

Sureweld 710P

Sureweld 710P is an all-position cellulosic electrode that is especially suited for welding high strength pipe. It produces the consistent, deep penetration required to maintain a proper keyhole when vertical-down welding in open root pipe joints. X-ray quality joints can be produced with Sureweld 710P using flat, horizontal, overhead, vertical-up and vertical-down welding procedures. Sureweld 710P is recommended for welding API grades X46, X52, and X56 pipe. It may also be used for welding root passes in higher grade pipe in some circumstances.

Specifications	
Classifications	ASME SFA 5.5 : E7010-P1 AWS A5.5 : E7010-P1
Approvals	Conforms to E7010-G
Industry	Industrial and General Fabrication Pipeline

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	Low alloyed (0.5 % Ni, 0.25 % Mo)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	500 MPa (73 ksi)	593 MPa (86 ksi)	22 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-30 °C (-22 °F)	39 J (29 ft-lb)

Typical Weld Metal Analysis %						
C	Mn	Si	S	P	Ni	Mo
0.10	0.30	0.20	0.02	0.01	0.50	0.24

Deposition Data			
Diameter	Current	Deposition Efficiency (%)	Deposition Rate @ 90% I max
0.0 x 450.0 mm			0.0 kg/h (0.0 lbs/h)
2.4 x 304.8 mm (3/32 x 12.0 in.)	40-75 A	72 %	0.7 kg/h (1.5 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	80-140 A	76.3 %	0.9 kg/h (2.0 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	130-175 A	73.6 %	1.3 kg/h (2.9 lbs/h)
4.8 x 350.0 mm (3/16 x 13.8 in.)	150-210 A	74.9 %	1.5 kg/h (3.3 lbs/h)