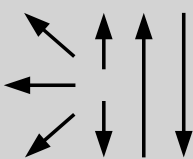


Classifications						
EN ISO 2560-A		EN ISO 2560-B		AWS A5.5		AWS A5.5M
E 42 2 C 2 5		E 4910 P1		E7010-P1		E4910-P1
Characteristics and typical fields of application						
Cellulose covered electrode for vertical down circumferential welds in pipeline constructions. Excellent weldability in root, hot, fill and cap pass welding. Easy slag removal. Particularly suitable for root pass welding (DC ±); also in the vertical up position. CTOD, HIC and HSCC tested.						
Base materials						
API5L: Gr. A, B, X42, X46, X52, X56, X60, Wurzel bis X 70 EN 10208-2: L290MB-, L360MB- and root pass L485MB- und NB-qualities EN 10113-3: S275ML, S355ML, S275NL, S355NL						
Typical analysis of all-weld metal (wt.-%)						
	C		Si		Mn	
wt-%	0.15		0.20		0.60	
Mechanical properties of all-weld metal						
Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	−20 °C	−40 °C
aw	420	530	22	80	55	28
Operating data						
	Polarity: DC (+)	Redrying: Do not redry!	ø (mm)	L mm	Amps A	
			3.2	350	80 – 130	
			4.0	350	120 – 180	
			5.0	350	160 – 220	
Wurzel auch DC (−)						
Approvals						
TÜV (03199), LR, CE						