

## CELLUTHERME

**CODIFICATION:**                      AWS :    SFA 5.1 E6010  
     IS :    814 EC4310X

### CHARACTERISTICS AND APPLICATIONS:

Cellutherme is a light coated cellulosic type electrode. Ideally suited for welding in all positions including vertical down. The weld metal possesses good mechanical properties. Ideal for stove pipe technique and faster welding. Welds are of radiographic quality. Typical applications include welding of pipes, tubes, ducts, etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P
Percent	: 0.07	0.50	0.20	0.016	0.018

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at (Joules)	
			Minus 20°C	Minus 30°C
480	400	27.0	70	50

### CURRENT AND PACKING DATA: DC(±)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 150-200	110-160	70-100	40-65
Qty.(Pcs./Carton)	: 55	80	120	200

**APPROVALS:** EIL, PDIL

### 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.