

Pipelin[®] LH-D100

Key Features

- Low hydrogen, vertical down electrode
- High productivity (80% higher productivity over traditional vertical up pipe welding)
- Q2 (3.1) Lot certificates showing chemistry and mechanical properties available online
- Touch start tapered tip
- Meets H4R diffusible hydrogen level and moisture resistance

Typical Applications

- Fill and cap pass welding up to X90 grade pipe
- Pipe repair
- Hot tapping

Conformances

AWS A5.5/A5.5M: E10045-P2 H4R

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
4.0	350	ED032633	Easy Open Can (EOC) 4.53 kg (3 x EOC per Carton)
4.5	350	ED032634	

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 E10045-P2	600 min	690 min	16 min	27 min	—
Typical Results - As Welded	650-700	710-750	23-26	77-114	42-85

Deposit Composition

	%C	%Mn	%Si	%P	%S	%Ni
Typical Results - As Welded	0.05-0.06	1.44-1.67	0.42-0.56	≤0.01	≤0.01	0.78-0.89
	%Cr	%Mo	%V	%B	Diffusible Hydrogen (ml/100g weld deposit)	
Typical Results - As Welded	0.04-0.06	0.40-0.46	≤0.01	0.004-0.005	2-4	

Typical Operation Procedures

Current (amps)		
Polarity	4.0mm	4.5mm
DC+	170-250	200-300