

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

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

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	530 MPa (77 ksi)	620 MPa (90 ksi)	23 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-30 °C (-22 °F)	40 J (30 ft-lb)

Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
3.2 x 350.0 mm (1/8 x 13.8 in.)	65-120 A	30 V	62 %	86 sec	0.68 kg/h (1.5 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	90-180 A	29 V	68 %	84 sec	1.15 kg/h (2.5 lbs/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	150-240 A	29 V	68 %	97 sec	1.55 kg/h (3.4 lbs/h)