Recommended maximum weave width is 2X diameter of electrode.

**WEAVE WIDTH**

Electrode diameter

**WEAVING**: Recommended maximum weave width is 2X diameter of electrode.

**STARTING THE ARC**

Touch start tapered tip in weld crater.

**BEAD CONTOUR**

WRONG

Narrow gap

RIGHT

Correct gap

**BREAKING THE ARC**

RIGHT  WRONG
Pipeliner® LH-D80, LH-D90 and LH-D100 are low hydrogen, high deposition electrodes specially designed for the vertical down welding of pipe. They are recommended for fill and cap pass welding of up to X70, X80 and X90 pipe, as well as pipe repair and hot tapping applications. For low diffusible hydrogen, high productivity and operator appeal — choose Pipeliner® LH-D electrodes.

Use Recommended Starting and Stopping Techniques
Porosity can be the result of incorrect starting or stopping techniques. Refer to Diagram #2 and #5 on opposite side.

Make Sure Operating Procedures are Correct
Pipeliner® LH-D electrodes recommended operating ranges are in the table below.

<table>
<thead>
<tr>
<th>Polarity</th>
<th>3.2 mm (1/8 in.)</th>
<th>4.0 mm (5/32 in.)</th>
<th>4.5 mm (11/64 in.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>DC+</td>
<td>120 - 170</td>
<td>170 - 250</td>
<td>200 - 300</td>
</tr>
</tbody>
</table>

Do Not Re-Strike Electrode
If arc does not initiate on first try, discard electrode and start with a new one.

Technique Tips for Weld Positions
12 o’clock Decreased current and rod angle will reduce spatter.
3 o’clock Increased current will help hold weld puddle up.
6 o’clock A push angle and weave will help flatten bead.

Use the Recommended Weaving Technique
Weaving too wide can cause undercutting and slag entrapment. Use a maximum weave width of approximately 2 times electrode diameter. Refer to Diagram #3 on opposite side for directions.

Use a Lincoln Electric Recommended Power Source
Use a Lincoln Electric power source with output capability to run at recommended operating procedures (120 - 300 Amps DC+). We have evaluated and recommend the following machines:
- Vantage® 300
- Vantage® 400
- Vantage® 500
- Classic® 300D
- SAE-400
- Ranger® 305D
- Ranger® 305G
- Invertec® V350 PRO