

NOUVE® 7010-G

Designation

AWS/SFA-5.1: E7010-G
UNS No. W07010

Welding Positions



Features

- ▶ Excellent arc characteristics
- ▶ Low moisture re-absorption
- ▶ Low spatter level
- ▶ Low smoke level
- ▶ Quick and easy slag removal
- ▶ Radiography quality

Applications

Welding of pressure pipes, general light structural steels, agricultural machinery.

Type of Current

Direct Current Electrode Positive (DCEP)

Recommended Welding Techniques

GENERAL : Electrode positive, work negative (DCEP)
 ARC LENGTH : Short arc

Weld Metal Chemistry

WELD METAL ANALYSIS (%)	AWS SPEC	TYPICAL
Carbon (C)	0.20 max	0.130
Manganese (Mn)	1.20 max	0.560
Silicon (Si)	0.60 max	0.167
Phosphorous (P)	0.03 max	≤ 0.01
Sulphur (S)	0.03 max	≤ 0.01
Nickel (Ni)	1.00 max	0.015
Molybdenum (Mo)	0.50 max	0.297
Chromium (Cr)	0.30 max	0.2

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Mechanical Properties (as welded)

MECHANICAL TESTS	AWS SPEC		TYPICAL	
Tensile Strength	490 MPa Minimum		560 MPa	
Yield Strength	415 MPa Minimum		440 Mpa	
Elongation % in 2"	22% Minimum		Above 23%	
Impact Energy (min)	Average Value	27J at -30°C	Average Value	32J at -30°C

Dimension, Current Condition & Packing Data

DIAMETER (IN)	DIAMETER (MM)	PACKAGE		CURRENT CONDITION (DC+) Amps
		INNER	OUTER	
3/32	2.5	2.5 Kg	20 Kg	60 - 90
1/8	3.15	5 Kg	20 Kg	80 - 110
5/32	4.0	5 Kg	20 Kg	110 - 150
3/16	5.0	5 Kg	20 Kg	150 - 180