

Pipelin[®] NR[®]-208-P

TOP FEATURES

- Vertical down hot, fill and cap pass welding of up to X80 grade pipe
- Designed to meet 27 J (20 ft-lbf) @ 0°C (32°F) in pipe applications
- ProTech[®] hermetically sealed packaging
- Designed to accommodate applications requiring Nickel content of 1% max
- Excellent operator appeal for pipe applications

TYPICAL APPLICATIONS

- Hot, fill and cap pass welding of up to X80 grade pipe
- Warm weather cross country pipe welding applications

CLASSIFICATION

AWS E81T8-G

CURRENT TYPE

DC-

WELDING POSITIONS

All except vertical up

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

C	Mn	Si	P	S	Al	Ni	HDM
0.04-0.08	1.74-1.99	0.33-0.38	0.012-0.019	<0.010	0.9-1.2	0.65-0.95	8 ml/100g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -29°C
Required: AWS A5.29		min. 470	550-690	min. 19	not specified
Typical values	AW	480-520	600-630	24-30	50-100

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
2.0	COIL	6.4	ED032890

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.