

## Description

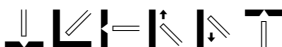
Cellulosic-coated electrode designed for the site welding of pipe and pipelines in API 5L X52 and X56 in all positions, using conventional stovepipe techniques. DC only.

## Recovery

90%

## Welding current

DC+



## Classifications

SFA/AWS A5.5	E7010-A1
EN 499	E 42 2 Mo C 21
BS 639 (1986)	E 51 43 C (10)

## Typical all weld metal composition, %

C	Si	Mn	Mo
0.07	0.1	0.3	0.5

## Typical mech. properties all weld metal

Yield stress, MPa	460
Tensile strength, MPa	540
Elongation, %	23

## Charpy V

Test temps, °C	Impact values, J
-20	65

## 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	27.6	0.7	55	0.76	87
4.0	350	90-180	29	0.64	39	1	90
5.0	350	150-240	27.5	0.68	24	1.45	104