

Lincoln® 8010

TOP FEATURES

- Cellulosic coated MMA electrode for root and hot passes as well as filling and capping up to X70 Grade pipe
- Excellent weldability in all positions
- Designed for both DC+ and DC- current
- Q2 lot controlled and tested 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	-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	530	610	27	23	≥60	77	68

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