

PRODUCT DATA SHEET

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-PI
EN	2560	E 42 3 Mo C Z I

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

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