

Classifications

EN ISO 3580-B:2008 : E 49 10-1M3
 AWS A5.5-06 : E7010-A1

Description

- Covering is high cellulose type for all positions welding of 0.5%Mo steel pipes used for high pressure, high temperature steam service, structural steel and plates or castings.
- Extremely good radiographic soundness and mechanical properties.
- Not to use the currents exceeding the recommended currents.
- Redry the electrode at 70-80°C for 30-60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.09	0.14	0.43	0.015	0.009	0.05	0.06	0.58	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 390	min. 490	min. 22			
EN ISO 3580-B	min. 390	min. 490	min. 20			
Example	440	550	29	60	50	PWHT

* PWHT : 620°Cx1Hr

Sizes available and recommended currents (DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	350	350
Amp. (A)	F V · OH	50~75 30~70	70~110 60~100	110~150 90~130	160~200 130~170

Approvals

ABS

3Y,E7010-A1

* Others : CE