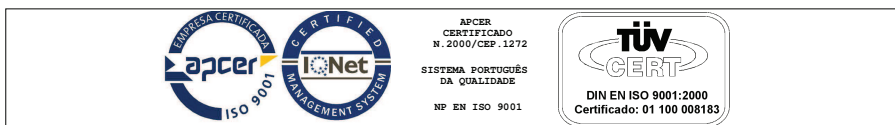


	TECHNICAL DESCRIPTION	FT-DT.05.08
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CERTIFIED COMPANY:



CLASSIFICATION:

AWS A5.1: E 6010
EN ISO 2560-A-E 35 2 C 2 5

DESCRIPTION:

Cellulose type electrode, indicated for welding of pipe lines in the vertical-downward position. Application in root passes. Good radiography quality.

SUITABLE FOR:

St 37.0 to St 52.0	StE 210.7 TM to StE 360.7 TM		
St 37.4 to St 52.4	API 5 LX: X 42 to X56		
StE 210.7 to StE 360.7			

TYPICAL CHARACTERISTICS OF ALL-WELD METAL:

Chemical Analysis (%):

C	Si	Mn	P	S			
0,10	0,25	0,35	< 0,02	< 0,02			

Mechanical Properties:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation 5d (%)	Charpy V (J)	
			- 29 °C	- 20 °C
>410	>480	>20	>27	>47

PRODUCT INFORMATION:

WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type (Pole +)	Pieces /Packet (Un)	Weight /Packet (kg)
2,5	350	70-90	AC/DC	300	5,0
3,2	350	90-140	AC/DC	190	5,0
4,0	350	130-180	AC/DC	120	5,0
5,0	450	160-230	AC/DC	85	7,2

WELDING POSITIONS:

