

# OK 22.46P

Type Cellulosic

SMAW  
E7010-G

## Description

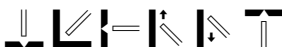
Cellulosic-coated electrode designed for the site welding of pipe and pipelines in API 5L X52 and X56 in all positions, using conventional stovepipe techniques. DC only.

## Recovery

90%

## Welding current

DC+



## Classifications

SFA/AWS A5.5	E7010-G
EN 499	E 42 2 C 21
BS 639 (1986)	E 51 43 C (10)

## Typical all weld metal composition, %

C	Si	Mn	Ni	Mo
0.1	0.14	0.5	0.4	0.3

## Typical mech. properties all weld metal

Yield stress, MPa	476
Tensile strength, MPa	544
Elongation, %	24

## Charpy V

Test temps, °C	Impact values, J
-20	60

## Approvals

LR	3, 3Y
BV	3, 3Y

## Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
3.2	350	65-120	31	0.58	65	0.62	90
4.0	350	90-180	30.5	0.59	42	0.93	93
5.0	350	150-240	28.6	0.67	24	1.47	100