

# CL-100

For welding of building and pipes

AWS A5.1 E6010  
KS D 7004 E4311  
JIS Z3211 E4311

## Applications

Welding of pipes, buildings, storage tanks and general structures.

## Characteristics

CL-100 is a cellulose type electrode for the vertical down welding of cross-country pipelines made particularly for root bead, hot pass, filler and capping passes. In addition light slag formation, stable arc, good penetration and easy puddle controlling make this electrode an excellent choice for pipe welding.

## Notes on usage

- (1) Pay attention not to use the currents exceeding the recommended currents, because the proper currents for cellulose type electrodes are lower in comparison with those for ordinary type electrodes.
- (2) As this electrode is prone to absorb moisture, store it with care.
- (3) Dry the electrodes at 70~100°C for 30~60 minutes before use.

## Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
0.12	0.48	0.22	0.014	0.011

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %	IV J (kgf-m)
			-30°C
420(43)	490(50)	30	50(5)

## Size & recommended current range (AC or DC+)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0	
	L (mm)	300	350	350	350	400
Amp.	F	50-75	70-110	110-155	155-200	200-245
	V&OH	30-70	55-105	90-140	120-180	-

• Approval : ABS

• Tip Color : Gray