

# PIPE WELDING ELECTRODES

## Section 12 - Welding Consumables

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## 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
4,8	140 - 225	1,2

## 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