Pipeliner® 16P

TOP FEATURES

- Excellent impact toughness down to -50°C
- Smooth, stable arc with excellent penetration
- Thin coating design enables easier access to narrow joints during root pass welding
- Meets NACE requirements
- Lot class 3.1 mechanical and chemical testing

TYPICAL APPLICATIONS

- Root pass welding of up to X100 grade pipe
- Hot, fill and cap pass welding up to X60
- Low hydrogen, vertical up capability on X60 grade pipe

CLASSIFICATION

AWS A5.1	E7016-1 H4
EN ISO 2560-A	E 42 5 B 1 2 H5

CURRENT TYPE

DC+; AC

(DC- could be used with 2.5mm for root pass)

WELDING POSITIONS

All positions

APPROVALS

ABS, LR, BV, DNV, RINA

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

C	Mn	Si	P	S
0.06	1.2	0.5	≤0.02	≤0.02

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -47/-50°C
AWS A5.1	AW	≥400	≥490	≥22	≥27
EN ISO 2560-A	AW	≥420	500-640	≥20	≥47
Typical values	AW	490	590	28	180
	PWHT 620°C/1h	420	620	22	110

AW = As welded, PWHT = Post Weld Heat Treatment

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-90
3.2 x 350	80-130
3.2 x 450	80-120
4.0 x 350	125-170
4.0 x 450	125-170
5.0 x 450	170-240

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	110	2.1	ED0372209
3.2 x 350	VPMD	65	2.0	ED0372210
3.2 x 450	VPMD	65	2.6	ED0372211
4.0 x 350	VPMD	45	2.1	ED0372212
4.0 x 450	VPMD	45	2.6	ED0372213
5.0 x 450	VPMD	45	2.1	ED0372214

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.