



HILCO PIPEWELD 7010

Stick electrodes – unalloyed steel

AWS A5.5: E 7010-P1

EN ISO 2560-A : E 42 3 C 25

Coating type:
Cellulose

Current:



*root pass

Welding positions:



Pipeweld 7010 is our cellulose-coated electrode recommended primarily for welding high-strength pipe butt joints in the vertical down position. The electrode is characterised by a deeply penetrating, forceful, spray type arc and readily removable slag. Typical application for Pipeweld 7010 is the welding of API 5L: X52 piping assemblies.

Base materials to be welded:

- Pipe steels L240MB - L360MB, API 5L X42 - X60
- Pipe steels root passes up to API 5L X70

Applications:

- Pipe welding

Chemical Composition, wt.% weld metal – typical:

C	Mn	Si
0,14	0,7	0,14

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
AW	≥ 420	≥ 500	≥ 22	20°C ≥ 100 -40°C ≥ 45

Packaging and welding data:

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	25,5	80-130
4,0	350	39,2	120-180