PIPE WELDING ELECTRODES

Hobart Pipemaster Pro-60

Pipemaster Pro-60 is a quick-starting, cellulosic mild steel electrode that provides outstanding arc stability, penetration and wash-in. It is ideal for welding in all positions and produces an X-ray quality weld with light slag that is easy to remove. Pipemaster Pro-60 can be used to weld the following API 5L steels: Grade A, B, X-42, X-46, X-52, X-56 and for the root pass on material up to X-80. It features enhanced weldability and increased mechanical properties.

Classifications		
AWS	A5.1	E6010
EN	2560	E 38 3 C 21

Approvals
American Bureau of Shipping Grade 3,3Y
Lloyds Register of Shipping Grade 3,3Y,No

Typical Chemical Analysis (All weld metal)			
% Carbon	0,08	**% Silicon**	0,15
% Manganese	0,45		

Typical Mechanical Properties (All weld metal in the as welded condition)	
Yield Strength	413 MPa
Tensile Strength	496 MPa
% Elongation on 5d	27
Charpy V-Notch at -29°C	68 J

Typical Current Values and Deposition Data (AC 50 OCV min or DC+/-)		
Diameter (mm)	**Current (A)**	**Deposition Rates (kg/hr)**
2,4	40 - 70	0,6
3,2	65 - 130	0,7
4,0	90 - 175	0,9

Packing Data		
Diameter (mm)	**Hermetically Sealed Steel Can (kg)**	**Item Number**
2,4	22,7	W075172
3,2	22,7	W075173
4,0	22,7	W075174

Hobart Pipemaster Pro-70

Pipemaster Pro-70 is a quick-starting, cellulosic mild steel electrode that provides outstanding arc stability, penetration and wash-in. It is ideal for welding in all positions and produces an X-ray quality weld with light slag that is easy to remove. Pipemaster Pro-70 is ideal for vertical down welding on API 5L, 5LX and X-56 through X-65 pipes. It features enhanced weldability and increased mechanical properties.

Classifications		
AWS	A5.5	E7010-P1
EN	2560	E 42 3 Mo C Z 1

Approvals
American Bureau of Shipping Grade 3,3Y
Lloyds Register of Shipping Grade 3,3Y,No

Typical Chemical Analysis (All weld metal)			
% Carbon	0,1	**% Phosphorous**	0,01
% Manganese	0,5	**% Sulphur**	0,01
% Silicon	0,1	**% Nickel**	0,05
% Molybdenum	0,3	**% Chromium**	0,02

Typical Mechanical Properties (All weld metal in the as welded condition)	
Yield Strength	482 MPa
Tensile Strength	579 MPa
% Elongation on 5d	25
Charpy V-Notch at -29°C	48 J

Typical Current Values and Deposition Data (DC+ only)		
Diameter (mm)	**Current (A)**	**Deposition Rates (kg/hr)**
3,2	70 - 140	0,9
4,0	80 - 190	1,2
4,8	120 - 230	1,7

Packing Data		
Diameter (mm)	**Hermetically Sealed Steel Can (kg)**	**Item Number**
3,2	22,7	W075163
4,0	22,7	W075164
4,8	22,7	W075165