

Pipelin[®] NR-208-XP

Key Features

- Vertical down capability
- Capable of producing weld deposits with impact toughness exceeding 122J @ -40°C
- Q2 (3.1) Lot Certificates showing 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
- Cold temperature cross country pipe applications

Conformances

AWS A5.29/A5.29M: E81T8-G

Welding Positions



Diameter / Packaging

Diameter mm	Part Number	Packaging
1.7	ED036650	Hermetically Sealed Pail 4 x 6.4kg
2.0	ED031968	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 @ -40°C
Requirements - AWS E81T8-G	470 min	550-690	19 min	NS
Typical Results - As Welded	490-560	550-630	20-29	94-167

Deposit Composition

	%C	%Mn	%Si	%P	%S	%Ni
Typical Results - As Welded	0.01-0.03	2.21-2.56	0.12-0.15	0.006-0.015	0.003 max.	1.04-1.22
	%Cr	%Mo	%V	%Al	%B	
Typical Results - As Welded	0.04-0.07	0.02 max.	0.003 max.	0.7-1.2	0.0014 Max.	

Typical Operation Procedures

Diameter Polarity	CTWD mm	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.7mm DC-	19	70-150	16-22	165-250	1.1-2.5
2.0mm DC-	19	70-130	17-20	195-295	1.5-2.9