



CELLUTHERME-AC

CODIFICATION:

AWS : SFA 5.1 E6011
EN ISO : 2560-B E 4311 A

CHARACTERISTICS AND APPLICATIONS:

Cellutherme-AC is a light coated cellulosic type, ideally suited for welding in all positions including vertical downwards. The electrode is characterized by forceful, spray type arc, which is also stable and easy to strike and re-strike. The weld beads are evenly rippled. 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 designed for welding pipes and tubes of all diameters in Stove Pipe Technique specially for root runs for achieving good penetration. Typical applications include: Storage tanks, Pressure vessels, Tank wagons, Tipping wagons, Rail coaches, Automobile body and panels, Chutes, Silos, Chimneys, Ducts, Ship's hull construction, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element : C Mn Si S P
Percent : 0.07 0.50 0.20 0.016 0.018

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact Strength (J) at minus 30°C
480	400	27.0	50

CURRENT AND PACKING DATA: AC/DC(+)

Size (mm)	: 4x350	3.15x350	2.5x350
Dia x Length			
Current Range (Amps)	: 110-150	70-105	50-70
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.