

# ES 7010

Type Cellulosic

SMAW

E7010-G

**ESWECO**  
*The Art of Welding*

## Description

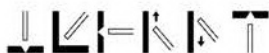
Cellulosic-coated electrode designed for the site welding of pipe and pipelines in API 5L X52 and X56 in all positions, using conventional stovepipe techniques. DC only.

## Recovery

90%

## Current

DC+



## Classifications

SFA/AWS A5.5	E7010-G
EN 499	E 42 2 C 21
BS 639 (1986)	E 51 43 C (10)

## Typical all weld metal composition, %

C	Si	Mn	Ni	Mo
0.1	0.14	0.5	0.4	0.3

## Typical mech. Properties all weld metal

Yield stress, MPa	476
Tensile strength, MPa	544
Elongation, %	25

## Charpy V

Test temps, °C	Impact values, J
-20	60

## Approvals

ABS 3Y

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	350	40-80	30
3.2	350	65-120	31
4.0	350	90-180	30.5
5.0	350	150-240	28.6