# KOBE-7010S FAMILIARC™

**Stick electrode**

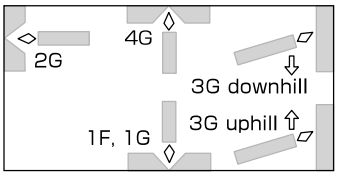
**Features:**
- Suitable for butt welding of pipes
- Excellent usability in vertical downward welding

**Classification:** AWS A5.5 E7010-P1

**Identification color:** 1st Brown, 2nd Black

**Polarity:** DCEP

**Welding Positions:**




## Packaging data

| ϕ mm | Length mm | kg/pack | kg/carton | g/piece | carton mm |
|---|---|---|---|---|---|
| 2.4 | 300 | 2 | 20 | 13 | 300W, 100H, 330L |
| 3.2 | 350 | 5 | 20 | 27 | 175W, 115H, 380L |
| 4.0 | 350 | 5 | 20 | 40 | 175W, 115H, 380L |
| 4.8 | 350 | 5 | 20 | 58 | 175W, 115H, 380L |

## Composition (all-weld metal mass%)

| | Typical | Guaranty [a] |
|---|---|---|
| **C** | 0.14 | 0.20 |
| **Si** | 0.10 | 0.60 |
| **Mn** | 1.01 | 1.20 |
| **P** | 0.01 | 0.03 |
| **S** | 0.01 | 0.03 |
| **Ni** | 0.01 | 1.00 |
| **Cr** | 0.02 | 0.30 |
| **Mo** | <0.01 | 0.50 |
| **V** | <0.01 | 0.10 |

Note: [a] Single values are maximum.

## Welding parameters (A)

| ϕ mm | 1F, 1G, 2G | 3G uphill, 4G | 3G downhill |
|---|---|---|---|
| 2.4 | 40~70 | 40~70 | 40~70 |
| 3.2 | 60~120 | 60~120 | 70~120 |
| 4.0 | 90~170 | 80~160 | 100~170 |
| 4.8 | 130~210 | 120~200 | 150~210 |

## All-weld mechanical properties

| | Typical | Guaranty |
|---|---|---|
| **0.2%YS (MPa)** | 470 | 414min. |
| **TS (MPa)** | 570 | 483min. |
| **El on 4d (%)** | 30 | 22min. |
| **IV -29℃ (J)** | 61 | 27min. |