typical high-strength, pipe butt joints in the vertical welding position with downward or upward progression. This electrode operates with a forceful penetrating arc, produce deep penetrating, spray-type welding arcs and thin, easily removable slag. It is extremely beneficial for welding of pipes in "Stove Pipe Technique" both for faster welding and greater control on penetration of the root runs. The welds are of radiographic quality. It is ideally suited for welding of API 5L-X56 & API 5L-X70 piping assemblies.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	S	P	Ni	Mo
Percent	: 0.08	0.45	0.15	0.018	0.018	1.00	0.25

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%
570	500	21.0

### CURRENT AND PACKING DATA: DC(+)

Size (mm)	: 4x350	3.15x350	2.5x350
Dia x Length			
Current Range (Amps)	: 120-170	90-120	60-80
Quantity (Pcs./Carton)	: 80	120	200

### APPROVAL: CE

### PRECAUTIONS:

1. In order to achieve best results, ensure a good joint fit-up.
2. Do not use high current, which may lead to high spatter loss.