



Product Data Sheet

OK PIPEWELD 7010 PLUS

E 'Manual metal-arc welding'
ESAB S.A. Ind. E Comércio Brazil

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by J-P Ernoult	Reg no EN007364	Cancelling EN005347	Reg date 2016-08-22	Page 1 (2)
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REASON FOR ISSUE

Typical mechanical properties amended.

GENERAL

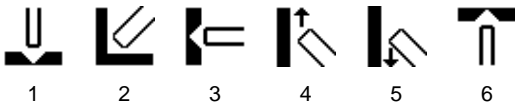
Cellulosic coated electrode for welding of low alloy steel pipes. Designed for vertical down welding, the deep penetrating arc provides good performance. Suitable for welding pipe steel types API 5L X52 to X60.

Polarity: DC+

Alloy Type: Low alloyed (0.3 % Ni, 0.2 % Mo)

Coating Type: Cellulosic covering

WELDING POSITIONS



CLASSIFICATIONS Electrode

SFA/AWS A5.5 E7010-P1
 EN ISO 2560-A E 42 2 Z C 21

APPROVALS

FBTS E 7010-P1

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.16
Si	0.03	0.25
Mn	0.3	0.6
P		0.03
S		0.03
Cr		0.05
Ni	0.3	0.5
Mo	0.2	0.35
V		0.05
Nb		0.05
Cu		0.3

MECHANICAL PROPERTIES OF WELD METAL

Properties	ISO		AWS	
	As welded Min	Max	As welded Min	Typ
Rp0.2 (MPa)			415	480
ReL (MPa)	420			
Rm (MPa)	500	640	490	570
A4 (%)			22	22
A5 (%)	20			
Charpy V at -20°C (J)	47			55
Charpy V at -30°C (J)			27	45



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
3.2 x 350	65	120	2.7	79	0.58	65	0.62	90	31	1,2,3,4,5,6
4.0 x 350	90	180	4	83	0.59	42	0.93	93	30.5	1,2,3,4,5,6
5.0 x 350	150	240	6.1	90	0.67	24	1.47	100	28.6	1,2,3,4,5,6

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)