

Pipeliner® LH-D100

CLASSIFICATION

AWS A5.5	E10045-P2 H4R	A-Nr	10
		F-Nr	4
		9606 FM	2

GENERAL DESCRIPTION

Basic covered low hydrogen electrode primarily designed for vertical down hot, fill and cap pass pipe welding
 Recommended for pipe grades up to and including API 5L Grade X90
 High deposition rates and excellent low temperature impact properties down to -46°C.
 Unique "hot start" tip helps initiate the arc and quickly establish puddle control
 Slag design allows for easy control of weld puddle

WELDING POSITIONS (ISO/ASME)



PG/3Gd



PJ/5Gd

CURRENT TYPE

AC / DC + / -

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Ni	Mo
0.05	1.55	0.45	0.009	0.009	0.9	0.45

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength [N/mm ²]	Tensile strength [N/mm ²]	Elongation [%]	Impact ISO-V(J)		
				-29°C	-46°C	
Required: AWS A5.5 Typical values	AW	min. 600 650	min. 690 730	min. 16 24	min. 27 100	70

PACKAGING AND AVAILABLE SIZES

Metal can	Diameter (mm) Length (mm)	Net weight/unit (kg)	
		3.2	4.0
		350	350
		4.5	4.5

Identification Imprint: LH-D100 10018-G Tip Color: none

Pipeliner® LH-D100: rev. C-EN24-01/02/16

Pipeliner® LH-D100

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
Pipe material	
API 5LX	X70, X80, X90
EN 10208-2	L415 up to L620

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type
3.2x350	120-170	DC+
4.0x350	170-250	DC+
4.5x350	200-300	DC+

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions PJ/5Gdown
3.2	20-170A
4.0	170-250A
4.5	200-300A