

# ROYAL 7010 (E 7010G)

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.

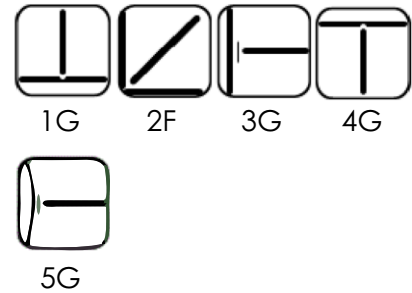
## Characteristics on Usage

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

- As this electrode is prone to absorb moisture, store it with care.
- Keep the arc as short as possible.

## Welding Positions



LOW ALLOY HIGH TENSILE ELECTRODES

## 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 <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	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 )	PIECES PER PACKET	PIECES 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