

FOR HIGH TENSILE  
STRENGTH STEEL

AWS E8010-G

# K-8010G

## Typical applications

Welding of 540N/mm<sup>2</sup> class high tensile strength steel for butt welding of pipes.

## Coating

High cellulose sodium type.

## Characteristics on Usage

- ① This electrode is characterized by deeply penetrating, forceful, spray type arc.
- ② Readily removable, thin friable slag
- ③ This electrode is capable of welding in the vertical position with either uphill or downhill progression
- ④ The electrode has been designed for use with DCEP.(Reverse polarity)

## Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Ni	Mo
0.10	0.60	0.93	0.42	0.35

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	Charpy V-notch J {kgf · m} (-29°C)
520 {53}	610 {62}	24	45 {5}

## Sizes available and recommended currents (DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	350	350
Amp.	F	50~80	70~110	110~150	160~200
	V&OH	40~70	60~110	90~130	140~170

## Welding positions



Approved by