

CARBO CEL 80

International standards	EN ISO 2560-A	E 46 3 1 Ni C 25						
	AWS A 5.5	E8010-P1						
Approvals								
Typical applications and characteristics	Cellulose-coated electrode for vertical-down welding for high strength large diameter pipelines. Highly economical compared with convention vertical-up welding. Especially recommended for hot pass filler and cove layers. Practice has shown a temperature of 150°C (300°F) to be sufficient for preheating purposes. Wall thickness over 20 mm (3/4 incl should in any case be preheated, regardless of the carbon level, and the preheating temperature should be raised to about 200°C (390°F). Usability in sour gas involving applications (acc. Hic test NACE TM-0284							
Operating temperature	From -30° C up to +450	°C						
Base materials	L290NB-L415NB, L290 X42-X70	MB-L415MB, -L485MB, S	235JRS1-S235J4S,					

Mechanical properties of all-weld metal	Tensile strength R _m N/mm²		Yield strength R _{eL} N/mm ²		Elongation A₅ %	Impact strength ISO – V J - 30°C	
(typical values)	560-650		> 460		> 20	> 47	
Weld metal analysis (typical, wt. %)	C 0,14	Si 0,2	Mn 0,9	Ni 0,6			
Current	= +						
Welding positions	PA, PB, PC, PD, PE, PF, PG						

Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
40 - 80	530	1060	16,2	8,5	17,0
60 – 110	330	660	26,5	9,0	18,0
90 – 140	230	460	40,1	9,5	19,0
120 – 180	160	320	60,8	10,0	20,0
	Amperage (A) 40 - 80 60 - 110 90 - 140 120 - 180	Amperage (A)Pcs./packet40 - 8053060 - 11033090 - 140230120 - 180160	Amperage (A)Pcs./packetPcs./carton40 - 80530106060 - 11033066090 - 140230460120 - 180160320	Amperage (A)Pcs./packetPcs./cartonkg/100040 - 80530106016,260 - 11033066026,590 - 14023046040,1120 - 18016032060,8	Amperage (A)Pcs./packetPcs./cartonkg/1000kg/packet40 - 80530106016,28,560 - 11033066026,59,090 - 14023046040,19,5120 - 18016032060,810,0

Rev. 001/12

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.