

CELWEL 70P

CLASSIFICATIONS

AWSA/SFA 5.5 E7010-P1

IDENTIFICATION : Name printed

CHARACTERISTICS

Gives excellent arc stability. Arc is smooth with very easy slag removal. Totally ideal for root pass and capping runs. Exceptional all position working characteristics, especially in vertical down (i.e stove-pipe technique) giving X-ray quality welds even for pipe welding.

TYPICAL APPLICATIONS

Welding of cross country pipelines subject to dynamic loading & mechanical restraint. Suitable for joining steels like ASTM SA-283 (B,C,D)-A (P.No1), API SLX-52 -X-65 grade pipes. Vertical down & overhead plate welding.

CURRENT CONDITIONS: DC (+)

5.0	4.0	3.2	2.5
160-210	110-160	80-120	50-70

WELDING POSITIONS:

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

REDRYING CONDITIONS

Not required

WELD METAL CHEMISTRY, (%)

C - 0.20 max	Mn - 1.20 max	Si - 0.60 max
S - 0.03 max	P - 0.03 max	Ni - 1.00 max
Cr - 0.30 max	Mo - 0.50 max	V - 0.10 max

PACKING DATA

Dia.,mm	5.0	4.0	3.2	2.5
Length,mm	350	350	350	350
Wt. per carton, kgs	6	6	6	6
Cartons/ box	3	3	3	3
Wt. per box, kgs	18	18	18	18

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd)	CVN Impacts, J -30°C
As-welded	490	415	22 min	27 min



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

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