

Pipelin[®] 6P+

Key Features

- High operator appeal and control in vertical down welding
- Easy slag removal
- Q2 (3.1) Lot Certificates showing chemistry and mechanical properties available online
- The standard in the pipe welding industry
- Boron-free design

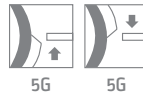
Conformances

AWS A5.1/A5.1M:	E6010
ABS:	E6010
DNV-GL:	3

Typical Applications

- Cross country and in-plant pipe welding
- Root pass welding up to X80 grade pipe
- Hot, fill and cap passes up to X60 grade pipe
- Meets NACE MR0175 for sour gas applications
- Test data available for SSC (NACE TM0177) & HIC (NACE TM0284)

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	ED030848	Easy Open Can 22.7kg
3.2	350	ED032610	Easy Open Can (EOC) 4.53 kg (3 x EOC per Carton)
4.0	350	ED030849	Easy Open Can 22.7kg

Mechanical Properties - As Required per AWS A5.1 / A5.1M

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
Requirements - AWS E6010	330 min	430 min	22 min	27 min
Typical Results - As Welded	405-515	495-620	22-36	27-85

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.11-0.20	0.51-0.77	0.15-0.32	0.006-0.016	0.005-0.011
	%Ni	%Cr	%Mo	%V	
Typical Results - As Welded	0.01-0.04	0.01-0.04	0.01-0.02	≤ 0.01	

Typical Operation Procedures

Polarity	Current (amps)	
	3.2mm	4.0mm
DC ±	75-135	100-175