

CELWEL 60

CLASSIFICATIONS

AWS A/SFA 5.1 E6010

IDENTIFICATION: Name Printed

CHARACTERISTICS

It gives excellent arc stability, arc smoothness and very easy slag removal. Ideal for root pass and capping runs. It has exceptional all-positional operating characteristics, especially in vertical down (stove-pipe technique), giving X-ray quality welds even for pipe welding.

IDEAL FOR WELDING OF : Cross country pipelines subject to dynamic loading and mechanical restraint Suitable for joining steels like A106Gr A/B, API5LX42-X56

WELD METAL CHEMISTRY, (%)

C - 0.10-0.20 S - 0.015 Max
Mn - 0.4-0.7 P - 0.020 Max. Si - 0.20-0.50

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd)	CVN Impacts, J	
As-welded	480-580	380-460	24-29	-20°C 70-90	-30°C 48-56

APPROVALS :

ABS Gr. 3 **TOYO** E6010
LRA DxVudo, BF, 3YM

CURRENT CONDITIONS: DC (+)

5.0 4.0 3.2 2.5
160-200 120-180 80-140 50-90

WELDING POSITIONS

F, H, V-down, V-up, OH

REDRYING CONDITION

Keep electrodes dry

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	350	350	350	350
Wt. per Tin pack, kg	6	6	6	6
Tin packs / box	3	3	3	3
Net wt per box, kg	18	18	18	18

SPECIAL TESTS

TEST TYPE	REMARKS
HIC & Sulphide SCC (NACE)	Passed



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