

## Stick electrode

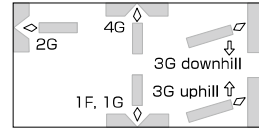
- Features:**
- Suitable for butt welding of pipes
  - Excellent usability in vertical downward welding

**Classification:** AWS A5.5 E8010-P1

**Identification color:** 1st Blue white

**Polarity:** DCEP

## Welding Positions:



## Packaging data

$\phi$ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	26	175W, 115H, 380L
4.0	350	5	20	40	175W, 115H, 380L
4.8	350	5	20	58	175W, 115H, 380L

## Composition (all-weld metal mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.15	0.20
<b>Si</b>	0.12	0.60
<b>Mn</b>	1.05	1.20
<b>P</b>	0.01	0.03
<b>S</b>	0.01	0.03
<b>Ni</b>	0.01	1.00
<b>Cr</b>	0.03	0.30
<b>Mo</b>	0.27	0.50
<b>V</b>	<0.01	0.10

## Welding parameters (A)

$\phi$ mm	1F, 1G, 2G	3G uphill, 4G	3G downhill
3.2	60~120	70~120	60~120
4.0	90~170	100~170	80~160
4.8	130~210	150~210	120~200

Note: <sup>a</sup> Single values are maximum.

## All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	520	462min.
<b>TS (MPa)</b>	620	552min.
<b>EI on 4d (%)</b>	28	19min.
<b>IV -29°C (J)</b>	54	27min.