

PIPE WELDING COVERED ELECTRODE

EURO PIPE 7011 AC

CODING: AWS/SFA-5. 5 E 7011

CHARACTERISTICS :

EURO PIPE 7011 AC 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 7011 AC 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	AC/DC(+)	60-90	100-140	130-180	170-230

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	Ni	S	P
percent	0.15	0.47	0.25	0.05	0.03	0.03

TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	CVN Impact value
480	560	22	30J (at -29°C)

RADIOGRAPHIC EVALUATION : GRADE-II - SATISFACTORY

FILLET WELD TEST: MET REQUIREMENTS

REBAKING INSTRUCTIONS: NOT PERMITTED