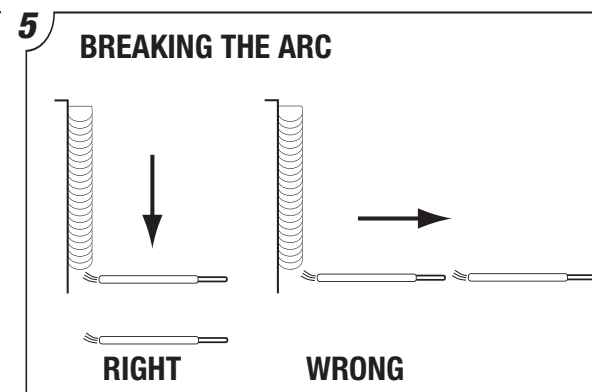
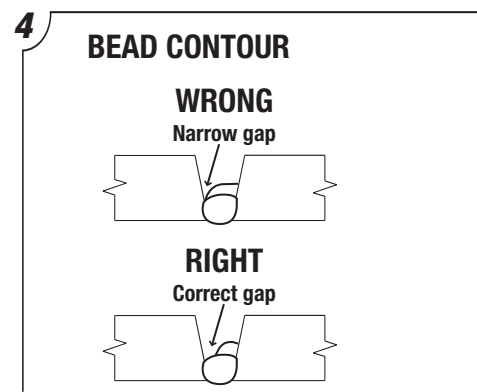
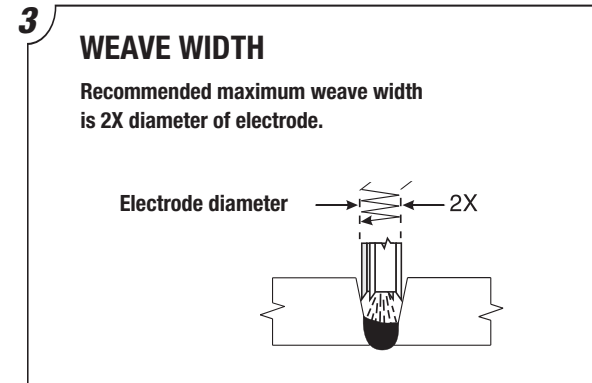
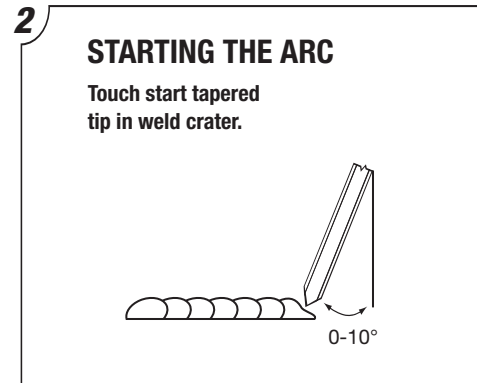
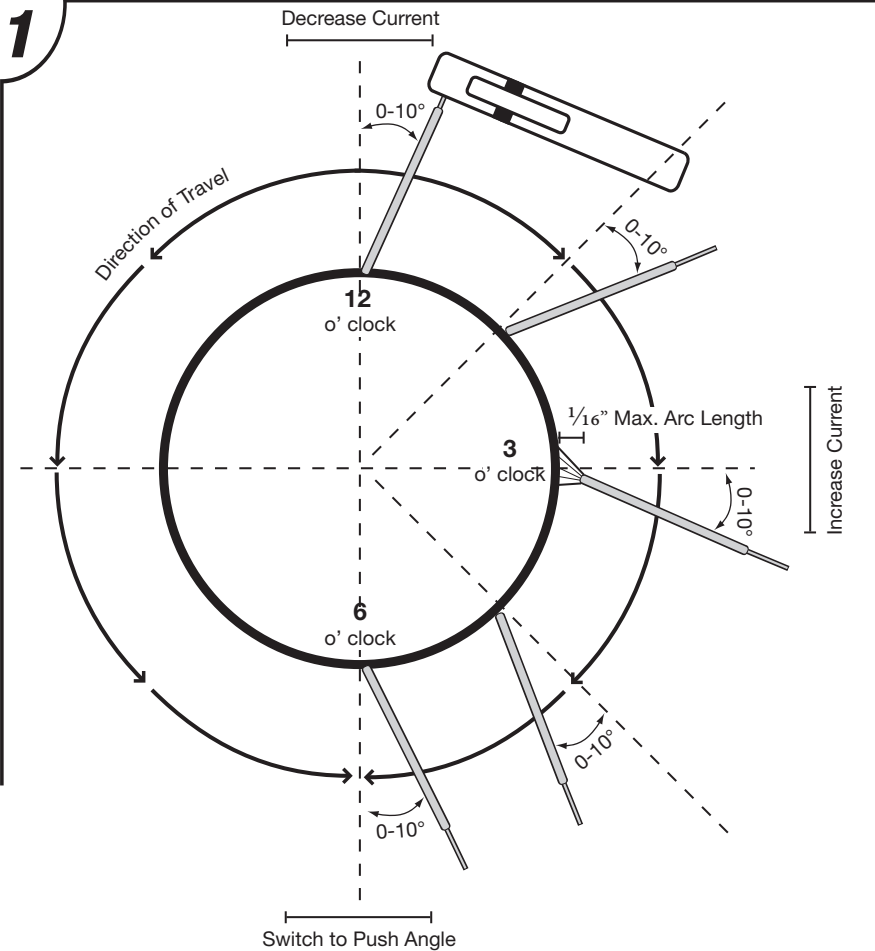


# PIPELINER®

## LH-D80/90/100

### WELDING GUIDELINES



## *Pipeliner® LH-D Welding – Helpful Hints*

**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.

<i>TYPICAL OPERATING PROCEDURES</i>			
Polarity	Current (Amps)		
	3.2 mm (1/8 in.)	4.0 mm (5/32 in.)	4.5 mm (11/64 in.)
DC+	120 - 170	170 - 250	200 - 300

### **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



**PIPELINER®**



Vantage® 500