



CELLUTHERME

CODIFICATION:

AWS : SFA 5.1 E6010
IS : 814 EC4310X
EN ISO : 2560-B E 43 10 A

CHARACTERISTICS AND APPLICATIONS:

Cellutherm is a light coated cellulosic type electrodes. The electrodes are characterized by a deeply penetrating, forceful, spray type arc and readily removable, thin, friable slag. Ideally suited for welding in all positions including vertical down. The weld metal possesses good mechanical properties. Ideal for stove pipe technique and faster welding. Welds are of radiographic quality. It is ideally suited for root pass welding of API 5L X42 and X46 grades. Typical applications include welding of pipes, tubes, ducts, 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	YS	Elongation	CVN Impact Strength (J)	
(MPa)	(MPa)	(L = 5d)%	Minus 30°C	Minus 20°C
480	400	27.0	50	70

CURRENT AND PACKING DATA: DC(±)

Size (mm)	:	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	:	110-160	70-100	40-65
(Amps)				
Qty.(Pcs./Carton)	:	80	120	200

APPROVALS: CE, EIL, PDIL

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.