

International standards	EN 499	E46 3 C 25
	AWS A 5.1	E8010-G

Approvals ---

Typical applications and characteristics Cellulose coated electrode for vertical down welding of high strength large diameter pipelines. Especially recommended for hot passes, Filler and covers.
Highly economical compared with vertical-up welding.

Excellent weldability also on soiled surfaces containing impurities from corrosion, paint residues, priming coats, etc.

High efficiency as compared to vertical up welding.

Operating temperature From -30° C up to +450° C

Base materials S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH
L210 – L415NB, L290MB – L415MB, P355T1, P235T2 – P355T2, P235G1TH, P255G1TH.
Root pass to L555MB.

API 5 LX, X42 – X60, Root pass to X 80.

Mechanical properties of all-weld metal (typical values)	Tensile strength R_m N/mm ²	Yield strength R_{eL} N/mm ²	Elongation A_5 %	Impact strength ISO – V J - 30°C
	560	> 460	20	> 47

Weld metal analysis (typical, wt. %)	C	Si	Mn	Ni	Mo
	0,1	0,2	0,5	0,7	0,3

Current = + for root pass welding -

Welding positions PA, PB, PC, PG, PE, PF, PG

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
3.2 x 350	80 – 130				5.0	20.0
4.0 x 350	120 – 180				5.0	20.0
5,0 x 350	160 – 210				5,0	20,0

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