

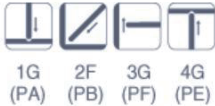
## E7010

AWS A5.1 E7010

### Description:

E7010 is an all-position cellulosic electrode that is especially suited for welding high strength pipe (API grades X46, X52 and X56). It produces consistent, deep penetration required to maintain a proper keyhole when vertical-down welding in open root pipe joints.

### Welding Position:



### Diameters:

2.5mm, 3.2mm, 4.0mm, 5.0mm.

### Typical Mechanical Properties:

Tensile strength(MPa):	633
Yield strength(MPa):	520
Elongation (%):	28
Impact values( $\geq 47$ )/(-30°C):	60

### Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0,09	0,45	0,02	0,01	0,23	0,20	0,035	0,20	0,004

### Welding Current: (AC/DC+)

Diameter(mm)		2,5	3,2	4,0	5,0
Current/A	F/H	60-90	70-110	110-150	150-200
Current/A	V/OH	50-80	60-100	100-140	140-180

### Note:

1. The electrode get damp easily, please stock it in dry environment.
2. Please bake the electrodes 60 minutes in 70-90°C before using if they are becoming damp.
3. Remove the rust, oil, water from the work piece before welding