



CEWELD E 7010

TYPE Cellulosic coated electrode for SMAW welding.(Typ E7010, E 43 3 C)

APPLICATIONS CEWELD® E 7010 is our cellulosic electrode for the vertical down welding of hot and filler passes as well as for capping of higher strength pipe steels particularly for API grades X56, X60 or L290MB-L415MB. In general, the electrode is suitable for root passes and hot passes, but in most cases a lower electrode such as our CEWELD® E 6010 is also preferred for pipes with higher strength.

PROPERTIES Besides the excellent weld metal toughness properties it offers easy operation, and a concentrated intensive arc with deep penetration characteristics in order to ensure sound joint welds with good X-ray quality..

CLASSIFICATION

AWS	A 5.5: E 7010-P1
EN ISO	2560-A: E 42 3 C 21
F-nr	3
FM	1

SUITABLE FOR **Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa)**
 1.0035, 1.0038, 1.0039, 1.0044, 1.0112, 1.0116, 1.0130, 1.0145, 1.0253, 1.0254, 1.0255, 1.0258, 1.0259, 1.0319, 1.0345, 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932
 S235JR-S355JR, S235JO-S355JO, P195TR1-P265TR1, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, L415NB, L415MB, WStE 380, WStE 420, S420NL
 A, B, D
 ASTM A 106, Gr. A, B; A 283 Gr. A, C; A 285 Gr. A, B, C; A 501, Gr. B; A 573, Gr. 58, 65, 70; A 633, Gr. A, C; A 711 Gr. 1013; API 5 L Gr. B, X42, X52, X56, X60, X65 (Root X 80)

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	S
0.14	0.18	1	0.02	0.02

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-30°C	
As Welded	450	560	26	70	55	HRc

REDRYING Not required

GAS ACC. EN ISO 14175