

## low-alloy Cellulosic Electrodes

# STARBLAZE PRIME 7010-A1

- ★ Excellent all position welding characteristics.
- ★ Best suitable for high strength pipes and pipelines welding, root passes and capping runs.
- ★ Excellent mechanical properties.
- ★ Radiographic quality weld.

**Classification**      **AWS A5.5** : E 7010-A1

**EN ISO 2560-A:** E 42 Z Mo C 2 1

**Description and applications**

Cellulosic coated electrode for welding of steels containing 0.50% moly and high strength steels. Excellent all position including vertical down characteristics. Exhibits a forceful arc with deep penetration and fast freezing weld puddle. Suitable for root passes and capping runs. Welds deposits are of X-ray quality.

**Base materials**

S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, L210 - L415NB, L290MB-L415MB, P355T1, P235T2 - P355T2, P235G1TH, P255G1TH

**Typical Weld Metal Chemical Composition (%)**

C	Si	Mn	Mo	S	P
0.10	0.25	0.50	0.50	0.015	0.020

**All weld metal Mechanical Properties (Typical)**

Heat Treatment	Tensile Strength R <sub>m</sub> (N/mm <sup>2</sup> )	Yield Strength R <sub>p</sub> (N/mm <sup>2</sup> )	Elongation A <sub>5</sub> (%)	Charpy Impact Value ISO-V(J) at RT
PWHT 620°C (± 15°C) /1 hr.	500 - 600	400 - 500	≥24	100

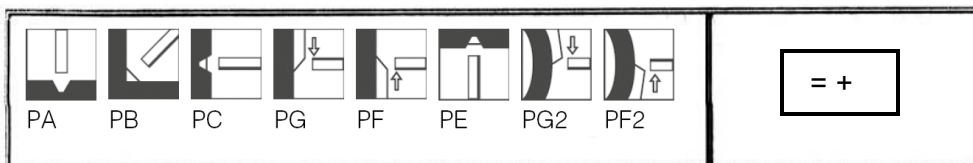
**Amperes (A)**

2.40mm	3.20mm	4.00mm	4.80mm
40-70	80-110	120-160	130-170

**Welding instruction**

Keep dry and avoid condensation. Re-drying not generally required. If necessary : 70°C for 30 minutes one time only.

**Welding Position**



**Stellaris Specialities India Ltd.**

(Division: StarBlaze India)

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