

Pipeliner® 18P

CLASSIFICATION

AWS A5.5 : E8018-G-H4R
ISO 2560-A : E 50 6 Mn1Ni B 32 H5

GENERAL DESCRIPTION

Designed for vertical up fill and cap pass welding of welding of high strength pipe up to and including X70
Excellent low temperature impact properties down to -60°C
Square burnoff makes welding easier, especially in critical pipe welding applications

WELDING POSITIONS

ISO/ASME PA/1G PB/2F PC/2G PB/3G up PE/4G PF/5G up

CURRENT TYPE

AC / DC + / -

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

C	Mn	Si	P	S	Ni
0.05	1.5	0.5	0.010	0.009	0.95

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition		Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J)	
					-40°C	-60°C
Required: AWS A5.5		min. 460	min. 550	min. 19		
ISO 2560-A		min. 500	560-720	min. 18		min. 47
Typical values	AW	550	640	24	140	80

PACKAGING AND AVAILABLE SIZES

Unit: metal can	Diameter (mm)	3.2	4.0
	Length (mm)	350	350
	Pieces / unit	139	75
	Net weight/unit (kg)	4.2	4.0

Identification Imprint: 8018-G H4R PIPELINER 18P Tip Color: none

Pipeliner®18P: rev. EN 23

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
Fumes: Material Safety Data Sheets (MSDS) are available on our website.

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MATERIALS TO BE WELDED

Steel grades/Code	Type
Pipe material	
API 5LX	X 56, X60, X65, X70, X80
EN 10208-2	L360 up to L485

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (S)*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weld- metal B	kg electrodes/ kg weldmetal 1/N
3.2x350	80-145	DC+	66	220	1.2	37.7	48	1.79
4.0x350	120-185	DC+	77	355	1.6	54.1	29	1.59

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions					
	PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G	PF/5Gup
3.2	140A	120A	145A	120A	120A	120A
4.0	150A	140A	150A	140A	140A	140A

REMARKS / APPLICATION ADVICE

Preheating pipe material L360 - L485 (X56 - X70) required (acc. EN 1011-2).