

**PIPE WELDING COVERED ELECTRODE****EURO PIPE SHIELD****CODING:** AWS/SFA-5. 5 E 7010 - G**CHARACTERISTICS :**

**EURO PIPE SHIELD** is an all position cellulosic 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.

**APPLICATIONS :**

**EURO PIPE SHIELD** is recommended for welding API grades x42,x 46, x52 and x56 pipe and the root pass upto API grade x70.

**CURRENT CONDITIONS:**

SIZE mm		2.50 X 350	3.25 X 350	4.00 X 350	5.00 X 350
CURRENT-Amps	DC(+)	60-90	100-140	130-180	170-230

**TYPICAL CHEMICAL COMPOSITION OF WELD METAL**

Element	C	Mn	Si	Ni	S	P	Mo
percent	0.15	0.47	0.18	0.05	0.03	0.03	0.40

**TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL**

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	CVN Impact value
480	560	22	36 J(at -46°C)

**RADIOGRAPHIC EVALUATION :** GRADE-II - SATISFACTORY**FILLET WELD TEST:** MET REQUIREMENTS**REBAKING INSTRUCTIONS:** NOT PERMITTED