

ROYAL 7010 (E 7010G)

AWS : SFA 5.5, E 7010 G

Applications

It is used in joining of cross country steel pipelines, pressure pipelines, storage tanks, welding of pipe line of AP-SL –X 52 etc. structural fabrication, field works where deep penetration is required.

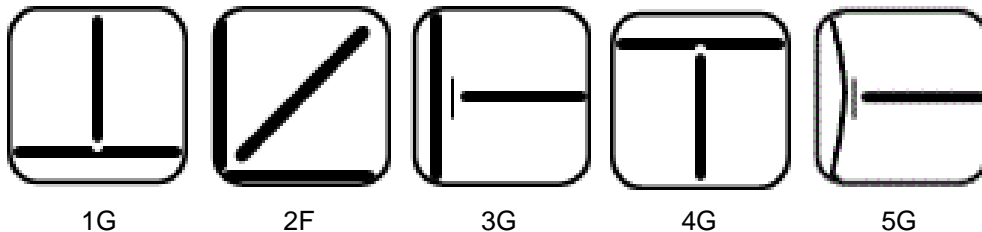
Characteristics on Usage

It is medium coated all position cellulosic electrode provides a deep penetration forceful arc with readily removable thin friable slag and deposits a flat bead with high melting rate. It gives a ductile and creep resistant 0.5% Ni steel weld deposit with radiographic quality.

Notes On Usage

1) As this electrode is prone to absorb moisture, store it with care.

2) Keep the arc as short as possible.

Welding Positions**Chemical Composition Of Weld Metal**

| C% | Mn% | Si% | S% | P% | Ni % |
|----------|----------|----------|-----------|-----------|----------|
| 0.20 Max | 1.50 Max | 0.75 Max | 0.030 Max | 0.030 Max | 0.50 Min |

Mechanical Properties Of Weld Metal

| U.T.S. (N/mm ²) | Y.S. (N/mm ²) | ELONGATION (L = 4d) % | IMPACT (CVN) AT - 30° C (J) |
|--------------------------------|------------------------------|----------------------------|------------------------------------|
| 490 Min | 390 Min | 22.0 % Min | 27 Joules Min |

Packing and Welding Current

| SIZE (mm) | KG PER PACKET | KG PER CARTON | Current (Amps) | In Amps |
|-------------|---------------|---------------|----------------|---------|
| 2.50 x 350 | 5 | 20 | DC (+) | 60 – 90 |
| 3.15 x 350 | 5 | 20 | | 100-140 |
| 4.00 x 350 | 5 | 20 | | 140-180 |
| 5.00 x 350 | 5 | 20 | | 180-240 |