

High strength cellulosic electrode

Classification

AWS A5.5 : E8010-P1
 ISO 2560-A : E 46 4 1Ni C 25

General description

Designed for vertical down welding of pipes up to and including X70
 Excellent resistance to porosity, X-ray quality welds
 High stacking efficiency: fill joints in fewer passes
 Exceptional mechanical properties

Welding positions



ISO/ASME PA/1G PB/2F PC/2G PF/3Gup PG/3Gdown PE/4G PF/5Gup PG/5Gdown

Current type

DC +

Approvals

ABS

+

Chemical composition (w%), typical, all weld metal

C	Mn	Si	Ni	Mo	P	S
0.17	0.7	0.25	0.8	0.2	0.01	0.01

Mechanical properties, typical, all weld metal

	Condition	0.2% Proof strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)		
					-29°C	-40°C	-46°C
Required: AWS A5.5		min. 460	min. 550	min. 19	27		
ISO 2560-A		min. 460	530-680	min. 20		min. 47	
Typical values	AW	460-559	550-676	20-27	62-99		46-84

Packaging and available sizes

Unit: Metal can	Diameter (mm)	3.2	4.0	5.0
	Length (mm)	350	350	350
Net weight/unit (kg)	4.5	4.5	4.5	

Identification Imprint: 8010-P1 PIPELINER 8P+

Tip Color: none

PIPELINER[®] 8P+: rev. EN 21