Fleetweld® 5P+

TOP FEATURES

- Deep arc penetration
- Light slag with minimal arc interference
- Excellent vertical and overhead capability

TYPICAL APPLICATIONS

- Cross country and in-plant pipe welding
- Steel with moderate surface contaminants
- Square edge butt welds
- Welding on galvanized and specially coated steels

CLASSIFICATION

AWS A5.1 E6010

CURRENT TYPE

DC +

WELDING POSITIONS

All

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si
0.20	0.56	0.17

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -29°C/-30°C
Required: AWS A5.1	AW	min. 330	min. 430	min. 22	min. 27
EN ISO		min. 420	500-640	min. 20	min. 47
Typical values		471	586	24	56

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x300	40-70
3.2x350	65-130
4.0x350	90-175
5.0x350	140-225

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Pieces / unit	Weight (kg)	Item number
2.4x300	CAN CAN	- -	4.5 22.7	ED032564 ED010283
3.2x350	CAN CAN	- -	4.5 22.7	ED032565 ED010278
3.2x450	CAN	-	22.0	3060272
4.0x350	CAN CAN	- -	4.5 22.7	ED032566 ED010285
4.0x450	CAN CAN	- -	22.0 23.0	3060271 3060273
4.8x350	CAN	-	22.7	ED010281
4.8x450	CAN	-	24.0	3060274

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:

Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.