

7010

CATEGORY SMAW Stick Electrodes

TYPE Cellulosic coated electrode for SMAW welding

APPLICATIONS 7010 A 1 is our cellulosic electrode for the vertical down welding of hot and filler passes as well as for capping of higher strength pipe steels particularly for API grades X56X60 or DIN grades StE 360.7 TM/StE 385.7 TM. In general the electrode is suited for root passes, however, in most cases even on higher strength pipes our 6010 is preferred.

PROPERTIES Besides the excellent weld metal toughness properties it offers easy operation, and a concentrated intensive arc with deep penetration characteristics in order to ensure sound joint welds with good X-ray quality..

CLASSIFICATION

AWS	A 5.5: E 7010-A1
EN ISO	2560-A: E 42 3 MoC 21 499: E 42 2 Mo C 21
DIN	8575:

SUITABLE FOR St:37.2, 44.2, 37.3, 52.3, H1, H11, 210.7, 290.7, 415.7 TM, 52.0, 37.4, 52.4, 35.8, 45.8, X42, X60, A-E StE

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo
0.10	0.4	0.15	-	-	0.50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	>420	510-590	>22	>47			

AW: as welded

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		kg / can	Packing	
	Length (mm)	Current (A)		kg / 6pack	kg / 1000
2,5	350	50-90			
3,2	350	80-130			
4,0	350	120-180			
5.0	350	160-210			

REDRYING TEMPERATURE Not needed