



# Product Data Sheet

# Nufive

E 'Manual metal-arc welding'  
ESAB S.A. Ind. E Comércio Brazil

Prepared by P-O Oskarsson	Qualified by Christos Skodras	Approved by Karin Ivarsson	Reg no EN005858	Cancelling EN002012	Reg date 2012-06-27	Page 1 (2)
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## REASON FOR ISSUE

Diameter 5.0mm deleted.

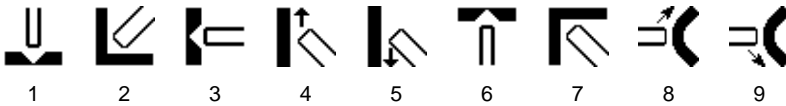
## GENERAL

Cellulosic-coated electrode design for sitewelding of pipe and pipelines in all positions using conventional stovepipe techniques, DC+ / AC.

**Min AC OCV:** 65  
**Polarity:** AC, DC+-

**Alloy Type:** CMn  
**Coating Type:** Cellulosic

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN 499	E 38 2 C 11
SFA/AWS A5.1	E6011
BS 639 (1986)	E 43 32 C (14)
EN ISO 2560-A	E 38 2 C 11

## APPROVALS

Not applicable

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C	0.03	0.13
Si	0.05	0.25
Mn	0.25	0.55
P		0.020
S		0.020

## MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS		Typ
	Min	Max	Min	Max	
As welded					
Rp0.2 (MPa)			330	410	
ReL (MPa)	380				
Rm (MPa)	470	560	415		495
A4-A5 (%)	20		22		26
Charpy V at -20°C (J)	47		47		70
Charpy V at -29°C (J)			27		40

**Comments:**



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## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	$\eta$	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	40	75	1.6	77.9	0.79	100	0.7	54	34	1,2,3,4,5,6,7,8,9
3.2 x 350	60	125	2.7	68.6	0.69	67	1.0	57	25	1,2,3,4,5,6,7,8,9
4.0 x 350	80	180	4.0	61.2	0.63	50	1.2	58	30	1,2,3,4,5,6,7,8,9

**W** = Weight (kg / 100 electrodes)

**$\eta$**  = Efficiency (g weld metal x 100 / g core wire)

**N** = Effective value (kg weld metal / kg electrodes)

**B** = Changes (number of electrodes / kg weld metal)

**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)

**T** = Fusion time at 90% of max current (s / electrode)

**U** = Arc voltage (V)