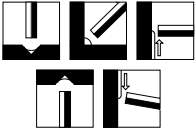


C-10Mo	CELLULOSE COATED ELECTRODE FOR VERTICAL DOWN WELDS IN LARGE DIAMETER CROSS- COUNTRY PIPELINES				DATA SHEET NO. 3			
SPECIFICATION	AWS A5.5		BS EN ISO 2560-B					
CLASSIFICATION	E7010-A1		E4910-1M3					
PRODUCT DESCRIPTION	The electrode contains some 35% of organic materials which in the arc transform into a shielding gas and contributes to a concentrated deep penetrating arc with a fast-freezing slag. The flux is extruded onto a mild steel core wire using only sodium silicates which ensures coating strength.							
WELDING FEATURES OF THE ELECTRODE	The electrode is suited for use on DC+ only and is ideal for both full penetration root runs using a controlled root gap and root face and a stringer bead technique and the capping pass. Slight grinding of the stringer bead with wire brushes prevents lateral inclusions followed by a hot pass that particularly on high stressed and or high carbon steels promotes hydrogen diffusion and thus reduces the probability of hydrogen induced cracking.							
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Cross country pipelines - storage tanks in following materials:</p> <p>Mild Steels: St 360 C-St 510 C, St 34.2, St 37.2, St 46.2, St 37.3, St 46.3, St 52.3. Pressure vessel steels: H1, H11, St 35 KKW, St 41 KKW. High strength steels: St 52, St 35.4, St 5.4, St 52.4, St E210.7-St E415.7, St E290.7TM-S t E415.7TM, St 35.8, St 45.8. API 5LX: X52 - X60. Suitable for root pass - hot pass - filler and cover passes.</p>							
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Mo Fe	
	MIN	-	-	-	-	-	0.40	
	MAX	0.12	0.6	0.4	0.03	0.03	0.65	
	TYPICAL	0.1	0.4	0.2	0.02	0.02	0.50 Bal.	
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS			
	Tensile strength	N/mm ²	490	580				
	0.2% Proof stress	N/mm ²	390	500				
	Elongation on 4d	%	22	28				
	Reduction of Area (RA)	%	-	70				
	Impact energy -30 °C	J	-	60				
WELDING AMPERAGE DC+ ONLY	Ø (mm)	2.6		3.2		4.0		
	MIN	40	80	130				
	MAX	90	130	180				
OTHER DATA	Electrodes that have become damp should be re-dried at 90°C for 30 mins							
RELATED PRODUCTS	Please contact our Technical Department for detail							