

PIPELINER ELECTRODE SELECTION GUIDE

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Products	AWS Classification	Low Strength				High Strength		
		<X60	X60	X65	X70	X80	X90	X100

MANUAL ELECTRODES

Stick (SMAW) Electrodes - Cellulosic

Pipeliners® 6P+, Fleetweld® 5P+®	E6010	R+F	R+F	R	R	R		
Pipeliners® 7P+	E7010-P1, E7010-G		R+F	R+F	R	R		
Pipeliners® 8P+, Pipeliners® Arc 80	E8010-P1, E8010-G		R+F	R+F	R+F	R		
Pipeliners® 80R	E8010-P1	R	R	R	R	R	R	R

Stick (SMAW) Electrodes - Basic, Low Hydrogen, Vertical Up

Pipeliners® 16P	E7016 H4	R+F	R	R	R	R	R	R
Excalibur® 8018-C3 MR®	E8018-C3 H4R		F	F	F			

Stick (SMAW) Electrodes - Basic, Low Hydrogen, Vertical Down

Pipeliners® LH-D80	E8045-P2 H4R		F	F	F			
Pipeliners® LH-D90	E9045-P2 H4R			F	F	F		
Pipeliners® LH-D100	E10045-P2 H4R				F	F	F	

SEMI-AUTOMATIC / AUTOMATIC

MIG (GMAW) Wires - Solid

Pipeliners® 70S-6	ER70S-6	R+F	R+F	R+F	R+F	R	R	R
Pipeliners® 80Ni1	ER80S-G		R+F	R+F	R+F	R+F	R	R

Flux-Cored (FCAW-S) Wires - Self-Shielded

Pipeliners® NR®-207+	E71T8-K6	F	F	F				
Pipeliners® NR®-208-P	E81T8-G		F	F	F			
Pipeliners® NR®-208-XP	E81T8-G		F	F	F			
Pipeliners® AutoShield® HW*	E91T8-G		F	F	F			

Flux-Cored (FCAW-G) Wires - Gas-Shielded

Pipeliners® 81M	E81T1-GM	F	F	F	F			
Pipeliners® 91M	E91T1-GM		F	F	F	F		
Pipeliners® 101M	E101T1-GM		F	F	F	F		
Pipeliners® 111M	E111T1-GM					F	F	F

R = Root Pass Only R+F = Root & Fill Passes F = Fill Pass Only

* Pipeliners AutoShield HW is currently only recommended for automatic welding