FLEXAL 70

OERLIKON

MMA Electrodes
C-Mn and low-alloy steels

Cellulosic coated electrode for welding girth seams of pipe lines, using the vertical-down technique. It is suitable for welding root passes, fill and cover passes.

Classification	
AWS	A5.5: E 7010-G
EN	499: E 42 2 C 21
EN ISO	2560-A: E 42 2 C 21

Approvals	Grades
ABS	
DNV	
LRS	
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.10	0.70	0.20	-	-	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
As Welded	≥ 420	500-640	≥ 24	≥ 47	-

Materials

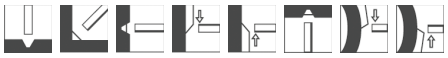
L210-L415, X42-X60

Storage and redrying

Do not re-dry

Current condition and welding position

DC+; DC-; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	50-70	16,2	10,3
3,2	350	80-120	26,7	18,0
4,0	350	110-150	40,0	26,4
5,0	350	140-200	60,0	41,8