

EURO PIPE 8010

CLASSIFICATION:

AWS A-5.5 E 8010

DESCRIPTION AND APPLICATION:

Cellulose coated electrode for vertical down pipe welding higher strength pipe steels. Especially recommended for hot passes, filler and cover layers.

BASE MATERIALS:

API Spec 5L: Grade X56,X60, X65,X70

DIN 17172 : Grade StE 385.7(TM) , StE 415.7(TM) ,StE 455.7(TM) as well as the root pass upto

StE 550.7(TM)

COATING TYPE: Cellulosic

WELDING CURRENT: DC+,DC (-) (For root beads)

WELDING POSITIONS: ALL

REDRYING TEMP: Not permitted

TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition,wt %:

| Element | C | Mn | Si | Ni | Mo |
|---------|------|-----|-----|-----|------|
| percent | 0.14 | 0.7 | 0.2 | 0.6 | 0.40 |

Mechanical properties:

| Y.S. N/sq mm. | UTS N/sq mm | % Elongation | CVN Impact value |
|------------------|----------------|-----------------|---------------------|
| >460 | 550-650 | >20 | 70 J at(+20°C) |

RECOMMENDED CURRENT RANGES:

| SIZE mm | 2.50 X 350 | 3.25 X 350 | 4.00 X 350 | 5.00 X 350 |
|------------------|--------------|------------|------------|------------|
| CURRENT- Amps | DC+ 50-65 | 90-120 | 110-140 | 140-200 |