

# CELWEL 60S

## CLASSIFICATIONS

**AWS A/SFA 5.1** E6011

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

Medium coated cellulosic type electrode having high melting speed suitable for welding in all position. It has a deep penetrating arc and easily removable slag. The weld is smooth and easily controlled in all positions. The welds are of radiographic quality.

## TYPICAL APPLICATIONS

Pipelines, ship building, storage tanks, pressure vessels, structural fabrication bridges truck frames and maintenance

**CURRENT CONDITIONS :** AC(90V), DC (+)

5.0	4.0	3.2	2.5
160-200	120-180	80-140	60-90

## WELDING POSITIONS

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

**REDRYING CONDITIONS** Keep electrodes dry

## WELD METAL CHEMISTRY (%)

C - 0.08 - 0.16	S - 0.030 max
Mn - 0.31 - 0.60	P - 0.030 max
Si - 0.12 - 0.30	

## 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

## MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L= 4xd)	CVN Impacts, J -30°C
As-welded	450-550	350-480	24-30	50-100



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