

# CELWEL 70G

## CLASSIFICATIONS

**AWSA/SFA 5.5** E7010-G

**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 pipes of API5LX52 to X65

## APPROVALS :

**ABS** E7010-G

**LRA** E7010-G

**TOYO** E7010-G

## CURRENT CONDITIONS: 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

Not required

## WELD METAL CHEMISTRY, (%)

C - 0.12 Max	S - 0.015 Max	Mo - 0.3 - 0.4
Mn - 0.4 - 0.8	P - 0.015 Max	Si - 0.1 - 0.3

## 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	
As-welded	530-595	450-500	22-27	-20°C 40-50	-30°C 30-50
PWHT : 620°C/1 hr.	520-590	450-500	22-2	35-45	30-40

## SPECIAL TESTS

TEST TYPE	REMARKS
HIC & Sulphide stress corrosion cracking (NACE)	Passed



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