

LINCOLN® 7010

TOP FEATURES

- Used for root and hot passes as well as filling and capping up to X60 grades
- When root pass welding, negative polarity is recommended
- Excellent weldability in all positions
- Q2 lot Controlled Chemistry and Mechanical Properties

TYPICAL APPLICATIONS

- Root pass welding of up to X80 grade pipe
- Hot, fill and cap pass of up to X65 grade pipe

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, LR, DNV, 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) +20°C
Typical values	AW	≥420	500-640	≥22	≥60

AW = As welded

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	40-80
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
2.5 x 350	CAN	555	9.0	627261
3.2 x 350	CAN	355	9.5	627262
4.0 x 350	CAN	237	9.5	627263
5.0 x 350	CAN	158	9.5	627264