

Pipelinor® G70M-E

TOP FEATURES

- All positional rutile flux cored wire for mechanized and semi-automatic welding with increased deposition rate (kg/h)
- Designed for pipeline applications. Easy to remove slag reduces cleaning time and improves operating factor
- Concentrated and deeply penetrating arc helps to achieve optimal quality of welds
- Focused and clearly visible arc column offers easier welding and reduces operator training time
- Stable mechanical properties, CVN > 47J at -50°C
- Very low hydrogen (HDM <4 ml/100g) and long term resistance against moisture pick-up in vacuum sealed packaging

CLASSIFICATION

AWS A5.29 E81T1-GM-H4
EN ISO 17632-A T 50 5 Z P M 2 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ (>15-25%) CO₂
Flow rate 15-25 l/min

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

Shielding gas	C	Mn	Si	Ni	P	S	Mo
M21	0.06	1.5	0.2	0.95	0.013	0.010	0.15

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
						-20°C	-40°C	-50°C
Required: AWS A5.29			min. 470	550-690	min. 19			
EN ISO 17632-A			min. 500	560-720	min. 18			min. 47
Typical values	M21	AW	580	630	23	100	90	70

*AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	4.5	944252
	SPOOL (B300)	16.0	944238N

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

Safety Data Sheets (SDS) are available here:



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