

# Pipelin<sup>®</sup> Arc 80

## Key Features

- Excellent impact properties without the micro alloying addition of Boron
- High productivity in vertical down and out of position pipe welding
- Deep penetration
- Q2 (3.1) Lot Certificates showing chemistry and mechanical properties available online

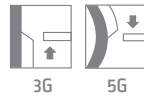
## Typical Applications

- Root pass welding up to X80 grade pipe
- Hot, fill and cap pass welding up to X70 grade pipe
- Meets NACE MR0175 for sour gas applications
- Test data available for SSC (NACE TM0177)

## Conformances

**AWS A5.5/A5.5M:** E8010-P1 / E8010-G

## Welding Positions



## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
4.0	350	ED034456	Easy Open Can 22.7kg
5.0	350	ED034457	

## Mechanical Properties - As Required per AWS A5.5 / A5.5M

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C	Charpy V-Notch J @ -45°C
<b>Requirements</b> - AWS E8010-P1	460 min	550 min	19 min	27 min	–
<b>Typical Results</b> - As Welded	460-540	550-650	19-29	51-114	34-93

## Deposit Composition

	%C	%Mn	%Si	%P	%S
<b>Typical Results</b> - As Welded	0.09-0.20	0.55-0.98	0.07-0.27	0.01-0.02	0.01-0.02
	%Ni	%Cr	%Mo	%V	%B
<b>Typical Results</b> - As Welded	0.73-1.00	0.02-0.05	0.13-0.22	0.01 max	0.0002 max

## Typical Operation Procedures

Polarity	Current (amps)	
	4.0mm	5.0mm
DC+	100-165	130-210