

Cellulosic Coated Electrode for Mild Steels

Classification

EN ISO 2560-A : E 46 2 Mo C 21
 AWS A5.5 : E7010-A1

General Description

AS S-7010 Mo is a cellulosic coated electrode. It has 0.5 % Mo content. Excellent molten pool control due to easily-removable slag and gaseous arc shielding eliminates porosity problems in weld beads which have good mechanical properties. In all positions, it enables notch-free, smooth weld beads of high penetration.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	Mo
0.08	0.10	0.70	0.50

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 480 N/mm²
 Tensile Strength : 600 N/mm²
 Elongation (L=5d) : 25 %
 Impact (ISO-V) : 50 J (-20°C)
 40 J (-30°C)

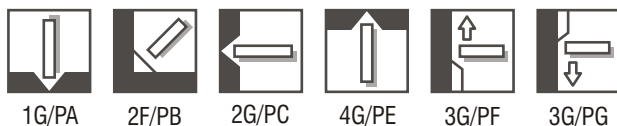
Approvals

GOST, SEPRO, TSE

Welding Parameters / Packing and Diameter Informations / Welding Positions

Current Type and Polarity : DC (+)

Diameter [mm]	Length [mm]	Current [A]			Electrode Weight [g/100 pcs]	Box Weight [kg] Quantity [pcs/box]	Export Box Box Weight [kg]
		[Root Pass]	[Hot Pass]	[Cover Pass]			
3.25	350	80 - 100	100 - 125	80 - 100	2500	6.0 / 240	5
4.00	350	110 - 130	115 - 140	110 - 130	3860	6.0 / 155	5



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Applications and Materials to be Welded

It is especially designed for the site welding of higher strength pipe and pipelines with 0.5 % Mo, that carry content carrying natural gas, crude petroleum or alike. It is particularly used on pipe steels in the 5LX52 - 5LX56 range. Ship building; storage tanks, and boiler and pressure vessel manufacturing are among its application areas. AS S-7010 Mo is an ideal electrode for welding in vertical downwards position.

	DIN	EN
General Structural Steels	St 33, St 35, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4	S185, S235, S275, S355 P235TR2 - P355T2
Fine Grained Steels	StE 255 - StE 355 WStE 255 - WStE 355	S255N - S355N P255NH - P355NH
Pipe Materials	StE 290-7 - StE 415-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X56, X60 (API 5LX)	L290NB - L415NB L290MB - L360MB -
Boiler and Pressure Vessel Steels	17 Mn 4, 19 Mn 5, 15 Mo 3 HI, HII, HIII	P295GH, P310GH, 16 Mo 3 P235GH, P265GH, P285NH
Elevated Temperature Steels	St 35-8, St 45-8	P235G1TH - P255G1TH
Ship Plates	A, B, C, D, E	-
Cast Steels	GS-38 - GS-45	GE200, GE240, GE260