elektrode jesenice d.o.o.

Classification:

EN 499:	E 38 2 C 21
DIN 1913:	E 43 53 C 4
AWS A-5.1:	E 6010
EN ISO 2560-A:	E 38 2 C 21
EN ISO 2560-B:	≈ E 43 10 A

CELEX

Description and application:

Cellulose coated all positional welding electrode for welding pipelines, cisterns and different containers.
It is suitable for vertical down root pass welding on DC negative polarity and for subsequent passes on DC positive polarity.

Base materials:

API Spec. 5L:	Grade A, B, X42, X46, X52, X56, as the root pass up to API grade X 80
DIN 17172:	Grade StE 210.7, StE 240.7.StE 290.7 (TM), StE 320.7 (TM), StE 360.7 (TM), as well as the root pass up to StE 550.7 (TM)
DIN 17100:	St 37-3, St 52-3
DIN 17155:	St 35.8, St 45.8
	H I, H II

Coating type:

Cellulosic

Welding current:

DC +
DC – (for root beads)

Welding positions:



Redrying temperature:

Not permitted

Typical all weld metal properties:

Chemical composition, wt %:

C	Si	Mn
0.14	0.2	0.8

Mechanical properties:

Yield strength	R_{eL} / $Rp_{0.2}$:	> 390	MPa (N/mm2)
Tensile strength	Rm:	450 - 550	MPa (N/mm2)
Elongation	A5:	> 22	%
Impact energy	KV:	> 70	J (+20°C)
		> 47	J (-20°C)

Approvals:

TÜV

Welding and packing data:

Welding parameters			Packing		
ϕ mm	Length mm	Current A	Weight/ Packet kg	Weight/ carton kg	Weight/ 1000 pcs kg *
2.5	300	50 – 65	4	16	13.4
3.25	350	90 – 120	5	20	26.5
4	350	110 – 140	5	20	40.0
5	350	140 – 200	6.6	26,4	80.5

* approximate data