

ES 7010-A1

SMAW

ESWECO
The Art of Welding

Type Cellulosic

E7010-A1

Description

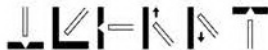
Cellulosic-coated electrode designed for the site welding of pipe and pipelines in API 5L X52 and X56 in all positions, using conventional stovepipe techniques. DC only.

Recovery

90%

Current

DC+



Classifications

SFA/AWS A5.5	E7010-A1
EN 499	E 42 2 Mo C 21
BS 639 (1986)	E 51 43 C (10)

Typical all weld metal composition, %

C	Si	Mn	Mo
0.07	0.1	0.3	0.5

Typical mech. Properties all weld metal

Yield stress, MPa	460
Tensile strength, MPa	540
Elongation, %	23

Charpy V

Test temps, °C	Impact values, J
-20	65

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
3.2	350	65-120	27.6
4.0	350	90-180	29
5.0	350	150-240	27.5