

LIGHT COATED CELLULOSIC TYPE ELECTRODE

CODING: AWS/SFA-5.1 E 6010
EN 499 E42 3C 25

EURO PIPE PLUS

CHARACTERISTICS :

EURO PIPE PLUS is a light coated cellulosic type electrode which can be used in all welding positions including vertical downward on DC(+) only. The covering has high content of cellulose to give deep penetrating, forceful arc suitable for wide applications of welding jobs including pipe welding, cisterns and different containers 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 PLUS 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	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	0.70	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	47 J(at -30°C)

RADIOGRAPHIC EVALUATION : GRADE-II - SATISFACTORY

FILLET WELD TEST: MET REQUIREMENTS

REBAKING INSTRUCTIONS: NOT PERMITTED