

## Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.5	AWS A5.5M
E 46 3 C 2 5	E 5510 P1	E8010-P1	E5510-P1

## Characteristics and typical fields of application

Cellulose covered electrode for vertical down circumferential welding of pipelines. Suitable for welding of root pass, hot pass, filler and deck layer; welding of root pass with AC (+/-). CTOD values at -10 °C > 0,25 mm HIC and HSCC testet.

## Base materials

API5L: X 42, X 46, X 52, X 56, X 60, X 65, X 70 and root pass up to X 80  
EN 10208-2: L290MB-, L485MB- and root pass up to L555MB- and NB-qualities;  
EN 10113-3: S355ML, S420ML, S460ML

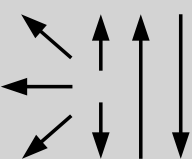
## Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Ni
wt-%	0.16	0.20	0.85	0.20

## Mechanical properties of all-weld metal

Heat-treatment	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	-20 °C	-30 °C
aw	460	550	19	70	60	47

## Operating data

	<b>Polarity:</b> DC ( + )	<b>Redrying:</b> Do not redry!	<b>ø (mm)</b>	<b>L mm</b>	<b>Amps A</b>
	for root pass DC ( - )				
			3.2	350	80 – 130
			4.0	350	140 – 190
			5.0	350	160 – 220

## Approvals

TÜV (03199), ABS, LR, CE