

## Classifications

EN ISO 2560-A	EN ISO 2560-B	AWS A5.1	AWS A5.1M
E 42 2 C 2 5	E 4310 A	E6010	E4310

## Characteristics and typical fields of application

Cellulose covered electrode for vertical down circumferential welds in pipeline constructions. Excellent weldability in root pass welding (DC ±); also in the vertical up position. CTOD, HIC and HSCC tested.

## Base materials

API5L: Gr. A, B, X42, X46, X52, root pass welding up to X 80  
 EN 10208-2: L290MB-, L360MB- root pass welding up to L485MB- und NB-qualities  
 EN 10113-3: S275ML, S355ML, S275NL, S355NL

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

	C	Si	Mn
wt-%	0.14	0.18	0.55

## 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		
				+20 °C	-20 °C	-40 °C
aw	420	510	22	80	50	28
sr	380	510	22	90	55	28

## 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 ( - )		2.5	300	50 – 80
			3.2	350	80 – 130
			4.0	350	120 – 180
	5.0	350	160 – 220		

## Approvals

TÜV (00247), DB (10.132.44), ABS, LR, GL, DNV; CE