

Pipeweld 90DH

A low alloyed low hydrogen electrode of AWS E9045-P2 type specially designed for downhill welding circumferential joints in pipelines API 5L X70,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.

Tekniska data

Klassificeringar	SFA/AWS A5.5 : E9045-P2 H4R EN ISO 18275-A : E 55 6 Mn1Ni B 45 H5
Godkännanden	NAKS/HAKC : 3.2-4.5 mm

Godkännanden baseras på fabriksplats. Kontakta ESAB för mer information.

Svetsström	DC+
Diffunderbart väte	<4.0 ml/100g
Legeringstyp	Low alloyed
Höljtyp	Basic

Typiska mekaniska värden

Villkor	Sträckgräns	Brottgräns	Förlängning
ISO			
Helsvetsgods	590 MPa	670 MPa	24 %

Slagseghetsdata Charpy V

Villkor	Provningstemperatur	Slagseghet
ISO		
Helsvetsgods	-60 °C	50 J
Helsvetsgods	-30 °C	80 J

Svetsgodsanalys %

C	Mn	Si	Ni
0.07	1.5	0.5	0.8

Insmältningsdata

Diameter	Ström	Bågspänning	Verkningsgrad (%)	Smälttid per elektrod vid 90% av maxström	Insvetstal vid 90 % I max
2.5 x 350.0 mm	70-100 A	21 V	70 %	58 sec	1.0 kg/h
3.2 x 350.0 mm	110-150 A	21 V	68 %	56 sec	1.5 kg/h
4.0 x 350.0 mm	180-220 A	24 V	67 %	54 sec	2.3 kg/h
4.5 x 350.0 mm	210-270 A	24 V	68 %	54 sec	2.9 kg/h