

# Inweld 8010-G

AWS A5.5 E8010-G

## Chemical Composition of Inweld 8010-G

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
Balance	0.20	0.30	1.00	0.50	1.20	0.60	0.03	0.03	---	---

## Description and Applications

Inweld E8010-G is a deep penetrating, high silicon spray arc electrode for welding high strength pipe joints in vertical up or vertical down welding applications. Inweld 8010-G achieves full penetration, X-Ray quality weld deposits and yield strengths greater than 80,000 psi which is necessary for high silicon pipeline applications. Has superior weld puddle control and light slag. Typical pipeline assemblies include API 5LX-56 through X-70 grade pipe and sheet metal applications.

Instructions - Clean the weld area of all contaminants. Bevel heavy sections to a 60 "V". For best results and if at all possible, preheat thicker pipes at 300-500°F. Always use this electrode with DC+ (reverse polarity). Set your amperage to the proper range for the size electrode you are using, maintain a short arc length and hold the electrode at a 15° angle in the direction of travel. Weaving technique should be used but do not exceed 3 times the diameter of the electrode. Do not use the whipping technique as this will cause porosity in the weld deposit. Allow to air cool slowly before removing slags.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	80,000 ksi
Yield Strength:	67,000 ksi
Elongation:	19%
Charpy V-Notch at -20°F:	81 ft-lbs

## Recommended Parameters

SMAW (DCEP)

<u>Wire Diameter</u>	<u>Flat Amperage</u>	<u>Vertical &amp; Overhead Amperage</u>
5/32"	120-160	110-150
3/16"	160-200	130-170

Arc Length: Very short arc, Flat use 15° angle from 90°, Vertical up & Overhead use weaving techniques within puddle

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