



# STOV - 70 (SPECIAL)

## PIPELINE ELECTRODE

**CLASSIFICATION :**

**IS : 1395-82 : E 49C - A1 10**  
**AWS/A 5.5 : E 7010 A1**

**CHARACTERISTICS :**

An all position high strength cellulose coated electrode especially designed for the welding of Cross Country Pipelines. It has good welder appeal, smooth arc characteristic giving radiographic quality welds.

**APPLICATIONS :**

- \* Out of position welding requiring good penetration.
- \* Welding of ductile and creep resistance steel, 0.5% Mo Steel.
- \* Welding of high strength pipelines with good notch toughness even at minus 46°C.

**RECOMMENDATIONS :**

Downhill travel is preferred for welding of pipes. Pre-heat interpass and post heating temperature between 95°C and 150°C should be employed 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	Mo
0.12 max	0.35-0.60 P 0.03max	0.35max S 0.03max	0.40-0.65

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

Yield Strength	Ultimate Tensile Strength	Elongation (GL=4d) (%)
N/mm <sup>2</sup> 420-470	N/mm <sup>2</sup> 520-570	22-29

**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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