PIPEWELD 8010 PLUS



Cellulosic coated electrode designed for low alloy steel. Deep penetration welding in all positions, especially designed for vertical down welding of high strength pipelines. Provides high economic benefits compared to welding vertical up. Recommended for welding pipe-lines of API 5LX: X60- X70.

Specifications	
Classifications	SFA/AWS A5.5 : E8010-P1 EN ISO 2560-A : E 46 2 Z C 21

Welding Current	DC+
Alloy Type	Low alloyed (0.3 % Ni, 0.25 % Mo)
Coating Type	Cellulosic covering

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	530 MPa (77 ksi)	620 MPa (90 ksi)	23 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	-30 °C (-22 °F)	40 J (30 ft-lb)

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.09	0.4	0.10	0.4	0.021	0.31

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
3.2 x 350 mm (1/8 x 13.8 in.)	65-120 A	30 V	62 %	86 sec	0.68 kg/h (1.5 lbs/h)
4.0 x 350 mm (5/32 x 13.8 in.)	90-180 A	29 V	68 %	84 sec	1.15 kg/h (2.5 lbs/h)