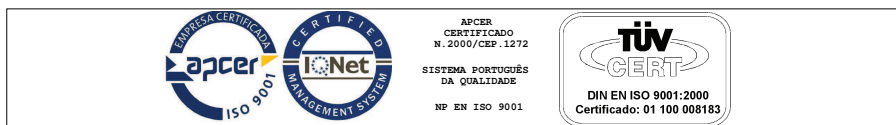


	<b>TECHNICAL DESCRIPTION</b>	FT-DT.41.08
	<b>EUROTROD CN 23</b>	PAGE 11/11

**CERTIFIED COMPANY:**



**CLASSIFICATION:**

**AWS A5.5: E 7010-A1, E 7010-G  
EN ISO 2560-A-E 42 2 Mo 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	Mo		
0,10	0,25	0,35	< 0,02	< 0,02	0,40		

**Mechanical Properties:**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation 5d (%)	Charpy V (J)	
			- 29 °C	- 20 °C
>410	>520	>22	>27	> 47

**PRODUCT INFORMATION:**

WELDING PARAMETERS				PACKING	
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	350	160 – 230	AC/DC	75	5,0

**WELDING POSITIONS:**

