

CELWEL 80G

CLASSIFICATIONS

AWS A/SFA 5.5 E8010-G

IDENTIFICATION: Name Printed

CHARACTERISTICS

Cellulose coated electrode for vertical-down welding of high strength, large and medium diameter pipelines. Especially recommended for hot passes. Filler and capping the deposit welds are of radiographic quality and meet API code requirements.

IDEAL FOR WELDING OF : High tensile pipe steels like APL 5LX60, and 70. Also suitable for welding thin welded X80 pipes.

APPROVALS

LRA - E8010-G

ABS - E8010-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 - 0.2 Max	S - 0.015 Max	Cr - 0.1-0.3
Mn - 0.60-1.2	P - 0.015 Max	Mo - <0.10
Si - 0.05-0.30	Ni - 0.75-1.0	V - <0.10

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	
				-45°C	-30°C
As-welded	550-670	460-565	19-24	30-50	>54
PWHT : 620°C/1 hr.	550-610	460-535	23-29	40-50	>40

SPECIAL TESTS

TEST TYPE	REMARKS
HIC & Sulphide SCC (NACE)	Passed



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