



CEWELD E 7010

TYPE	Cellulosic coated electrode for SMAW welding.(Typ E7010, E 43 3 C)															
APPLICATIONS	CEWELD® E 7010 is our cellulosic electrode for the vertical down welding of hot and filler passes as well as for capping of higher strength pipe steels particularly for API grades X56, X60 or L290MB-L415MB. In general, the electrode is suitable for root passes and hot passes, but in most cases a lower electrode such as our CEWELD® E 6010 is also preferred for pipes with higher strength.															
PROPERTIES	Besides the excellent weld metal toughness properties it offers easy operation, and a concentrated intensive arc with deep penetration characteristics in order to ensure sound joint welds with good X-ray quality..															
CLASSIFICATION	AWS	A 5.5: E 7010-P1														
	EN ISO	2560-A: E 42 3 C 21														
	F-nr	3														
	FM	1														
SUITABLE FOR	<p>Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa)</p> <p>1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932</p> <p>S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL</p> <p>A, B, D</p> <p>ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60, X65 (Root X 80)</p>															
APPROVALS	CE															
WELDING POSITIONS																
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <td style="width: 25%;">C</td> <td style="width: 25%;">Si</td> <td style="width: 25%;">Mn</td> <td style="width: 25%;">P</td> <td style="width: 25%;">S</td> </tr> <tr> <td>0.14</td> <td>0.18</td> <td>1</td> <td>0.02</td> <td>0.02</td> </tr> </table>		C	Si	Mn	P	S	0.14	0.18	1	0.02	0.02				
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0.2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th>-20°C</th> <th>-30°C</th> </tr> <tr> <td>As Welded /</td> <td>450</td> <td>560</td> <td>26</td> <td>70</td> <td>55</td> </tr> </table>		Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		-20°C	-30°C	As Welded /	450	560	26	70	55
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			-20°C	-30°C												
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REDRYING TEMPERATURE	Not required															
GAS ACCORDING EN 14175																