KOBE-8010S FAMILIARC™

Stick electrode

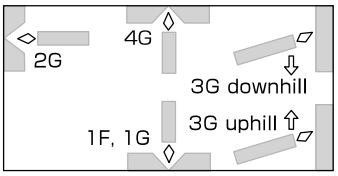
Features:
- Suitable for butt welding of pipes
- Excellent usability in vertical downward welding

Classification: AWS A5.5 E8010-P1

Identification color: 1st Blue white

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	26	175W, 115H, 380L
4.0	350	5	20	40	175W, 115H, 380L
4.8	350	5	20	58	175W, 115H, 380L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.15	0.20
Si	0.12	0.60
Mn	1.05	1.20
P	0.01	0.03
S	0.01	0.03
Ni	0.01	1.00
Cr	0.03	0.30
Mo	0.27	0.50
V	<0.01	0.10

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2G	3G uphill, 4G	3G downhill
3.2	60~120	70~120	60~120
4.0	90~170	100~170	80~160
4.8	130~210	150~210	120~200

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	520	462min.
TS (MPa)	620	552min.
El on 4d (%)	28	19min.
IV -29℃ (J)	54	27min.