

# 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

Pipelinor® 6P+	E6010	R+F	R+F	R	R	R		
Pipelinor® 7P+	E7010-P1		R+F	R+F	R	R		
Pipelinor® 8P+	E8010-P1		R+F	R+F	R+F	R		

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

Pipelinor® 16P	E7016 H4	R	R	R	R	R	R	R
Pipelinor® 18P	E8018-G H4R		F	F	F			
Pipelinor® 19P	E10018-G H4R			F	F	F	F	

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

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

### SEMI-AUTOMATIC / AUTOMATIC

#### MIG (GMAW) Wires - Solid

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

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

Pipelinor® NR®-207+	E71T8-K6	F	F	F				
Pipelinor® NR®-208-P	E81T8-G		F	F	F			
Pipelinor® NR®-208-XP	E81T8-G		F	F	F			

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

Pipelinor® 81M	E81T1-GM	F	F	F	F			
Pipelinor® 101M	E101T1-GM		F	F	F	F		
Pipelinor® 111M	E111T1-GM					F	F	F

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