

# JACKSUN XCEL710 P1

AN EXCELLENT ALL-POSITION, CELLULOSIC COATED  
ELECTRODE FOR HIGH YIELD PIPE WELDING

BASIC ALLOY: FE, MN, NI  
AWS/SFA-5.5: E 7010-P1  
EN ISO 2560-A E 46 3 C 25

## KEY FEATURES:

An excellent all-position electrode with cellulose coating provides good welder appeal and smooth arc characteristics. This electrode has been specially designed for high-yield pipeline steels. It delivers great arc stability and the best penetration possible when welding 5L, 5LX, and X52-X65 pipes.

## APPLICATIONS

- High-yield pipe steels
- Drill platforms
- Ship-building
- Storage tanks

## RE-DRY CONDITION:

- Not recommended

## CHEMICAL COMPOSITION:

| C    | Mn  | Si   | S     | P     | Ni   | Cr   | Mo   | V    |
|------|-----|------|-------|-------|------|------|------|------|
| 0.20 | 1.2 | 0.60 | 0.030 | 0.030 | 1.00 | 0.30 | 0.50 | 0.10 |

(Single value maximum)

## MECHANICAL PROPERTIES:

| YS (N/mm <sup>2</sup> ) | UTS (N/mm <sup>2</sup> ) | EL % (l=5d) | CHARPY "V" NOTCH<br>IMPACT AT |
|-------------------------|--------------------------|-------------|-------------------------------|
| 415 min.                | 490 min.                 | 22 min      | - 30°C : 27 J min             |

## WELDING POSITION



1G/1F



2G/2F



3G UP



3G DOWN



4G

## DIEMENSION, CURRENT CONDITION & PACKING DATA

| Size(mm)<br>(Dia) | Size(inch)<br>(Dia) | Current Condition<br>(DC+/AC) Amps | Kg./pkt. | KG/Case |
|-------------------|---------------------|------------------------------------|----------|---------|
| 2.50/ 2.40        | 3/ 32"              | 50-80                              | 5        | 20      |
| 3.15/ 3.20        | 1/ 8"               | 80-130                             | 5        | 20      |
| 4.00              | 5/ 32"              | 110-160                            | 5        | 20      |