# PIPEWELD 9010 PLUS

Cellulosic coated electrode designed for low alloy steel. Deep penetration welding in all positions, especially in the vertical downward ; recommended for welding pipe-lines of API 5LX: X70- X80.

| Specifications | |
|---|---|
| **Classifications** | SFA/AWS A5.5 : E9010-P1<br>EN ISO 2560-A : E 50 2 1NiMo C 21 |
| **Approvals** | FBTS : E 9010-P1 |

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

| | |
|---|---|
| **Welding Current** | DC+ |
| **Alloy Type** | Low alloyed (0.9 % Ni, 0.4 % Mo) |
| **Coating Type** | Cellulosic covering |

| Typical Tensile Properties | | | |
|---|---|---|---|
| **Condition** | **Yield Strength** | **Tensile Strength** | **Elongation** |
| **AWS** | | | |
| As Welded | 620 MPa ( 90 ksi ) | 700 MPa ( 102 ksi ) | 22 % |

| Typical Charpy V-Notch Properties | | |
|---|---|---|
| **Condition** | **Testing Temperature** | **Impact Value** |
| **AWS** | | |
| As Welded | -30 °C ( -22 °F ) | 35 J ( 26 ft-lb ) |
| As Welded | -20 °C ( -4 °F ) | 60 J ( 44 ft-lb ) |

| Typical Weld Metal Analysis % | | | | |
|---|---|---|---|---|
| **C** | **Mn** | **Si** | **Ni** | **Mo** |
| 0.10 | 1.00 | 0.20 | 0.90 | 0.40 |

| 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 | 32 V | 63 % | 79 sec | 0.82 kg/h ( 1.8 lbs/h ) |
| 4.0 x 350.0 mm ( 5/32 x 13.8 in. ) | 90-180 A | 34 V | 63 % | 78 sec | 1.17 kg/h ( 2.6 lbs/h ) |
| 5.0 x 350.0 mm ( 0.197 x 13.8 in. ) | 150-240 A | 32 V | 63 % | 90 sec | 1.67 kg/h ( 3.7 lbs/h ) |