

# Pipelin<sup>®</sup> NR<sup>®</sup>-208-XP

## TOP FEATURES

- Vertical down hot, fill and cap pass welding of up to X80 grade pipe
- Capable of producing weld deposits with impact toughness exceeding 122 J at -40 °C
- ProTech<sup>®</sup> hermetically sealed packaging

## TYPICAL APPLICATIONS

- Hot, fill and cap pass welding of up to X80 grade pipe
- Cold temperature cross country pipe applications

## CLASSIFICATION

AWS E81T8-G  
E81T8-A4-K12

## CURRENT TYPE

DC-

## WELDING POSITIONS

All except vertical up

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Al	Ni
0.01-0.04	2.21-2.75	0.12-0.14	0.013	0.003	0.9-1.2	1.04-1.26

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-29 °C	-40 °C
Required: AWS A5.29		min. 470	550-690	min. 19	not specified	not specified
Typical values	AW	500-550	575-615	21-28	131-200	88-143

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.7	COIL	6.4	ED036650
2.0	COIL	6.4	ED031968

### TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.