ESC 80G

High Strength Cellulosic Electrode for Pipe Welding – **AWS/ASME SFA 5.5 E8010-G**

Key Benefits

- Medium coated and Ni (nickel) alloyed cellulosic type electrode
- Due to its high penetration, it is suitable for root pass and fill passes in the vertical down direction.
- DCEN (-) is ideal in root passes and DCEP (+) is recommended for fill and cap passes in vertical down position.

Welding Positions

Typical Applications

- Suitable for welding high strength steels, micro alloyed and low alloyed steels and pipes.
- Well-suited for welding high strength unalloyed and low alloy steels in shipbuilding, storage vessels, boilers, pipe-line constructions and assembly works.

Chemical Analysis

	%C	%Mn	%Si	%S	%P
Typical Wire Composition	0.10	0.80	0.20		
Typical Wire Composition	**%Cr**	**%Ni** 0.90	**%Mo**	**%Cu**	**%Other**

Mechanical Properties

	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elongation (%)	Impact Energy (J)
Typical Results (all weld metal) As Welded	500 MPa	570 MPa	24	-20C → 60J -30C → 50J

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Ordering Information

Product Code	Product (AWS Specification)	Dimension mm/inches	Single Pack Weight kg/lb	Box Weight kg/lb
1148110M15	ESC 80G (E8010-G)	2.50 x 350 mm (3/32" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1148116M15	ESC 80G (E8010-G)	3.25 x 350 mm (1/8" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1148120M15	ESC 80G (E8010-G)	4.0 x 350 mm (5/32" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)
1148128M15	ESC 80G (E8010-G)	5.0 x 350 mm (3/16" x 14")	5.0 kg (11.0 lb)	15.0 kg (33.0 lb)

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