

## LIGHT COATED CELLULOSIC TYPE ELECTRODE

**EURO PIPE**

**CODING:** AWS/SFA-5.1 E 6010

### CHARACTERISTICS :

**EURO PIPE** 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, 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** 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 buildings 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	S	P
percent	0.14	0.65	0.30	0.025	0.005

### 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