Pipeliner® LH-D80

CLASSIFICATION

AWS A5.5	E8045-P2 H4R	**A-Nr**	1
ISO 2560-A	E 46 4 Z B 4 5 H5	**F-Nr**	4
		9606 FM	1/2

GENERAL DESCRIPTION

Specifically designed for vertical down
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 X70
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
0.05	1.15	0.45	0.009	0.009

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) -30°C	Impact ISO-V(J) -46°C
Required: AWS A5.5		min. 460	min. 550	min. 19	min. 27	
ISO 2560-A		min. 460	530-680	min. 20	min. 47	
Typical values	AW	490	580	27	80	50-95

PACKAGING AND AVAILABLE SIZES

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

Identification Imprint: LH-D80 8018-G Tip Color: none

Pipeliner® LH-D80: rev. C-EN23-01/02/16

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
Pipe material	
API 5LX	X60, X65, X70
EN 10208-2	L415 up to L485

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