

<b>International standards</b>	EN ISO 2560-A	E38 3 C 21
	AWS A 5.1	E6010

**Approvals** TÜV, DB, CE

**Typical applications and characteristics** Cellulose medium coated electrode for joining and repairing pipelines, especially in vertical down position. Due to its high penetration, CARBO CEL 70 is particularly suitable for welding root layers and built up passes in the vertical down direction. Excellent weldability also on soiled surfaces containing impurities from corrosion, paint residues, priming coats, etc. High efficiency as compared to vertical up welding.

**Application fields** Shipbuilding, storage vessels, boilers, pipeline constructions

**Operating temperature** From -30° C up to +350° C

**Base materials** S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, S235JRS1 – S235J2S2  
L210 – L360NB, L290MB – L360MB, P355T1, P235T2 – P355T2, P235G1TH, P255G1TH, X42-X52.  
Root pass L555NB, L555MB.

<b>Mechanical properties of all-weld metal</b> ( typical values )	<b>Tensile strength <math>R_m</math></b> N/mm <sup>2</sup>	<b>Yield strength <math>R_{eL}</math></b> N/mm <sup>2</sup>	<b>Elongation <math>A_5</math></b> %	<b>Impact strength</b> ISO – V J -30°C
	min. 380	470 - 540	min. 22	min. 47 J

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Si</b>	<b>Mn</b>
	0,12	0,2	0,6

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

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

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	Kg/carton
2,5 x 350	40 – 80	530	1060	16,2	8,5	17,0
3,2 x 350	60 – 110	330	660	26,5	9,0	18,0
4,0 x 350	90 – 140	230	460	40,1	9,5	19,0
5,0 x 350	120 – 180	160	320	60,8	10,0	20,0

Rev. 001