

Sureweld 810P

Sureweld 810P is an all-position cellulosic electrode that is especially suited for welding high strength pipe. It produces the consistent, deep penetration required to maintain a proper keyhole when vertical-down welding in open root pipe joints. X-ray quality joints can be produced with Sureweld 810P using flat, horizontal, overhead, vertical-up, and vertical-down welding procedures. Sureweld 810P is recommended for welding API grades X60, X65, and X70 pipe.

Specifications	
Classifications	ASME SFA 5.5 : E8010-P1 AWS A5.5 : E8010-P1
Approvals	CWB : CSA 48.1 E41010

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

Welding Current	DC+
Alloy Type	Low alloyed (1 % Ni, 0.1 % Mo)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	501 MPa (73 ksi)	609 MPa (88 ksi)	24 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-30 °C (-22 °F)	42 J (31 ft-lb)
As Welded	-46 °C (-51 °F)	34 J (25 ft-lb)

Typical Weld Metal Analysis %						
C	Mn	Si	S	P	Ni	Mo
0.10	0.48	0.24	0.014	0.008	0.98	0.11