

CL-101

For welding of pipes and general structures

AWS A5.1 E6011
KS D 7004 E4311
JIS Z3211 E4311

Applications

Welding of pipes, buildings and thin steel sheets.

Characteristics

CL-101 is a cellulose type electrode for mild steel designed for AC power use. The strong arc force and rapid solidifications of metal facilitate welding in the vertical and overhead positions. The arc can be directed easily in any position with light slag formation and minimum spatter loss.

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
0.10	0.45	0.20	0.015	0.012

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	IV J (kgf-m)
			-30°C
410(42)	470(48)	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 : Black