CEWELD E 7010

certilas® THE FILLER METAL SPECIALIST

TYPE

Cellulosic coated electrode for SMAW welding.(Typ E7010, E 42 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

CEWELD® E 7010 is characterized not only by the excellent toughness properties of the weld metal but also by its easy handling due to the concentrated, intensive arc with deep penetration. This ensures perfect joint welds with good X-ray security. CEWELD® E 7010 is also very suitable for sour gas applications.

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, X60, (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	$R_{P0,2}$ (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