

Pipeliner[®] LH-D90

CLASSIFICATION

AWS A5.5	E9045-P2 H4R	A-Nr	10
ISO 18275-A	E 55 4 ZB 4 5 H5	F-Nr	4
		9606 FM	2

GENERAL DESCRIPTION

Basic covered low hydrogen electrode primarily designed for vertical down hot, fill and cap pass pipe welding
 Recommended for pipe grades up to and including API 5L Grade X80
 High deposition rates and excellent low temperature impact properties down to -46°C.
 Unique "hot start" tip helps initiate the arc and quickly establish puddle control
 Slag design allows for easy control of weld puddle

WELDING POSITIONS (ISO/ASME)



PG/3Gd



PJ/5Gd

CURRENT TYPE

AC / DC + / -

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Ni	Cr	Mo
0.05	1.30	0.5	0.009	0.009	0.25	0.05	0.2

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)		
				-29°C	-40°C	-46°C
Required: AWS A5.5 ISO 18275-A Typical values	min. 530 min. 550 575	min. 620 610-780 645	min. 17 min. 18 27	min. 27 95	min. 47	60
AW						

PACKAGING AND AVAILABLE SIZES

Metal can	Diameter (mm)	3.2	4.0
	Length (mm)	350	350
Net weight/unit (kg)	4.5	4.5	

Identification Imprint: LH-D90 Tip Color: none

Pipeliner[®] LH-D90: rev. C-EN24-01/02/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
Pipe material	
API 5LX	X65, X70, X80
EN 10208-2	L415 up to L555

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type
3.2x350	120-170	DC+
4.0x350	170-250	DC+
4.5x350	200-300	DC+

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions PJ/5Gdown
3.2	140-170A
4.0	180-240A
4.5	200-260A