

International standards	EN 499	E 42 3 1 Ni C 21
	AWS A 5.1	E8010-G
	DIN 1913	E 51 43 C 4

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 bei - 20°C - 30°C	
	560	> 460	28	60	47

Weld metal analysis (typical, wt. %)	C	Si	Mn	Ni
	0,1	0,2	1	0,8

Current = + for root pass welding =-

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

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/package	kg/carton
2,5 x 350	40 – 80	299	897	16,7	5	15
3,2 x 350	60 – 110	181	543	27,6	5	15
4,0 x 350	90 – 140	117	351	42,8	5	15
5,0 x 350	120 – 180	83	243	60,3	5	15

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