

# Pipeliner<sup>®</sup> NR<sup>®</sup> -207+

## CLASSIFICATION

AWS A5.29 : E71T8-K6

## GENERAL DESCRIPTION

Optimum performance on vertical down hot, fill and cap pass welding in pipe steels such as API 5L X42 through X70  
 Self-shielded, flux cored. No need for external gas or flux  
 Produces quality welds in moderate wind conditions with no tenting  
 Superior arc characteristics and feedability  
 Very good crack resistance, CTOD and Charpy-V impact properties.

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PG/3Gd



PE/4G



PJ/5Gd

## CURRENT TYPE

DC -

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Ni	Al
0.05	1.22	0.25	0.01	0.01	0.82	1.1

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition		Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) -29°C
Required: AWS A5.29	AW	min. 400	485-620	min. 20	min. 27
Typical values		435	545	30	

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	2.0
Unit : 6.35 kg coil 14C	X

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## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
<b>Pipe material</b>	
API 5LX	X42, X46, X52, X56, X60, X65, X70
EN 10208-2	L290 up to L485

## CALCULATION DATA

Diameter (mm)	Electrical stick- out (mm)	Wire Feed Speed (cm/min)	Current (A)	Arc Voltage (V)	Deposition rate (kg/h)
2.0	19	170-330	210-305	18-21	2.0-3.7