



CELLUTHERME-Mo

CODIFICATION: AWS : SFA 5.5 E7010-G

CHARACTERISTICS AND APPLICATIONS:

Cellutherme-Mo is a light coated cellulosic type electrode. This electrode operates with a forceful penetrating arc. Ideally suited for welding in all positions including vertical down. Special feature has been found extremely beneficial for welding of pipes in "Stove Pipe Technique" both for faster welding and greater control on penetration of the root runs. Electrode is designed to yield a weld deposit containing 0.5Mo and therefore is suited for welding C - 0.5Mo steels and is ideal for root passes in pipes.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	S	P	Mo
Percent	0.08	0.45	0.15	0.020	0.025	0.51

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%
511	434	26.0

CURRENT AND PACKING DATA: DC(±)

Size (mm)	: 5x350	4x350	3.15x350	2.5X350
Dia x Length				
Current Range (Amps)	: 150-200	110-150	70-100	40-65
Qty.(Pcs./Carton)	: 55	80	120	200

APPROVALS: Adani Infra

PRECAUTIONS :

1. In order to achieve best results, ensure a good joint fit-up and avoid uneven or excessive gap.
2. Do not use high current, which may lead to high spatter loss.