Pipeliner® LH-D80

Key Features

- Low hydrogen, vertical down electrode
- High productivity (80% higher productivity over traditional vertical up pipe welding)
- Q2 (3.1) Lot certificates showing chemistry and mechanical properties available online
- Touch start tapered tip
- Meets H4R diffusible hydrogen level and moisture resistance
- Complies to NACE MR0175 for sour gas applications

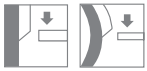
Typical Applications

- Fill and cap pass welding up to X70 grade pipe
- Pipe repair
- Hot tapping

Conformances

AWS A5.5/A5.5M: E8045-P2 H4R

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
4.0	350	ED032627	Easy Open Can (EOC) 4.53 kg (3 x EOC per Carton)
4.5	350	ED032628	Easy Open Can (EOC) 4.53 kg (3 x EOC per Carton)

Mechanical Properties - As Required per AWS A5.5 / A5.5M

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C	Charpy V-Notch J @ -40°C
Requirements - AWS E8045-P2	460 min	550 min	19 min	27 min	–
Typical Results - As Welded	470-530	560-590	26-30	54-163	27-147

Deposit Composition

	%C	%Mn	%Si	%P	%S	%Ni
Typical Results - As Welded	0.04-0.06	1.14-1.54	0.43-0.60	≤0.01	≤0.01	0.01-0.03
	%Cr	**%Mo**	**%V**	**%B**	**Diffusible Hydrogen** (ml/100g weld deposit)	
Typical Results - As Welded	0.03-0.05	≤0.02	0.01 max	0.005-0.008	2-4	

Typical Operation Procedures

Current (amps)		
Polarity	**4.0mm**	**4.5mm**
DC+	170-250	200-300