

Stick electrode

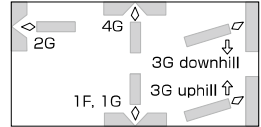
- Features:**
- Suitable for butt welding of pipes
 - Excellent usability in vertical downward welding

Classification: AWS A5.5 E7010-P1

Identification color: 1st Brown, 2nd Black

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.4	300	2	20	13	300W, 100H, 330L
3.2	350	5	20	27	175W, 115H, 380L
4.0	350	5	20	40	175W, 115H, 380L
4.8	350	5	20	58	175W, 115H, 380L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.14	0.20
Si	0.10	0.60
Mn	1.01	1.20
P	0.01	0.03
S	0.01	0.03
Ni	0.01	1.00
Cr	0.02	0.30
Mo	<0.01	0.50
V	<0.01	0.10

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2G	3G uphill, 4G	3G downhill
2.4	40~70	40~70	40~70
3.2	60~120	60~120	70~120
4.0	90~170	80~160	100~170
4.8	130~210	120~200	150~210

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	470	414min.
TS (MPa)	570	483min.
El on 4d (%)	30	22min.
IV -29°C (J)	61	27min.