

Pipelin[®] 8P+

Key Features

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

Typical Applications

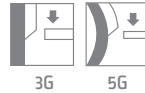
- Root pass welding up to X80 grade pipe
- Hot, fill and cap passes up to X70 grade pipe
- Meets NACE MR0175 for sour gas applications
- Test data available for SSC (NACE TM0177) & HIC (NACE TM0284)

Conformances

AWS A5.5/A5.5M: E8010-P1 / E8010-G

ABS: E8010-P1

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	ED030826	Easy Open Can 22.7kg
4.0	350	ED030827	
5.0	350	ED030828	

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 E8010-P1	460 min	550 min	19 min	27 min	–
Typical Results - As Welded	460-560	560-680	19-30	51-114	56-88

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.11-0.20	0.55-0.91	0.09-0.36	0.01 max	0.01 max
	%Ni	%Cr	%Mo	%V	%B
Typical Results - As Welded	0.60-1.00	0.01-0.05	0.09-0.21	0.02 max	0.002 max

Typical Operation Procedures

Polarity	Current (amps)		
	3.2mm	4.0mm	5.0mm
DC+	65-120	100-165	130-210