Product Data Sheet
E 'Manual metal-arc welding'

CITOFLEX

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
P-O Oskarsson	Tero Tolonen	Tony Dray	EN005989	EN004983	2013-01-18	1 (2)

REASON FOR ISSUE

Classification updated

GENERAL

Cellulosic-coated electrode designed for welding of pipes and pipelines in all positions using conventional and stovepipe techniques .

Polarity: DC+

Alloy Type: CARBON MANGANESE
Coating Type: Cellulosic

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.1	E6010
EN ISO 2560-A	E 38 3 C 21

APPROVALS

CE	EN 13479
VdTÜV	07122

APPROVALS (SPECIFIC)

RINA	3

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.060	0.150
Si	0.10	0.30
Mn	0.30	0.60
P		0.030
S		0.030
Cr		0.20
Ni		0.30
Mo		0.2
V		0.05
Nb		0.05
Cu		0.3

MECHANICAL PROPERTIES OF WELD METAL

	ISO		AWS
	As welded		As welded
Properties	**Min**	**Max**	**Min**
Rp0.2 (MPa)			330
ReL (MPa)	380		
Rm (MPa)	470	560	430
A4 (%)			22
A5 (%)	22		
Charpy V at -30°C (J)	47		27

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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A) Min	Current (A) Max	W	η	N	B	H	T	U	Welding Positions
2.5 x 300	40	80	1.4	97	0.66	106	0.7	47	34	1,2,3,4,5,6,7,8,9
3.2 x 350	60	110	2.7	94	0.64	58	1.0	60	37	1,2,3,4,5,6,7,8,9
4.0 x 350	90	140	4.2	96	0.65	37	1.3	73	36	1,2,3,4,5,6,7,8,9
5.0 x 350	110	170	6.4	98	0.67	23	1.8	87	34	1,2,3,4,5,6,7,8,9

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)