

S-7010.A1

Type : Cellulesic

Conformances

AWS A5.5/ ASME SFA5.5 E7010-A1

EN ISO 2560-A-E42 0 Mo C 1 5

ABS AWS A5.5 E7010-A1

LR 2Y

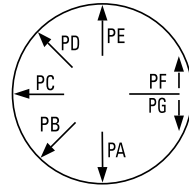
Applications

- Low alloy steel (0.5% Mo)
- Pipe line

Features

- Good X-ray performance
- Good mechanical properties

Welding Position



Current

DC ±

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Mo
0.09	0.12	0.32	0.015	0.015	0.61

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Heat Treatment
552 (80,000)	575 (83,400)	28.4	620°C(1148°F) X 1hr. S.R

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (12)	350 (14)	350 (14)	350 (14)
F & HF	55~80	80~120	120~160	160~210
V-up, OH	50~70	70~110	110~150	-