

<b>International standards</b>	EN 499	E46 3 C 25
	AWS A 5.1	E8010-G

**Approvals** ---

**Typical applications and characteristics** Cellulose coated electrode for vertical down welding of high strength large diameter pipelines. Especially recommended for hot passes, Filler and covers.  
Highly economical compared with vertical-up welding.

Excellent weldability also on soiled surfaces containing impurities from corrosion, paint residues, priming coats, etc.

High efficiency as compared to vertical up welding.

**Operating temperature** From -30° C up to +450° C

**Base materials** S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH  
L210 – L415NB, L290MB – L415MB, P355T1, P235T2 – P355T2, P235G1TH, P255G1TH.  
Root pass to L555MB.

API 5 LX, X42 – X60, Root pass to X 80.

**Mechanical properties of all-weld metal**

( typical values )

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{eL}$ N/mm <sup>2</sup>	Elongation $A_5$ %	Impact strength ISO – V J - 30°C
560	> 460	20	> 47

**Weld metal analysis**  
(typical, wt. %)

C	Si	Mn	Ni	Mo
0,1	0,2	0,5	0,7	0,3

**Current** = + for root pass welding -

**Welding positions** PA, PB, PC, PG, PE, PF, PG

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
3.2 x 350	80 – 130				5.0	20.0
4.0 x 350	120 – 180				5.0	20.0
5,0 x 350	160 – 210				5,0	20,0