

# Pipelin<sup>®</sup> 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<sup>®</sup> - Certificate showing actual deposit chemistry and mechanical properties available online
- High deposition rates
- ProTech<sup>®</sup> hermetically sealed packaging

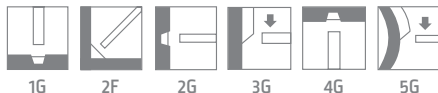
## Typical Applications

- 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<br>MPa | Tensile Strength<br>MPa | Elongation<br>% | Charpy V-Notch<br>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<br>Polarity | CTWD<br>mm | Wire Feed Speed<br>in/min | Voltage<br>volts | Current<br>amps | Deposition Rate<br>kg/hr |
|----------------------|------------|---------------------------|------------------|-----------------|--------------------------|
| 2.0mm DC-            | 19         | 70-130                    | 18-21            | 210-305         | 2.0-3.7                  |