

Cellulosic electrode**GENERAL DESCRIPTION**

Cellulosic type electrode.
 For root, fill and cap layers.
 Especially recommended for root passes.
 Good radiography quality.

APPLICATIONS

API 5LX X42 - X56
 St 37.0 - St 52.0
 St 37.4 - St 52.4
 StE 210.7 - StE 360.7
 StE 210.7 TM - StE 360.7 TM

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.10	Si : 0.25	Mn : 0.35	P : < 0.02	S : < 0.02
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MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 410 MPa	≥ 480 MPa	≥ 20 %	≥ 47 J (-20°C)

GENERAL INFORMATION

Welding positions	All			
Shielding gas	NA			
Packing	5 Kg in a plastic box			
Polarity	Ac or DC, reverse polarity (electrode positive)			
Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	350	450

Tips & Tricks

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.