

# Pipelinor® NR-207+

## Key Features

- Vertical down hot, fill and cap pass welding of up to X70 grade pipe
- Capable of producing weld deposits with impact toughness exceeding 27 J (20 ft-lbf) at -29°C [-20°F]
- Q2 Lot® - Certificate showing actual deposit chemistry and mechanical properties available online
- High deposition rates
- ProTech® hermetically sealed packaging

## Typical Applications

- Hot, fill and cap pass welding up to X70 grade pipe

## Conformances

**AWS A5.29/A5.29M: 2005** E71T8-K6

## Welding Positions



## Diameter / Packaging

Diameter mm	Part Number	Packaging
2.0	ED030924	Hermetically Sealed Pail 4 x 6.4kg

## Mechanical Properties - As Required per AWS A5.29 / A5.29M

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
<b>Requirements</b> - AWS E71T8-K6	400 min	490-620	20 min	27 min
<b>Typical Results</b> - As Welded	450-500	550-600	25-32	91-378

## Deposit Composition

	%C	%Mn	%Si	%P	%S	%Ni
<b>Typical Results</b> - As Welded	0.05-0.08	1.17-1.34	0.26-0.31	0.004-0.010	0.003 max.	0.72-0.91
	%Cr	%Mo	%V	%Al	%B	
<b>Typical Results</b> - As Welded	0.02-0.05	0.03 max.	0.005 max.	0.9-1.2	0.0007 Max.	

## Typical Operation Procedures

Diameter Polarity	CTWD mm	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
2.0mm DC-	19	70-130	18-21	210-305	2.0-3.7