

# PIPELINER® 80R

Mild Steel - AWS A5.5 E8010-P1

## KEY FEATURES

- Same welding behavior as Fleetweld® 5P+ with a 80ksi strength
- Cross country and in-plant welding
- Deep arc penetration
- Light slag with minimal arc interference
- Q2 Lot® Control - Certificate showing actual deposit chemistry and mechanical properties per lot available online
- Excellent vertical and overhead capability

## CONFORMANCES

AWS A5.5: E8010-P1  
CWB: E5510-P1

## WELDING POSITIONS

All

## TYPICAL APPLICATIONS

- Root pass welding for X80 or higher
- Hot, fill and cap pass welding of up to X70 grade pipe

## DIAMETERS / PACKAGING

Diameter in (mm)	10lb (4.5kg) Easy Open Can
1/8 (3.2)	ED038209
5/32 (4.0)	ED038210

## MECHANICAL PROPERTIES

	Yield Strength MPa [ksi]	Tensile Strength MPa [ksi]	Elongation %	Charpy V-Notch J [ft-lbs] @-29°C [-20°F]
<b>Requirements</b> - AWS A5.5 E8010-P1	460 [67] min	550 [80] min	19 min	27 [20] min
<b>Typical Results</b> - As-Welded	610 [88]	500 [73]	28	64 [48]

## DEPOSIT COMPOSITION

	%C	%Mn	%Si	%P	%S	%Ni
<b>Requirements</b> - AWS E70C-6M H4	0.20 max	1.20 max	0.60 max	0.03 max	0.03 max	0.30 max
<b>Typical Results</b>	0.20	0.66	0.22	≤ 0.01	≤ 0.01	0.02
	%Cr	%Mo	%V	Other Total		
<b>Requirements</b> - AWS E70C-6M H4	0.30 max.	0.50 max.	0.10 max.	0.50 max.		
<b>Typical Results</b>	0.02	0.13	0	<0.50		

## TYPICAL OPERATING PROCEDURES

Polarity	Current (Amps) 1/8 in (3.2mm)
DC+	75-135
DC-	75-135

Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at [www.lincolnelectric.com](http://www.lincolnelectric.com)

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

#### 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.

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