

# Cellulosic Electrodes







# AMA 1048 P

**Standards:** AWS/ASME SFA - 5.5 E 7010 - G

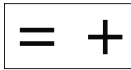
**Application / Properties:** Cellulosic electrode for welding of large diameter and high strength pipes using the vertical down technique. It is suitable for welding root passes. hot passes. filler and cover passes.

**Weld metal analysis in % (typical)**

C	Mn	Si	Mo	S	P
0.11	0.40	0.1	0.27	<0.02	<0.02

**Mechanical Properties of all-weld metal :**  
(single values are typical values)

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A4 (%)	ISO-V Impact energy (j) - 30 °C
>400	>500	>22	>27



Amperage:		
3.25 Ø	4.0Ø	5.0Ø
80-120	110-140	140-200



**Material:**

Unalloyed Structural steels-----St 37, St 44, St 52-3  
 Boiler plates-----H I, H II, H III  
 Pipe steels-----StE 210.7(St 34.7), StE240.7(St 38.7), StE290.7(St 43.7), StE 320.7(St 47.7), StE 360.7(St 53.7)  
 API steels-----X42, X45, X52, X60

Redrying : If necessary 1 h at 100-120°C.



# AMA 1049 P

**Standards:** AWS/ASME SFA - 5.5 E 8010 - G

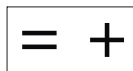
**Application / Properties:** Cellulosic electrode for welding of large diameter and high strength pipes using the vertical down technique. It is suitable for welding root passes. hot passes. filler and cover passes.

**Weld metal analysis in % (typical)**

C	Mn	Si	Ni	Mo	S	P
0.12	0.7	0.1	0.65	0.26	<0.02	<0.02

**Mechanical Properties of all-weld metal :**  
(single values are typical values)

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A4 (%)	ISO-V Impact energy (j) - 30 °C
>460	>550	>19	>27



Amperage:		
3.25 Ø	4.0Ø	5.0Ø
80-120	110-140	140-200



**Material:**

Unalloyed Structural steels-----St 37, St 44, St 52-3  
 Boiler plates-----H I, H II, H III  
 Pipe steels-----StE 210.7(St 34.7), StE240.7(St 38.7),  
 StE290.7(St 43.7), StE 320.7(St 47.7), 360.7(St 53.7),  
 StE415.7(St60.7)  
 API steels-----X42, X45, X52, X60, X65

Redrying : If necessary 1 h at 100-120°C.



# AMA 1707 NP

**Standards:** AWS/ASME SFA - 5.5 E 7010 - A1

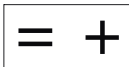
**Application / Properties:** Cellulosic electrode for welding of pipelines using the vertical down technique. It is suitable for welding root passes, hot passes, filler and cover passes.

### Weld metal analysis in % (typical)

C	Mn	Si	Mo	S	P
0.10	0.40	0.15	0.50	<0.02	<0.02

### Mechanical Properties of all-weld metal : (single values are typical values)

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation A4 (%)	ISO-V Impact energy (j) + 20 °C
>400	500-600	>22	>80



Amperage:		
3.25 Ø	4.0Ø	5.0Ø
80-120	110-140	140-200



### Material:

Unalloyed Structural steels-----St 37, St 44, St 52-3  
Boiler plates-----H II  
Pipe steels-----St 45, St 45.4, St 45.8, StE 210.7 (St 34.7), StE240.7 (St 38.7), StE290.7 (St 43.7), StE 320.7 (St 47.7), StE 360.7 (St 53.7), StE 415.7 (St 60.7)  
API steels-----X42, X45, X52, X60

Redrying : If necessary 1 h at 100-120°C.