

# 7010

WELDING ROD FOR QUALITY WELDS WITH HIGH AND LOW ALLOY STEEL. SUITABLE FOR ALL WELDING POSITIONS WHERE GREAT PENETRATION IS REQUIRED

CLASSIFICATION: A.W.S: E-7010-A1

IDENTIFICATION: BLUE COATING

**APPLICATIONS:** This electrode's most important applications are in Carbon-Molybdenum steel welds, specially in pipes. It is recommended for welding in oil pipelines, boilers, tanks, railway cars, dirt moving equipment, alloy steel buckets in excavators and in the production of tools for the oil industry.

**CHARACTERISTICS AND PROCEDURE:** For flat welds, keep the arc short. As a rule, use medium amperage. When changing the welding rod, clean the undercut before you restart welding, to fill it up with a circular movement and then, move on. When welding in flat and horizontal position, try to swing as little as possible. In overhead welds, it is recommended to make thin weld beads to avert overheating the plate. This will allow the filler metal to harden quickly. When welding vertically downwards, use standard amperage values, a medium arc and a welding rod not thicker than 5/32" for the first pass. Then, finish filling up the chamfer with a 3/16" welding rod. This is a cellulosic welding rod; its filler metal is a Carbon-Molybdenum alloy which is specially suitable to weld in all positions with highly resistant steel and to seal pressure pipes in oil and gas pipelines. Its powerful arc and light slag allow the use of E-7010 welding rods in general fitting jobs where it is essential to work with ease in all positions and to achieve great penetration and top safety in the weld seams.

<b>TENSILE RESISTANCE:</b>	5,000 - 5,600 KG./CM2 (71,100 A 79,650 PSI)
<b>ELASTIC LIMIT:</b>	4,200 - 4,500 KG./CM2 (60,000 A 64,000 PSI)
<b>ELONGATION IN 5 cm:</b>	22 - 25%
<b>BRINELL HARDNESS:</b>	160 - 180 BHN
<b>POSITIONS:</b>	ALL
<b>CURRENT:</b>	DC REVERSE POLARITY

FILLER METAL CHEMICAL ANALYSIS %						SIZES	AMPERAGE
C	Mn	Mo	P	S	Si	3.25 mm - 1/8"	80-130
0.11	0.50	0.50	0.03	0.03	0.26	4.0 mm - 5/32"	105-180
						5.0 mm - 3/16"	150-230