Lincoln® 8010

TOP FEATURES

- Cellulosic coated MMA electrode for root and hot passes as well as filling and capping up to X80 Grade pipe
- Excellent weldability in all positions
- Designed for both DC+ and DC- current
- 3.1 tested batches to provide actual weld composition and mechanical properties

TYPICAL APPLICATIONS

- Pipeline

CLASSIFICATION

AWS A5.5	E8010-P1
	E8010-G
EN ISO 2560-A	E 46 3 1NiMo C 2 1

CURRENT TYPE

DC-; DC+

WELDING POSITIONS

All positions

APPROVALS

ABS, TÜV

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

C	Mn	Si	Ni	Mo
0.1	0.8	0.2	0.7	0.3

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)		Impact ISO-V (J)	
				4d	5d	-20°C	-30°C
AWS A5.5	AW or PWHT	≥460	≥550	≥19	-	-	≥27
EN ISO 2560-A	AW	≥460	530-680	-	≥20	-	≥47
Typical values	AW	540	615	25	23	77	69

AW = As welded, PWHT = Post Weld Heat Treatment

- = not specified

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	60-110
4.0 x 350	90-140
5.0 x 350	110-170

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	MCAN	355	9.5	627266
4.0 x 350	MCAN	238	9.5	627267
5.0 x 350	MCAN	156	9.5	627268

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.