

FLEXAL 80

TOP FEATURES

- Excellent weldability in all position
- Used for root and hot passes as well as filling and capping up to X70 grades
- Clearly visible weld puddle for improved control and weldability
- Shall be used in DC+ or DC- current.

TYPICAL APPLICATIONS

- Pipeline

CLASSIFICATION

AWS	E8010-G
EN ISO 2560-A	E 46 3 1NiMo C 21

CURRENT TYPE

DC-/+

WELDING POSITIONS

All positions

APPROVALS

ABS	LR	DNV	TÜV
+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Ni	Mo
0.1	0.8	0.2	0.7	0.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition*		Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					+20°C	-20°C	-30°C
AWS A5.5	AW or PWHT	≥460	≥550	≥19	not specified	not specified	not specified
EN ISO 2560-A	AW	≥460	530-680	≥20	not specified	not specified	≥47
Typical values	AW	530	610	23	≥60	77	68

* AW = As welded, PWHT = Post Weld Heat Treatment

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2x350	60-110
4.0x350	90-140
5.0x350	110-170

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
4.0 x 350	MCAN	238	9.5	W000287267
5.0 x 350	MCAN	156	9.5	W000287268

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.