

## PIPEWELD 8010 PLUS

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.

Specifications	
<b>Classifications</b>	SFA/AWS A5.5 : E8010-P1 EN ISO 2560-A : E 46 2 Z C 21
<b>Approvals</b>	FBTS : E 8010-P1

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Low alloyed (0.3 % Ni, 0.25 % Mo)
<b>Coating Type</b>	Cellulosic covering

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
As Welded	530 MPa	620 MPa	23 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
<b>AWS</b>		
As Welded	-30 °C	40 J

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 350.0 mm	65-120 A	30 V	62 %	86 sec	0.68 kg/h
4.0 x 350.0 mm	90-180 A	29 V	68 %	84 sec	1.15 kg/h
5.0 x 350.0 mm	150-240 A	29 V	68 %	97 sec	1.55 kg/h