



STOV - 70 AP

PIPELINE ELECTRODE

CLASSIFICATION :

IS : 1395-82 : E 49 C-G1 10
AWS/A 5.5 : E 7010 P1

APPROVALS :

EIL

CHARACTERISTICS :

An all position electrode with cellulosic coating providing good welder appeal and smooth arc characteristic. This electrode has been specially designed for high yield pipeline steels. It has unique usability characteristic.

APPLICATIONS :

- * Out of position welding requiring good penetration.
- * Welding of high yield pipeline steels
- * Storage tanks
- * Drill platforms, Ships etc.

RECOMMENDATIONS :

Downhill travel is preferred for welding of pipes. Pre-heat interpass and post heating temperature between 95°C and 150°C should be applied if ambient temperature is below 0°C. For vertical down welding use higher amperage and faster travel staying ahead of puddle and for vertical up and overhead, use slight whipping or weaving technique.

**CHEMICAL ANALYSIS
OF WELD-METAL(%) :**

C	Mn	Si	Ni	Mo	P	S
0.20	1.2	0.6	1.0	0.50	0.03	0.03
max	max	max	max	max	max	max

**MECHANICAL PROP-
ERTIES OF ALL WELD-
METAL (AS PER
AWS/A 5.5) :**

Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d) (%)
N/mm ² 420 min	N/mm ² 510-610	22-28

CURRENT CONDITIONS : USE DC (+) ONLY

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	50-80	80-120	120-150	150-200

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