

OK 22.47P

SMAW

Type Cellulosic

E 46 3 1Ni C 21

Description

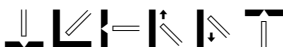
Cellulosic-coated electrode designed for the site welding of pipe and pipelines in API 5L X60 and X70 in all positions, using conventional stovepipe techniques. DC only.

Recovery

90%

Welding current

DC+



Classifications

EN 499	E 46 3 1Ni C 21
SFA/AWS A5.5	E8010-G
BS 639 (1986)	E 51 32 C (10)

Typical all weld metal composition, %

C	Si	Mn	Ni	Mo
0.08	0.2	0.6	0.8	0.3

Typical mech. properties all weld metal

Yield stress, MPa	513
Tensile strength, MPa	600
Elongation, %	24

Charpy V

Test temps, °C	Impact values, J
-20	80
-30	70

Approvals

LR 3, 3Y

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
3.2	350	65-120	30	0.62	61	0.68	86
4.0	350	90-180	29	0.68	37	1.15	84
5.0	350	150-240	29	0.68	24	1.55	97