

<b>International standards</b>	EN 499	E42 2 Mo C 21
	AWS A 5.1	E7010-A1
	DIN 1913	E 51 43 C 4

**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.

<b>Mechanical properties of all-weld metal</b>  ( typical values )	<b>Tensile strength</b> $R_m$ N/mm <sup>2</sup>	<b>Yield strength</b> $R_{eL}$ N/mm <sup>2</sup>	<b>Elongation</b> $A_5$ %	<b>Impact strength</b> ISO – V J bei - 20°C - 30°C	
	570	510	27	70	47

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Mo</b>
	0,1	0,14	0,4	0,5

**Current** Fill : = + for root pass welding = -

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

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 350	40 – 80	299	897	16,7	5	15
3,2 x 350	60 – 110	181	543	27,6	5	15
4,0 x 350	90 – 140	117	351	42,8	5	15
5,0 x 350	120 – 180	83	243	60,3	5	15

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