

LIGHT COATED CELLULOSIC TYPE ELECTRODE

EURO PIPE WELD

CODING: AWS/SFA-5.1 E 6011
DIN E 4343 C 4

CHARACTERISTICS :

EURO PIPE AC is a light coated cellulosic type electrode which can be used in all welding positions including vertical downward. The covering has high content of cellulose to give deep penetrating, forceful arc suitable for wide applications of welding jobs including pipe welding, stove pipe welding etc.

ADVANTAGES :

- Forceful and spray type arc suitable for deep penetration and sound welding jobs.
- Mechanically sound weld metal of Radiographic quality.
- Suitable in all welding positions including vertical downward.
- Thin friable easily removable slag.
- Non interference of slag with weld metal.

APPLICATIONS :

EURO PIPE AC has wide applications and the most important is its use in joining pipe lines, where the electrode is operated in all welding positions. The weld deposit is also of high quality and meets radiographic requirements on multi-pass runs. Other applications include welding mild steel, galvanized steel, low alloy steel, structural work such as building s and bridges, pressure vessel fittings, storage tanks etc.,

CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.25 X 350	4.00 X 450	5.00 X 450
CURRENT-Amps	AC/DC(+)	60-90	100-140	130-180	170-230

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	Ni	S	P
percent	0.14	0.65	0.30	0.10	0.025	0.025

TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	CVN Impact value
420	560	23	55 J(at -20°C)

RADIOGRAPHIC EVALUATION : GRADE-II - SATISFACTORY

FILLET WELD TEST: MET REQUIREMENTS

REBAKING INSTURCTIONS: NOT PERMITTED

EURO PIPE 8010

CLASSIFICATION:

AWS A-5.5 E 8010

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

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