

Brand Name & Classification

AWS/ASME SFA-5.5: E7010 G
EN499: E 38 2 C 25

Properties

Electrode for welding of pipe lines (girth seams) using vertical down technique. It is suitable for welding root passes, hot passes, filler and cover passes. It is also suitable for root passes on high strength pipe steels

Application

Pipe steels: St 37.0 – St 44.0 – St 52.0
St 37.4 – St 44.4 – St 52.4
StE 210.7 – StE 360.7
StE 210.7 TM – StE 415.7 TM
API 5 LX steels: X42 to X60

**Weld Metal Analysis
Typical values**

Carbon: 0.10
Silicon: 0.20
Manganese: 0.40
Molybdenum: 0.40

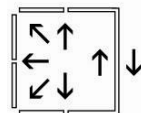
Typical Mechanical properties

Yield Strength	Tensile Strength	Elongation	Impact Strength
>420 N/MM2	500 – 640 N/mm2	> 26 %	90 J at +20 c 50 J at -20 c

Welding Current & Positions

= - RP

= + CP



Currents

Dia	Length	Amperes
2.6	350	60-80
3.2	350	80-120
4.0	350	110-150
5.0	350	140-200