

S-7010.P1

Type : Cellulosic

Conformances

AWS A5.5/ ASME SFA5.1 E7010-P1
CWB CSA W48 E4910-P1

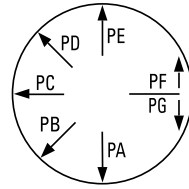
Applications

- Root pass welding for Pipe line
- General fabrication
- Vertical down welding

Features

- Standard in the pipe welding industry
- Deep penetration High ductility (root pass)

Welding Position



Current

DC +

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Steel can	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	300 (12)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	350 (14)		√
5.0 (3/16)	350 (14)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.127	0.24	0.45	0.017	0.006	0.017	0.023	0.162

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
480 (69,600)	565 (82,000)	28.8	-45 (-49)	47 (35)

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	50~75	75~1325	90~165	140~220
V-up, OH	40~70	65~115	90~145	125~185