Product Data Sheet PIPEWELD 8010 PLUS

E 'Manual metal-arc welding'
ESAB S.A. Ind. E Comércio Brazil

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
A-C Thorsson	P-O Oskarsson	J-P Ernoult	EN007586	EN007365	2017-07-13	1 (2)

REASON FOR ISSUE

New EN designation.

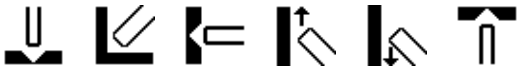
GENERAL

Cellulosic coated electrode designed for low alloy steel. Deep penetration welding in all positions, especially designed for vertical down welding of high strength pipelines. Provides high economic benefits compared to welding vertical up. Recommended for welding pipe-lines of API 5LX: X60- X70.

Polarity: DC+

Alloy Type: Low alloyed (0.3 % Ni, 0.25 % Mo)
Coating Type: Cellulosic covering

WELDING POSITIONS



1 2 3 4 5 6

CLASSIFICATIONS Electrode

SFA/AWS A5.5	E8010-P1
EN ISO 2560-A	E 46 2 Z C 21

APPROVALS

FBTS	E 8010-P1

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.05	0.12
Si	0.05	0.30
Mn	0.40	0.65
P		0.030
S		0.030
Cr		0.05
Ni	0.20	0.60
Mo	0.18	0.40
V		0.05

MECHANICAL PROPERTIES OF WELD METAL

	ISO		AWS	
	As welded		As welded	
Properties	**Min**	**Max**	**Min**	**Typ**
Rp0.2 (MPa)			460	530
ReL (MPa)	460			
Rm (MPa)	530	680	550	620
A4 (%)			19	23
A5 (%)	20			
Charpy V at -20°C (J)	47			
Charpy V at -30°C (J)			27	40

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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	N	B	H	T	U	Welding
Ø x Length	Min	Max								Positions
3.2 x 350	65	120	2.6	85	0.62	61	0.68	86	30	1,2,3,4,5,6
4.0 x 350	90	180	4	93	0.68	37	1.15	84	29	1,2,3,4,5,6
5.0 x 350	150	240	6.1	92	0.68	24	1.55	97	29	1,2,3,4,5,6

W = Weight (kg / 100 electrodes)
η = Efficiency (g weld metal x 100 / g core wire)
N = Effective value (kg weld metal / kg electrodes)
B = Changes (number of electrodes / kg weld metal)
H = Deposit rate at 90% of max current (kg weld metal / hour arc time)
T = Fusion time at 90% of max current (s / electrode)
U = Arc voltage (V)