

Fleetweld® 5P+

Key Features

- Standard in the pipe welding industry
- Reliable high ductility root welds
- High operator appeal and control
- No deliberate addition of Boron

Typical Applications

- Steel with moderate surface contaminants
- Cross country and in-plant pipe welding
- Repair welding

Conformances

AWS A5.1/A5.1M: E6010

Lloyds Register: 3M

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.4	300	ED032564	Easy Open Can (EOC) 4.53 kg (3 x EOC per Carton) Easy Open Can - 22.7kg
2.4	300	ED010283	
3.2	350	ED010278	
4.0	350	ED010285	
4.8	350	ED010281	

Mechanical Properties - As required per AWS A5.1

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
Requirements - AWS	330 min	430 min	22 min	27 min
Typical Results - As Welded	415-500	500-610	22-29	51-93

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.09-0.20	0.46-0.79	0.10-0.32	0.005-0.017	0.004-0.014
	%Ni	%Cr	%Mo	%V	
Typical Results - As Welded	≤ 0.04	≤ 0.04	≤ 0.02	≤ 0.01	

Typical Operation Procedures

Polarity	Current (amps)			
	2.4mm	3.2mm	4.0mm	4.8mm
DC+	50-85	75-135	100-175	140-225
DC-	50-85	75-135	100-175	-