

RATNA 8010 P1

Cellulosic coated electrode for high strength pipe welding

CLASSIFICATION : AWS/SFA-5.5: E 8010 P1

CHARACTERISTICS : An all position, cellulose coating type electrode that show an increase in deposition rates with both welding techniques. Its gives good penetration, very low spatter and smooth arc, easily removable slag.

APPLICATION :

1. Welding of high strength pipeline steels.

2. Welding suitable for use in root, filling and capping runs in API 5LX60 to 5LX70 grade line pipe.

RE-DRY CONDITION : Not recommended

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S&P	Ni	Cr	Mo	V
0.20 max.	1.20 Max.	0.60 Max.	0.030 Max	1.00 Max.	0.30 Max	0.50 Max.	0.10 Max.

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
460 Min.	550 min.	19 min.	Minus 30 ⁰ C : 50-80 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+) Amps	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	50-80	270	1080
3.15/ 3.20 X 350	1/ 8" X 14"	80-130	160	640
4.00 X 350	5/ 32" X 14"	110-160	105	420

Customer packing on request.