

OK 22.48P

SMAW

Type

Cellulosic

E 50 2 1NiMo C 21

Description

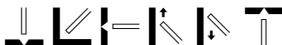
Cellulosic-coated electrode designed for the site welding of pipe and pipelines.

Recovery

90%

Welding current

DC+



Classifications

EN 499

SFA/AWS A5.5

E 50 2 1NiMo C 21

E9010-G

Typical all weld metal composition, %

C	Si	Mn	Ni	Mo	Cu
0.1	0.2	1.0	0.8	0.5	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	560
Tensile strength, MPa	700
Elongation, %	22

Charpy V

Test temps, °C	Impact values, J
-20	60

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	32	0.67	56	0.82	79
4.0	350	90-180	34	0.63	39	1.17	78
5.0	350	150-240	32	0.67	24	1.67	90