

K-7010A1

AWS E7010-A1

FOR HEAT-RESISTING STEEL

Typical applications

Welding of C-0.5%Mo steel pipes used for high pressure, high temperature steam service, structural steel and plates or castings. Welding of long distance pipe lines.

Coating

High cellulose type.

Characteristics on Usage

- ① Extremely good radiographic soundness and mechanical properties.
- ② Not to use the currents exceeding the recommended currents
- ③ Preheat at 100~200°C and postheat treat at 620~680°C.
- ④ Redry the electrode at 70~80°C for 30 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Mo
0.09	0.14	0.43	0.49

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	PWHT
440 {45}	550 {56}	29	620°C × 1hr. S · R

Sizes available and recommended currents (DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amp.	F	50~75	70~110	110~150	160~200
	V&OH	30~70	60~100	90~130	130~170

Welding positions



Approved by

ABS