

Pipelin[®] LH-D90

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

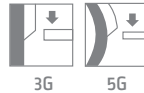
Typical Applications

- Fill and cap pass welding up to X80 grade pipe
- Pipe repair
- Hot tapping

Conformances

AWS A5.5/A5.5M: E9045-P2 H4R

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	ED032629	Easy Open Can (EOC) 4.53 kg (3 x EOC per Carton)
4.0	350	ED032630	
4.5	350	ED032631	

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 9045-P2	530 min	620 min	17 min	27 min.	–
Typical Results - As Welded	550-620	640-680	24-30	86-144	62-135

Deposit Composition

	%C	%Mn	%Si	%P	%S	%Ni
Typical Results - As Welded	0.05-0.07	1.21-1.40	0.40-0.60	≤0.01	≤0.01	0.25-0.30 ¹ / 0.80-1.00 ²
	%Cr	%Mo	%V	%B	Diffusible Hydrogen (ml/100g weld deposit)	
Typical Results - As Welded	0.03-0.04	0.18-0.22	≤0.01	0.003-0.005	2-4	

¹3.2mm diameter only | ²4.0mm and 4.5 mm

Typical Operation Procedures

Polarity	Current (amps)		
	3.2mm	4.0mm	4.5mm
DC+	120-170	170-250	200-300