PIPELINER® 7P+

Low Alloy, Cellulosic, Pipe · AWS E7010-P1

Key Features

- Q2 Lot® - Lot Controlled Chemistry and Mechanical Properties
- Meets NACE MR0175 for sour gas applications
- Test data available for SSC (NACE TM0177) & HIC (NACE TM0284)

Conformances

AWS A5.5: E7010-P1 , E7010-G

ABS: E7010-P1

ISO 2560-A: E 46 3 1Ni C 2 1

Welding Positions

Designed for vertical down welding of cross-country and in-plant pipe

Typical Applications

- Root pass welding of up to X80 grade pipe
- Hot, fill and cap pass of up to X65 grade pipe

DIAMETERS / PACKAGING

Diameter mm (in)	Length mm (in)	10 lb (4.5 kg) Easy-Open Can 30 lb (13.6 kg) Master Carton	50 lb (22.7 kg) Easy Open Can
3.2 (1/8)	350 (14)	ED032612	ED031611
4.0 (5/32)	350 (14)	ED032613	ED031612
5.0 (3/16)	350 (14)	ED032614	ED031613

MECHANICAL PROPERTIES[1] — *As Required per AWS A5.5*

	Yield Strength[2] MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf) @ -29°C (-20°F)	Charpy V-Notch J (ft-lbf) @ -40°C (-40°F)
Requirements - AWS E7010-P1	415 (60) min	490 (70) min	22 min	27 (20) min	Not Specified
Typical Results[3] - As-Welded	455-515 (66-75)	525-635 (76-92)	23-29	49-92 (36-68)	31-85 (23-63)

DEPOSIT COMPOSITION[1] — *As Required per AWS A5.5*

	%C	%Mn	%Si	%P	%S
Requirements - AWS E7010-P1	0.20 max	1.20 max	0.60 max	0.03 max	0.03 max
Typical Results[3] - As-Welded	0.09-0.20	0.44-0.83	0.06-0.31	0.01-0.02	0.01-0.02
	%Ni	**%Cr**	**%Mo**	**%V**	
Requirements - AWS E7010-P1	1.00 max	0.30 max	0.50 max	0.10 max	
Typical Results[3] - As-Welded	0.58-0.90	0.02-0.05	0.04-0.21	≤ 0.01	

TYPICAL OPERATING PROCEDURES

Polarity	Current (Amps) 3.2 mm (1/8 in)	4.0 mm (5/32 in)	5.0 mm (3/16 in)
DC+	65-130	100-165	130-210

[1]Typical all weld metal. [2]Measured with 0.2% offset. [3]See test results disclaimer
NOTE: This product contains micro-alloying elements. Additional information available upon request.

Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

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.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

Publication C1.100.8 | Issue Date 03/26
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