

## CLASSIFICATION

EN ISO 2560-A : E 46 2 Mo C 21  
AWS A5.5 : E7010-A1

## GENERAL DESCRIPTION

L-7010 Mo is a cellulosic coated electrode. It has 0.5 % Mo content. Excellent molten pool control due to easily-removable slag and gaseous arc shielding eliminates porosity problems in weld beads which have good mechanical proper ties. In all positions, it enables notch-free, smooth weld beads of high penetration.

## APPROVALS

GOST, SEPRO, TSE

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

C	Si	Mn	Mo
0.08	0.10	0.70	0.50

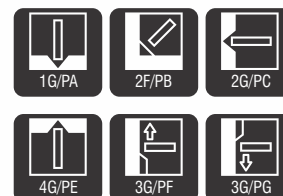
## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Yield Strength	: 480 N/mm <sup>2</sup>
Tensile Strength	: 600 N/mm <sup>2</sup>
Elongation (L=5d)	: 25 %
Impact (ISO-V)	: 50 J (- 20°C) 40 J (- 30°C)

## WELDING PARAMETERS / PACKING AND DIAMETER INFORMATIONS / WELDING POSITIONS

Current Type and Polarity : DC (+)

Diameter [ mm ]	Length [ mm ]	Current [A]			Electrode Weight [ g/100 pcs ]	Box Weight [ kg ] Quantity [ pcs/box ]	Export Box Box Weight [ kg ]
		Root Pass	Hot Pass	Cover Pass			
3.25	350	80 - 100	100 - 125	80 - 100	2500	6.0 / 240	5
4.00	350	110 - 130	115 - 140	110 - 130	3860	6.0 / 155	5



## APPLICATIONS AND MATERIALS TO BE WELDED

It is especially designed for the site welding of higher strength pipe and pipelines with 0.5 % Mo, that carry content carrying natural gas, crude petroleum or alike. It is par ticularly used on pipe steels in the 5LX52 - 5LX56 range. Ship building; storage tanks, and boiler and pressure vessel manufacturing are among its application areas. L-7010 Mo is an ideal electrode for welding in ver tical downwards position.

	DIN	EN
<b>General Structural Steels</b>	St 33, St 35, St 37, St 44, St 44-2, St 44-3, St 52 St 37-4, St 44-4, St 52-4	S185, S235, S275, S355 P235TR2 - P355T2
<b>Fine Grained Steels</b>	StE 255 - StE 355 WStE 255 - WStE 355	S255N - S355N P255NH - P355NH
<b>Pipe Materials</b>	StE 290-7 - StE 415-7 StE 290-7 TM - StE 360-7 TM X42, X46, X52, X56, X60 (API 5LX)	L290NB - L415NB L290MB - L360MB -
<b>Boiler and Pressure Vessel Steels</b>	17 Mn 4, 19 Mn 5, 15 Mo 3 HI, HII, HIII	P295GH, P310GH, 16 Mo 3 P235GH, P265GH, P285NH
<b>Elevated Temperature Steels</b>	St 35-8, St 45-8	P235G1TH - P255G1TH
<b>Ship Plates</b>	A, B, C, D, E	-
<b>Cast Steels</b>	GS-38 - GS-45	GE200, GE240, GE260

**Liability** : All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance.  
**Fumes** : Consult information on Welding Safety Sheet, available upon request.

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