

Classifications

EN ISO 2560-A:2006	: E 42 0 C 22	JIS Z 3211	: E4910-G
EN ISO 2560-B:2006	: E 49 10-G A		
AWS A5.5-06	: E7010-G		

Description

- Covering is high cellulose type for all positions welding of pipes, general light structural steels.
- This electrode is characterized by deeply penetrating, forceful, spray type arc.
- Readily removable, thin friable slag.
- Good mechanical properties and the weld metal meets requirement X-ray.
- Redry the electrode at 70~80°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.10	0.56	0.87	0.014	0.013	0.34	0.03	0.28	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-30°C	
AWS A5.5	min. 390	min. 490	min. 22			
EN ISO 2560-A	min. 420	500~640	min. 20	≥ 47		
Example	470	570	27	60	40	AW

* AW : As-Welded

Sizes available and recommended currents (DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp. (A)	F V · OH	50~80 40~70	70~110 60~100	110~150 90~130	160~200 140~170

Approvals

JIS, CE