

# Lincoln® 7010

## TOP FEATURES

- Cellulosic coated MMA electrode for root and hot passes as well as filling and capping up to X60 Grade pipe
- Excellent weldability in all positions
- Designed for both DC+ and DC- current
- Q2 lot controlled and tested to provide actual weld composition and mechanical properties

## TYPICAL APPLICATIONS

- Pipeline

## CLASSIFICATION

AWS A5.5	E 7010-P1
EN ISO 2560-A	E 42 3 Mo C 21

## CURRENT TYPE

DC-; DC+

## WELDING POSITIONS

All positions

## APPROVALS

ABS, TÜV

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Mo
0.1	0.7	0.2	0.5

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)		Impact ISO-V (J) -30°C
				4d	5d	
AWS A5.5	AW	≥415	≥490	≥22	-	≥27
EN ISO 2560-A	AW	≥420	500-640	-	≥20	≥47
Typical values	AW	475	520	27	23	66

AW = As welded

- = not specified

## OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	60-110
4.0 x 350	90-140
5.0 x 350	110-170

## AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	MCAN	355	9.5	627262
4.0 x 350	MCAN	237	9.5	627263
5.0 x 350	MCAN	158	9.5	627264