OK 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.

Specifications	
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**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
3.2 x 350 mm (1/8 x 13.8 in.)	65-120 A	31 V	58 %	90 sec	0.62 kg/h (1.4 lbs/h)
4.0 x 350 mm (5/32 x 13.8 in.)	90-180 A	30.5 V	59 %	93 sec	0.93 kg/h (2.1 lbs/h)
5.0 x 350 mm (0.197 x 13.8 in.)	150-240 A	28.6 V	67 %	100 sec	1.47 kg/h (3.2 lbs/h)