



Selectarc C7010

Cellulose Electrode
High resistance

Classification

AWS A5.5 : E7010-A1

ISO 2560-A : E 42 2 Mo C 2 1

Description & Applications

Cellulose coated electrode specially for pipe welding in vertical downhand position. Very thin slag and easy to remove. Particularly recommended for root passes. Very good behaviour on bad prepared joints (rust, painting...).

Main applications: Used for metal constructions, for piping systems, tanks, blacksmithing, craft works.

Base materials

Construction steels for general use, Tube steels, Ship steels:

EN	S275JR – S355	L360NB, L415NB, L415MB
ASTM	A283 grade B, C, D	A570 gr 30, 33, 40, 55
API SPEC 5LX	X42 – X60	

Typical Weld Metal Composition (%)

C	Si	Mn	Mo	P	S
0.13	0.15	0.40	0.5	<0.025	<0.025

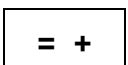
All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
430	570	27	-20°C 75

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350	4,0x350
Current	(A)	70	110	150

Direct current (= -) pole on the electrode in the root pass, then + pole for the following passes.



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