



# Selectarc C8010

Cellulose Electrode  
Very High resistance

## Classification

AWS A5.5 : E8010-G

ISO 2560-A : E 46 4 1Ni C 2 5

## Description & Applications

Cellulose coated electrode specially for pipe welding in vertical downhand position. Very thin slag and easy to remove. Particularly recommended for root passes. Very good behaviour on bad prepared joints (rust, painting...).

**Main applications:** Used for metal constructions, for piping systems, tanks, blacksmithing, craft works.

### Base materials

#### Construction steels for general use, Tube steels, Ship steels:

EN	S275JR – S355	L415NB, L415MB, L485NB, L485MB
ASTM	A570 gr 50	
API SPEC 5LX	X56 – X70	

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	V	P	S
0.12	0.2	0.8	<0.30	0.8	<0.20	<0.20	<0.10	<0.025	<0.025

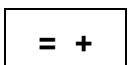
## All Weld Metal Mechanical Properties

R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> ( % )	KV ( J )
510	590	24	-20°C 75

## Welding Current & Instructions

Electrode	ØxL ( mm )	3,2x350	4,0x350	5,0x350
Current	( A )	110	150	190

Direct current ( = - ) pole on the electrode in the root pass, then + pole for the following passes.



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