

Fleetweld® 5P

Key Features

- Deep arc penetration
- Light slag with minimal arc interference
- Excellent vertical and overhead capability
- No deliberate addition of Boron

Typical Applications

- Steel with moderate surface contaminants
- Cross country and in-plant pipe welding
- Good for square edge butt welds
- Welding on galvanized and coated steels

Conformances

AWS A5.1/A5.1M: E6010

Lloyds Register: 3M

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.4	350	ED010211	Easy Open Can 22.7kg
3.2	350	ED010203	
4.0	350	ED010216	
4.8	350	ED010207	

Mechanical Properties - As required per AWS A5.1

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
Requirements - AWS	330 min	430 min	22 min	27 min
Typical Results - As Welded	420-475	515-570	25-31	41-68

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.09-0.17	0.40-0.63	0.09-0.43	0.005-0.017	0.005-0.014
	%Ni	%Cr	%Mo	%V	
Typical Results - As Welded	≤ 0.05	≤ 0.05	≤ 0.03	≤ 0.01	

Typical Operation Procedures

Polarity	Current (amps)			
	2.4mm	3.2mm	4.0mm	4.8mm
DC+	40-80	70-130	90-165	140-225
DC-	50-85	75-135	100-175	-