



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.

Specifications				
Classifications	SFA/AWS A5.5 : E8045-P2 H4R			
	EN ISO 2560-A : E 46 4 B 45 H5			
Welding Current	DC+			
Diffusible Hydrogen	< 4.0ml/100g			
Alloy Type	Carbon Manganese			
Coating Type	Basic covering			

Typical Tensile Properties					
Condition Yield Strength Tensile Strength Elongation					
ISO					
As Welded	530 MPa	620 MPa	27 %		

Typical Charpy V-Notch Properties				
Condition	Testing Temperature	Impact Value		
ISO				
As Welded	-30 °C	L 06		
As Welded	-40 °C	80 J		

Typical Weld Metal Analysis %				
C	Mn	Si		
0.07	1.25	0.5		

Deposition Data						
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate	
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	