DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM8010G Premium Electrode

Classification: **E8010G**

AWS A 5.5 / ASME SFA 5.5

DuraMax DM8010G is a All Position Cellulosic Coated Electrode for High Strength Pipe Welding

Characteristics

High Cellulose coating electrode for high strength pipe welding, it is showing an increase in deposition rates with both welding techniques. Electrodes gives smooth and stable Arc with good penetration and very low spatter loss and very easily removable slag.
Manganese value maintain at high level for the obtaining of good Impact values at subzero temperature with high tensile strength.

Typical Applications on Usage

1) Welding of high strength pipeline steels.
2) Welding suitable for use in root, filling and capping runs in API 5LX60 to 5LX70 grade line pipe.

RE-DRY CONDITIONS: Not Recommended

All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.20 max	1.0 *	0.80 *	0.030 max	0.030 max	0.50 *	0.30 *	0.20 *	0.10 *

* The undiluted weld metal shall have minimum of at least one of the element as mentioned above

All Weld Mechanical Properties

YS (N/mm²)	UTS (N/mm²)	EL % (1=4d)	CHARPY "V" NOTCH IMPACT AT
460 Min	550 Min	19 Min	Minus -30°C : 50 -80 J

(Single values are minimum)

Sizes available and recommended currents (DC +)

SIZE	3/32	1/8	5/32
AMPS	50 ~ 80	80 ~ 130	110 ~ 160

POLARITY: DCEP = DC, Electrode Positive (reverse polarity) has the most weld penetration.
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930