

Pipelin[®]er 7P+

Key Features

- High productivity in vertical down and out of position pipe welding
- Q2 (3.1) Lot certificates showing chemistry and mechanical properties available online
- Clean, visible weld puddle, deep penetration
- Superior puddle control

Typical Applications

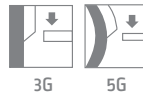
- Cross country and in-plant pipe welding
- Root pass welding up to X80 grade pipe
- Hot, fill and cap passes up to X65 grade pipe
- Meets NACE MR0175 for sour gas applications
- Test data available for SSC (NACE TM0177) & HIC (NACE TM0284)

Conformances

AWS A5.5/A5.5M: E7010-P1 / E7010G

ABS: E7010-P1

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	ED031611	Easy Open Can 22.7kg
4.0	350	ED031612	
5.0	350	ED031613	

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 E7010-P1	415 min	490 min	22 min	27 min	–
Typical Results - As Welded	460-540	560-660	22-32	54-110	37-103

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.11 - 0.18	0.50 - 0.88	0.10 - 0.40	0.01	0.01 max
	%Ni	%Cr	%Mo	%V	%B
Typical Results - As Welded	0.66 - 0.97	0.04 max	0.07 - 0.20	0.01	0.002

Typical Operation Procedures

Current (amps)			
Polarity	3.2mm	4.0mm	5.0mm
DC+	65-130	100-165	130-210