

# PRODUCT DATA SHEET

## Pipemaster Pro-80



Pipemaster Pro-80 is a quick-starting, cellulosic mild steel electrode that provides the best possible 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-80 is ideal for vertical down welding on X-56 through X-70 pipes as well as pipe steels with silicon content of up to 0,3. It features enhanced weldability.

### Classifications

AWS	A5.5	E8010-PI
EN	2560	E46 2 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	0,13	% Phosphorous	0,01
% Manganese	0,53	% Sulphur	0,01
% Silicon	0,12	% Nickel	0,05
% Molybdenum	0,35	% Chromium	0,03

### Typical Mechanical Properties (All weld metal in the as welded condition)

Yield Strength	499 MPa
Tensile Strength	592 MPa
% Elongation on 5d	23
Charpy V-Notch at -29°C	43 J

### Typical Current Values and Deposition Data (DC+ only)

Diameter (mm)	Current (A)	Deposition rates (kg/hr)
3,2	70 - 140	0,8
4,0	80 - 190	1,2
4,8	130 - 240	1,6

### Packing Data

Diameter (mm)	Hermetically Sealed Steel Can (kg)	Item Number
3,2	22,7	W078023
4,0	22,7	W078024
4,8	22,7	W078025

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For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02  
E-mail: [customer.service@afrox.linde.com](mailto:customer.service@afrox.linde.com) Website: [www.afrox.com](http://www.afrox.com)

