

JACKSUN XCEL-10

HIGH CELLULOSIC ELECTRODE FOR PIPE WELDING

BASIC ALLOY: C, FE, MN
AWS/SFA-5.1:E6010
EN ISO 2560-A E 42 3 C 25

KEY FEATURES:

A medium coated, cellulosic type electrode with forceful and spray arc, ensures deep penetration in all position including vertical down hand. Weld metal is of radiographic quality coupled with easy slag detachability, weld metal is ductile

APPLICATIONS

- Suitable for tank & vessels.
- General fabrication
- Vehicles, Storage tanks
- Railway wagons and machinery.
- Ship construction, light structural steel works

RE-DRY CONDITIONS:

- Not recommended

CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.20 max.	0.40-0.80	0.30 Max	0.030 Max	0.030 Max

MECHANICAL PROPERTIES

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
330-450	430-560	22-30	- 3C : 50-80 J

WELDING POSITION

1G/1F



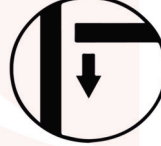
2G/2F



3G UP



3G DOWN



4G



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+/ AC) Amps	Kg /pkt.	Kg/Case
2.50/ 2.40	3/ 32"	50-80	5	20
3.15/ 3.20	1/ 8"	90-130	5	20
4.00	5/ 32"	110-160	5	20