

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.

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:	C-Mn-Ni-Mo
Coating Type:	Cellulosic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As welded	480 MPa	570 MPa	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As welded	-20 °C	55 J
As welded	-30 °C	45 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
0.09	0.46	0.12	0.34	0.24

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
3.2 x 350 mm	65-120 A	31 V	0.58	65	90 s	0.62 kg/h
4.0 x 350 mm	90-180 A	30.5 V	0.59	42	93 s	0.93 kg/h
5.0 x 350 mm	150-240 A	28.6 V	0.67	24	100 s	1.47 kg/h