

Pipeweld 7010 Plus

Cellulosic coated electrode for welding of low alloy steel pipes. Designed for vertical down welding, the deep penetrating arc provides good performance. Suitable for welding pipe steel types API 5L X52 to X60.

Specifications	
Classifications	SFA/AWS A5.5 : E7010-P1 EN ISO 2560-A : E 42 2 Z C 21
Approvals	FBTS : E 7010-P1

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

Welding Current	DC+
Alloy Type	Low alloyed (0.3 % Ni, 0.2 % Mo)
Coating Type	Cellulosic covering

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	480 MPa	570 MPa	22 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
AWS		
As Welded	-30 °C	45 J
As Welded	-20 °C	55 J

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Mo
0.09	0.46	0.12	0.34	0.24

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
3.2 x 350.0 mm	65-120 A	31 V	58 %	90 sec	0.62 kg/h
4.0 x 350.0 mm	90-180 A	30.5 V	59 %	93 sec	0.93 kg/h
5.0 x 350.0 mm	150-240 A	28.6 V	67 %	100 sec	1.47 kg/h