

Cellulosic Coated Electrode for Mild Steels

Classification

EN ISO 2560-A : E 46 3 Z C 21
AWS A5.5 : E8010-G

General Description

AS S-8010 Ni is an easy to strike cellulosic coated electrode that provide the highest impact notch toughness values among our range of cellulosic coated electrodes. Due to its higher mechanical properties, it is useful for the root and deposit pass of large diameter pipe connections having high yield strength. In all positions, it enables notch-free, smooth weld beads of high penetration. It enables excellent molten pool control due to easily-removable, low-volume slag.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Ni
0.10	0.30	1.10	0.20

Mechanical Properties, Typical, All Weld Metal

Yield Strength	: 480 N/mm ²
Tensile Strength	: 600 N/mm ²
Elongation (L=5d)	: 24 %
Impact (ISO-V)	: 60 J (-20°C)
	50 J (-30°C)

Approvals

GOST, SEPRO, TSE

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (+)

Diameter [mm]	Length [mm]	Current [A]			Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
		[Root Pass]	[Hot Pass]	[Cover Pass]			
2.50	350	40 - 80	-	-	1540	6.2 / 400	5
3.25	350	80 - 100	90 - 120	80 - 100	2600	5.7 / 220	5
4.00	350	110 - 130	120 - 140	110 - 130	3910	5.5 / 140	5
5.00	350	-	140 - 170	140 - 160	6060	5.8 / 95	5



1G/PA



2F/PB



2G/PC



4G/PE



3G/PF



3G/PG



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Applications and Materials to be Welded

AS S-8010 Ni can be used in the site welding of pipe and pipelines made particularly from low alloyed high strength steels. Site welding of pipe steels in the 5LX60 - 5LX70 range is a good example to application areas. AS S-8010 Ni is an ideal electrode for welding in vertical downwards position.

	<u>DIN</u>	<u>EN</u>
Pipe Materials	StE 290-7 - StE 415-7 StE 290-7 TM - StE 415-7 TM X42, X46, X52, X56, X60, X70 (API 5LX)	L290NB - L415NB L290MB - L360MB –
Ship Plates	A, B, C, D, E	–