

PIPEWELD 80DH

A low hydrogen electrode of AWS E8045-P2 type specially designed for downhill welding circumferential joints in pipelines API 5L X52- X70. Suitable for root pass in higher strength steels subject to welding procedure qualification. The low hydrogen weld metal provides high notch toughness and excellent ductility to reduce the risk of cracking. The electrode has been specially designed to provide excellent striking properties and elimination of start porosity. Productivity is significantly higher than conventional low hydrogen electrodes for welding vertically up.

Tekniska data

Klassificeringar	SFA/AWS A5.5 : E8045-P2 H4R EN ISO 2560-A : E 46 4 B 45 H5
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Svetsström	DC+
Diffunderbart väte	< 4.0ml/100g
Legeringstyp	Carbon Manganese
Höjljtyp	Basic covering

Typiska mekaniska värden

Villkor	Sträckgräns	Brottgräns	Förlängning
ISO			
Helsvetsgods	530 MPa	620 MPa	27 %

Slagseghetsdata Charpy V

Villkor	Provningstemperatur	Slagseghet
ISO		
Helsvetsgods	-40 °C	80 J
Helsvetsgods	-30 °C	90 J

Svetsgodsanalys %

C	Mn	Si
0.07	1.25	0.5

Insmältningsdata

Diameter	Ström	Bågspänning	Verkningsgrad (%)	Smälttid per elektrod vid 90% av maxström	Insvetstal vid 90 % I max
2.5 x 350.0 mm	80-90 A	25 V	67 %	53 sec	1.0 kg/h
3.2 x 350.0 mm	110-150 A	26 V	68 %	53 sec	1.6 kg/h
4.0 x 350.0 mm	180-220 A	28 V	74 %	50 sec	2.8 kg/h
4.5 x 350.0 mm	180-280 A	28 V	71 %	50 sec	3.4 kg/h