

Product Data Sheet

MILD STEEL ELECTRODE

BRAND NAME VJ 7010

AWS/ASME Class E7010

SPECIFICATION SFA 5.5



Features and Applications :

VJ E7010 is an all position electrode that is especially suited for welding high strength pipe. It produces the consistent, deep penetration required to maintain a proper keyhole when vertical down welding in open root pipe joints.its recommended for welding API grades x42,x 46, x52 and x56 pipe and the root pass upto API grade x70.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	Max
C	0.15
Mn	0.47
Si	0.25
Ni	0.05
S	0.03
P	0.03

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	Typical
YS (MPa)	480
UTS (MPa)	560
El (%)	22
Charpy V at -30°C (J)	40

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (kg)
	Min	Max	
Dia x Length			Qty / Pkt
2.50 x 350	40	70	3.5
3.15 x 350	70	110	3.5
4.00 x 350	110	160	3.5
5.00 x 350	160	210	3.5

CURRENT : DC (+)

WELDING POSITION:

