

International standards	EN 499	E42 3 C 25
	ISO 2560	E51 3 C 10
	AWS A 5.1	E7010-P1

Approvals ---

Typical applications and characteristics Cellulose coated electrode for joining and repairing pipelines, especially in vertical down position. CARBO Cel 7010 is particularly suitable for welding root layers.

Excellent weldability also on soiled surfaces containing impurities from corrosion, paint residues, priming coats, etc.

High efficiency as compared to vertical up welding.

Operating temperature From -30° C up to +450° C

Base materials S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH L210 – L415NB, L290MB – L415MB, P355T1, P235T2 – P355T2, P235G1TH, P255G1TH.
Root pass to L480MB.

API 5 LX, X42 – X60, Root pass to X 70.

Mechanical properties of all-weld metal (typical values)	Tensile strength R_m N/mm ²	Yield strength R_{eL} N/mm ²	Elongation A_5 %	Impact strength ISO – V J - 30°C
	580	> 420	> 22	> 47

Weld metal analysis (typical, wt. %)	C	Si	Mn
	0,14	0,14	0,7

Current = - / + , ~ 60V

Welding positions PA, PB, PC, PG, PE, PF, PG

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
3.2 x 350	80 – 130				5.0	20.0
4.0 x 350	120 – 180				5.0	20.0
5,0 x 350	160 – 210				5,0	20,0

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