



# HILCO Pipeweld 8010

Stick electrodes - unalloyed steel - pipeline

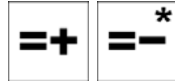
AWS A5.5: E 8010-P1

EN ISO 2560-A: E 46 4 1Ni C 25

**Coating type:**

Cellulose

**Arc voltage:** 70V

**Current:**

\*root pass

**Tip colour:**

-

**Welding positions:****Printing:**

E 8010-P1 / Pipeweld 8010

Pipeweld 8010 is our cellulose coated electrode for cross-country welding high-strength butt joints in API 5L pipe steels. The electrode is characterised by a deeply penetrating, forceful, spray type arc and readily removable slag. Typical application for Pipeweld 8010 is the welding of API 5L: X65 pipe steel. For root pass welding we recommend to use Pipeweld 6010. Electrodes are packed in metal cans to ensure moisture levels for proper operation.

**Base materials to be welded:**

- Pipe steel P235T1-P355N, L210-L485MB, S275ML-S460ML, X42-X70, TStE290-TstE445.7TM
- Root passes in pipe steel up to L550MB(NB), X80, StE550.7TM

**Applications:**

- Oil & Gas Industry

**Equivalent product in alternative welding process:**

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
-	K60	Hilcord 52	-	H100 / HW430	-

**Chemical composition, wt.% weld metal – typical:**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	V	Al
0,16	0,85	0,20	≤ 0,030	≤ 0,030		0,20					

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 460	≥ 550	≥ 20	-30°C ≥ 47

**Packaging and welding data:**

Dia. Mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
3,2	350	26,8	80-130
4,0	350	40,5	120-180
5,0	350	62,0	160-220