

Characteristics and Applications:

PipeMark 710 is a cellulose electrode for both vertical-down welding of high strength large diameter pipelines. The product is excellent for root passes, hot passes, filler and cover layers. Especially recommended for root pass welding. PipeMark 710 is designed for DCEP and DCEN welding. The product can be applied to vertical-down and all position welding and features with stable arc, good slag detachability, and deep penetration. It is suitable for the welding of pressure pipes, oil tanks, and boilers.

Notes on usage:

1. Be sure to clean up the contaminations on the base metal.
2. Not allow to re-dry electrode

Typical chemical composition of weld metal (wt%) :

C	Mn	Si	P	S
0.12	0.8	0.12	0.015	0.010

Typical mechanical properties of weld metal :

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30°C (-20 °F)
520(75)	630(91)	22	40(30)

Welding position:

Sizes and recommended current range (DCP/DCEN):

Diameter (mm)	2.4	2.6	3.2	4.0	4.8
Length (mm)	350		350	350	350
Amps	50-70		60-100	90-140	140-200

Base Materials :

EN: S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P355T2, L210-L415NB, P235G1TH, P255G1TH. Root pass up to L480MB

API 5 L: A, B, X 42, X 46, X 52, X 56, X 60. Root pass up to X 70.

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Other tests and procedures may produce different results.

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