

**Fleetweld® 5P+****CLASSIFICATION**

AWS A5.1 : E6010  
 ISO 2560-A : E 42 3 C 25

**GENERAL DESCRIPTION**

Cellulosic coated electrode for pipe and general welding  
 Gives high ductility root welds  
 Very deep penetration ensures sound root pass  
 Easy striking, easy slag release  
 High volume of generated gas eliminates porosity  
 Reduces problems from dirt and oil on surface

**WELDING POSITIONS**

PF/5G up



PG/5G down

ISO/ASME

**CURRENT TYPE**

DC +

**APPROVALS**

LR TÜV  
 3 +

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

C	Mn	Si
0.15	0.50	0.25

**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)		
					-20°C	-29°C	-30°C
Required: AWS A5.1 ISO 2560-A	AW	min. 331 min. 420	min. 414 500-640	min. 22 min. 20		27	
Typical values		440	520	26	70		47 65

**PACKAGING AND AVAILABLE SIZES**

	Diameter (mm)	Length (mm)	Available diameters			
			2.5	3.2	4.0	5.0
Unit: Linc Can	Pieces / unit	304	180	130	83	
	Net weight/unit (kg)	5.0	4.9	5.1	5.1	

Identification Imprint: 6010-FW5P+ Tip Color: none

Fleetweld® 5P+: rev. EN 23

# Fleetweld® 5P+

## MATERIALS TO BE WELDED

Steel grades/Code	Type
<b>Pipe material</b>	
EN 10208-1	L 210, L 240
EN 10208-2	L 240, L 290, L 360
EN 10216-1 / 10217-1	P 235, P 275, P 355
API 5LX	X42, X46, X52
Gaz de France	X42, X46, X52

## CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time		Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
			- per electrode at max. current - (S)*	Energy E(kJ)				
2.5x355	40-70	DC+				15.8		
3.2x355	65-130	DC+				26.2		
4.0x350	90-175	DC+				40.0		
5.0x350	140-225	DC+				61.5		

\*Stub end 35mm

## WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions	
	PF/5G up	PG/5G down
2.5	55A	65A
3.2	90A	110A
4.0	130A	150A
5.0	150A	165A

## REMARKS / APPLICATION ADVICE

Preheating pipe material L360 (X52) required (acc. EN 1011-1)

Pipeclamps to be removed after finishing root pass, start welding hot pass (within 5 min) after root pass

Use electrodes directly from metal cans