

GRIDUCT 70P1

IDENTIFICATION

Griduct 70P1, E7010P1

CLASSIFICATION

AWS/SFA 5.5 : E7010P1

EN 499 E382MoC25

DESCRIPTION

Medium coated, all position, cellulosic electrode with a forceful penetrating arc for pipe welding suitable for cross-country pipelines for root, filler and capping passes using down-hand welding technique, weld metal is highly ductile and of X-ray quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Mo	Ni	Cr	V
0.20 Max	1.20 Max	0.60 Max	0.025 Max	0.03 Max	0.50 Max	1.00 Max	0.3 Max	0.08 Max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact Strenght	
			Temp	Joules
490 Min	415 Min	22 Min	+26°C	60 Min
			+30°C	27 Min

TYPICAL APPLICATIONS

- Pipe Lines for depositing root run in the in-plant pipe lines.
- For cross-country pipe line, root, filler & capping passes.
- Pipe Steels API TLX-grade 42-60.
- Specially suited for pressure pipe lines which cannot be welded from inside.

CURRENT CONDITIONS: DC (+)

RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS DC(+)	PACKING/BOX (PCS)	WEIGHT/1000 PCS (KG)
2.50	350	60-95	200	16
3.15	350	80-130	130	27
4.00	350	110-160	80	39