

	<b>TECNHICAL DATA SHEET</b>	FT-DQ01
	<b>EUROTROD CN 10</b>	PÁG. 1/1

• **CLASSIFICATION:**

AWS A5.1: E 6010  
EN ISO 2560-A-E 35 2 C 2 1

**CERTIFIED COMPANY:**



Management System  
ISO 9001:2015

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ID 1100008183



**DESCRIPTION:**

Cellulose type electrode, indicated for welding of pipe lines in the vertical-downward position. Application in root passes. Good radiography quality.

**SUITABLE FOR:**

St 37.0 to St 52.0	StE 210.7 TM to StE 360.7 TM		
St 37.4 to St 52.4	API 5 LX: X 42 to X56		
StE 210.7 to StE 360.7			

**TYPICAL CHARACTERISTICS OF ALL-WELD METAL:**

**Chemical Analysis (%):**

C	Si	Mn	P	S			
0,10	0,25	0,35	<0,02	<0,02			

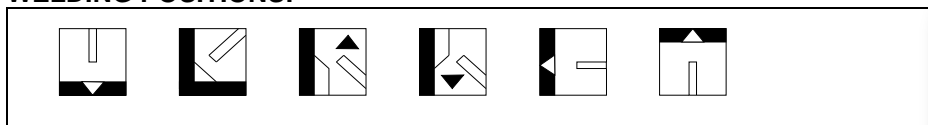
**Mechanical Properties:**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation 5d (%)	Charpy V (J)	
			- 30 °C	- 20 °C
>410	>480	>20	>27	>47

**PRODUCT INFORMATION:**

WELDING PARAMETERS				PACKING DATA	
Diameter (mm)	Length (mm)	Recommended Current (A)	Current Type Pole +/- <sup>1</sup>	Pieces /Packet (Un)	Weight /Packet (kg)
2,5	350	70-90	AC/DC	300	5,0
3,2	350	90-140	AC/DC	190	5,0
4,0	350	130-180	AC/DC	120	5,0
5,0	350	160-230	AC/DC	82	5,5

**WELDING POSITIONS:**



<sup>1</sup> Negative polarity for root passes



Welding Technology

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