Pipeweld 100DH

A low alloyed low hydrogen electrode of AWS 10018-G type specially designed for downhill welding circumferential joints in pipelines API 5L ,X80. 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.

Specifications	
Classifications	SFA/AWS A5.5 : E10018-G H4R EN ISO 18275-A : E 62 5 Z B 45 H5
Approvals	NAKS/HAKC : 3.2-4.5 mm

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

Welding Current	DC+
Diffusible Hydrogen	< 4.0 ml/100g
Alloy Type	Low alloyed
Coating Type	Basic

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	690 MPa	740 MPa	23 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	-50 °C	55 J

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**
0.06	1.89	0.39	1.58	0.03	0.01

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	110-150 A	27 V	67 %	53 sec	1.6 kg/h
4.0 x 350.0 mm	180-220 A	28 V	78 %	50 sec	2.8 kg/h
4.5 x 350.0 mm	230-270 A	28 V	71 %	50 sec	3.4 kg/h