

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 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

Tensile_Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	620 MPa	700 MPa	22 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
AWS		
As Welded	-30 °C	35 J
As Welded	-20 °C	60 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Mo
0.10	1.00	0.20	0.90	0.40

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
3.2 x 350.0 mm	65-120 A	32 V	63 %	79 sec	0.82 kg/h
4.0 x 350.0 mm	90-180 A	34 V	63 %	78 sec	1.17 kg/h
5.0 x 350.0 mm	150-240 A	32 V	63 %	90 sec	1.67 kg/h