PIPELINER® LH-D100

Low Alloy, Low Hydrogen, Pipe ▪ AWS E10045-P2 H4R

KEY FEATURES

- Durable coating that does not break
- Easy to use with a controllable slag system
- 80% higher productivity over traditional vertical-up pipe welding
- Q2 Lot- Certificates showing actual deposit chemistry and mechanical properties available online

CONFORMANCES

AWS A5.5/A5.5M: 2006	E10045-P2 H4R
ASME SFA-A5.5:	E10045-P2 H4R
CWB/CSA W48-06:	E10045-P2 H4R

TYPICAL APPLICATIONS

- Fill and cap pass welding of up to X90 grade pipe
- Pipe repair
- Hot tapping

WELDING POSITIONS

Vertical Down

DIAMETERS / PACKAGING

Diameter mm (in)	Length in (mm)	10 lb (4.5 kg) Easy Open Can 30 lb (13.6 kg) Master Carton
3.2 (1/8)	14 (350)	ED032632
4.0 (5/32)	14 (350)	ED032633
4.5 (11/64)	14 (350)	ED032634

MECHANICAL PROPERTIES[1] – *As Required per AWS A5.5/A5.5M: 2006*

	Yield Strength[2] MPa (ksi)	Tensile Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft•lbf) @ -29°C (-20°F)	Charpy V-Notch J (ft•lbf) @ -46°C (-50°F)
Requirements - AWS E10045-P2 H4R	600 (87) min	690 (100) min	16 min	27 (20) min	Not Specified
Typical Results[3] - As-Welded	620-690 (90-100)	705-750 (102-109)	21-28	75-110 (55-81)	56-85 (41-63)

DEPOSIT COMPOSITION[1] – *As Required per AWS A5.5/A5.5M: 2006*

	%C	%Mn	%Si	%P	%S
Requirements - AWS E10045-P2 H4R	0.12 max	0.90 - 1.70	0.80 max	0.03 max	0.03 max
Typical Results[3] - As-Welded	0.04-0.06	1.25-1.65	0.35-0.55	≤ 0.01	≤ 0.01
	%Ni	**%Cr**	**%Mo**	**%V**	**Diffusible Hydrogen (mL/100g weld deposit)**
Requirements - AWS E10045-P2 H4R	1.00 max	0.20 max	0.50 max	0.05 max	4.0 max
Typical Results[3] - As-Welded	0.70-1.00	≤ 0.08	0.40-0.50	≤ 0.01	2-4

TYPICAL OPERATING PROCEDURES

	Current (Amps)		
Polarity	**3.2 mm(1/8 in)**	**4.0 mm (5/32 in)**	**4.5 mm (11/64 in)**
DC+	120-170	170-250	200-300

[1]Typical all weld metal. [2]Measured with 0.2% offset. [3]See test results disclaimer on next pg.
NOTE: This product contains micro-alloying elements. Additional information available on request.

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

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.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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