Pipeweld 7010 Plus

Cellulosic coated electrode for welding of low alloy steel pipes. Designed for vertical down welding, the deep penetrating arc provides good performance. Suitable for welding pipe steel types API 5L X52 to X60.

Classifications	SFA/AWS A5.5 : E7010-P1 EN ISO 2560-A : E 42 2 Z C 21
Approvals	FBTS E 7010-P1

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	Low alloyed (0.3 % Ni, 0.2 % Mo)
Coating Type	Cellulosic covering

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	480 MPa (70 ksi)	570 MPa (83 ksi)	22 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-20 °C (-4 °F)	55 J (41 ft-lb)
As Welded	-30 °C (-22 °F)	45 J (33 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
0.09	0.46	0.12	0.34	0.24

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Burn-off Time/ Electrode	Deposition Efficiency %	Deposition Rate @ 90% I max
3.2 x 350.0 mm (1/8 x 13.8 in.)	65-120 A	31 V	65	90 sec	58 %	0.62 kg/h (1.4 lb/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	90-180 A	30.5 V	42	93 sec	59 %	0.93 kg/h (2.1 lb/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	150-240 A	28.6 V	24	100 sec	67 %	1.47 kg/h (3.2 lb/h)

12287-en_US-FactSheet_Main-01 2022-05-19