DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM7010 Premium Electrode

Classification: **E7010**

AWS A 5.5 / ASME SFA 5.5

DuraMax DM7010 is ALL POSITION CELLULOSIC ELECTRODE

Characteristics

DM7010 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.

Features and Typical Applications

1) Light slag for minimal arc interference
2) Deep penetration
3) Clean, visible weld puddle
4) Superior puddle control
5) Recommended for welding API grades X46, X52 and X56 pipe.
6) Cross Country pipe lines.
7) In-plant pipes.

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Mo
0.12 max	0.60 max	0.40 max	0.030 max	0.030 max	0.40 - 0.65

All Weld Mechanical Properties

YS MPa	UTS MPa	EL %	CHARPY "V" NOTCH IMPACT AT @-29°C
440 - 510	540 - 580	22 - 30	35 - 43

Sizes available and recommended currents (DC +)

SIZE	3/32	1/8	5/32	3/16
AMPS	50 ~ 90	75 ~ 130	90 ~ 175	140 ~ 225

POLARITY: DCEP
DCEP: DC, Electrode Positive (reverse polarity) has the most weld penetration
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930