PipeMark 810

AWS A5.5 E8010-P1
EN ISO 2560-B-E5510-P1 A

Characteristics and Applications:

PipeMark 810 is a cellulose electrode for both vertical-down welding of high strength large diameter pipelines. It is excellent for root passes, hot passes, filler and cover layers, especially recommended for root pass welding. PipeMark 810 is designed for DCEP and DCEN welding. The welding in vertical down and all position can be done with stable arc, good slag detachability, and deep penetration. It is suitable for the welding of pressure pipes, oil tanks, and boilers.

Notes on usage:

1. Be sure to clean up the contaminations on the base metal.
2. Not allow to re-dry electrode

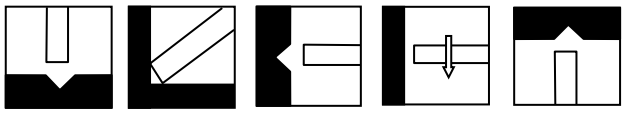
Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S
AWS	≦0.20	≦1.20	≦0.60	≦0.03	≦0.03
EN ISO	≦0.20	≦1.20	≦0.60	≦0.03	≦0.03
Typical value	0.13	1.0	0.10	0.015	0.01

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30°C (-20°F)
AWS	≧460(67)	≧550(80)	≧19	≧27(20)
EN ISO	≧460(67)	≧550(80)	≧17	≧27(20)
Typical value	550(80)	650(94)	22	41(30)

Welding position:



Sizes and recommended current range (DC＜±＞):

Diameter (mm)	2.4	2.6	3.2	4.0	4.8
Length (mm)	350		350	350	350
Amps	50-70		60-100	90-140	140-200

Base Materials:

EN: L415NB-L485NB, L415MB-L485MB

API 5 L: X56, X60, X65, X70

COVERED ELECTRODES

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