

CLASSIFICATION:
AWS A-5.5 E 8010-G



DESCRIPTION AND APPLICATION:

Cellulose coated electrode for vertical down pipe welding higher strength pipe steels. Especially recommended for hot passes, filler and cover layers.

BASE MATERIALS:

API Spec 5L: Grade X56,X60, X65,X70
DIN 17172 : Grade StE 385.7(TM) , StE 415.7(TM) ,StE 455.7(TM) as well as the root pass upto
StE 550.7(TM)

COATING TYPE: Cellulosic

WELDING CURRENT: DC+,DC (-) (For root beads)

WELDING POSITIONS: ALL

REDRYING TEMP: Not permitted

TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition,wt %:

Element	C	Mn	Si	Ni	Mo
percent	0.14	0.7	0.2	0.6	0.40

Mechanical properties:

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	CVN Impact value
>460	550-650	>20	70 J at(+20°C)

RECOMMENDED CURRENT RANGES:

SIZE mm		2.50 X 350	3.25 X 350	4.00 X 350	5.00 X 350
CURRENT- Amps	DC+	50-65	90-120	110-140	140-200