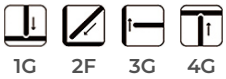
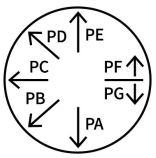
S-8010.P1

Classification

AWS A5.5/ASME SFA-5.5 E8010-P1
EN ISO 2560-A E46 2 ZNi C 2 1

Welding Positions





Features

- S-8010.P1 is a high cellulose type electrode for welding with direct current.
- Vertical downward welding can be performed easily
- Suitable for all position welding of pipes
- Deep penetration and fast freezing

Polarity

AC or DC +

Application Areas

- Root pass welding for pipeline
- General fabrication

Redrying Conditions

70~100°C (158~212°F) X 0.5~1hr

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.17	0.25	0.80	0.017	0.005	0.66	0.04	0.01	0.01

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
499(72)	613(89)	26	-30(-20)	47(35)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
3.2 (1/8)	350 (14)	75~120	65~115	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
4.0 (5/32)	350 (14)	90~165	90~145	
5.0 (3/16)	350 (14)	140~220	125~185	