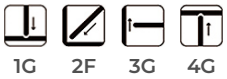
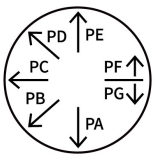
S-7010.P1

Classification

AWS A5.5/ASME SFA-5.5 E7010-P1

Welding Positions





Features

- Standard in the pipe welding industry
- Deep penetration High ductility (root pass).
- Pipe welding positions 5G-Up and 5G-Down are applicable

Polarity

DC +

Application Areas

- Root pass welding for pipeline
- General fabrication
- Vertical down welding

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Approvals

CWB
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.17	0.24	0.68	0.017	0.007	0.18	0.03	0.01	0.01

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
421(61)	523(76)	26	-30(-20)	47(35)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	300(12)	50-75	40-70	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	75-125	65-115	
4.0(5/32)	350(14)	90-165	90-145	
5.0(3/16)	350(14)	140-220	125-185	