

## CARBO CEL 7010

International standards

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.

**Mechanical properties** of all-weld metal

( typical v	alues)
-------------	--------

Tensile strength R <sub>m</sub> N/mm²	Yield strength R <sub>eL</sub> N/mm <sup>2</sup>	Elongation A₅ %	Impact strength ISO – V J bei - 20°C - 30°	
570	510	27	70	47

Weld metal analysis (typical, wt. %)

С	Si	Mn	Мо
0,1	0,14	0,4	0,5

Fill : = + Current

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

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.