










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 StE 360.7 TM, StE 385.7 TM. In general the electrode is suited for root passes, however, in most cases even on higher strength pipes our 6010 is preferred.				
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	Reh ≤ 420 MPa ISO 15608: 1.1, 1.2 1.0426, 1.0429, 1.0481, 1.0484, 1.0409, 1.0421, 1.0430, 1.0436, 1.0473, 1.0482, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.05821.8902, 1.8912, 1.8932, 1.8972, 1.8900, 1.8910, 1.8930 S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, L210-L415NB, L290MB - L415MB, P355T1, P235T2 - P355T2, P235G1TH, P255G1TH (Root L480MB) API Spec. 5 L: Grade A, B, X42, X46, X52, X56, X60, X65 (Root X 80)				
APPROVALS	CE				
WELDING POSITIONS	<div>PAPBPCPDPEPFPG</div>				
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S
	0.14	0.18	1	0.02	0.02
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V
	As Welded /	450	560	26	-20°C70-30°C55
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175					