

# Pipelin<sup>®</sup> 7P+

## TOP FEATURES

- Root pass welding of up to X80 grade pipe.
- Hot, fill and cap pass of up to X65 grade pipe.
- Vertical down welding.
- Meets NACE MR0175 for sour gas applications.
- Test data available for SSC (NACE TM0177).
- Cellulosic electrode

## CLASSIFICATION

AWS A5.1 E7010-P1, also meets E7010-G

## CURRENT TYPE

DC+

## WELDING POSITIONS

All positions

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

C	Mn	Si	P	S	Ni	Mo
0.15	0.6	0.1	0.015	0.015	0.85	0.1

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-29°C	-40°C
Required: AWS A5.1		min. 415	min. 490	min. 22	27	
Typical values	AW	470	570	24	80	70

AW = As welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	65-130
4.0 x 350	100-165
5.0 x 450	130-210

## 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](http://www.lincolnelectric.eu) for any updated information.