

S-7010.A1

Type : Cellulesic

Conformances

AWS A5.5/ ASME SFA5.5 E7010-A1

EN ISO 2560-A-E42 0 Mo C 1 5

ABS AWS A5.5 E7010-A1

LR 2Y

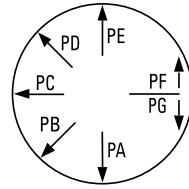
Applications

- Low alloy steel (0.5% Mo)
- Pipe line

Features

- Good X-ray performance
- Good mechanical properties

Welding Position



Current

DC ±

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

| Diameter mm (in) | Length mm (in) | Standard | |
|---------------------|-------------------|----------------------|-----------------------|
| | | packet 5kg(11lbs) | carton 20kg(44lbs) |
| 2.6 (3/32) | 350 (14) | | √ |
| 3.2 (1/8) | 350 (14) | | √ |
| 4.0 (5/32) | 400 (16) | | √ |
| 5.0 (3/16) | 400 (16) | | √ |

Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Mo |
|------|------|------|-------|-------|------|
| 0.09 | 0.12 | 0.32 | 0.015 | 0.015 | 0.61 |

Typical Mechanical Properties of All-Weld Metal

| YS MPa(lbs/in ²) | TS MPa(lbs/in ²) | EL (%) | Heat Treatment |
|---------------------------------|---------------------------------|-----------|--------------------------|
| 552 (80,000) | 575 (83,400) | 28.4 | 620°C(1148°F) X 1hr. S.R |

Typical Welding Parameters / Amp.(A)

| Diameter mm (in) | 2.6 (3/32) | 3.2 (1/8) | 4.0 (5/32) | 5.0 (3/16) |
|------------------|------------|-----------|------------|------------|
| Length mm (in) | 300 (12) | 350 (14) | 350 (14) | 350 (14) |
| F & HF | 55~80 | 80~120 | 120~160 | 160~210 |
| V-up, OH | 50~70 | 70~110 | 110~150 | - |