

# PROLINE

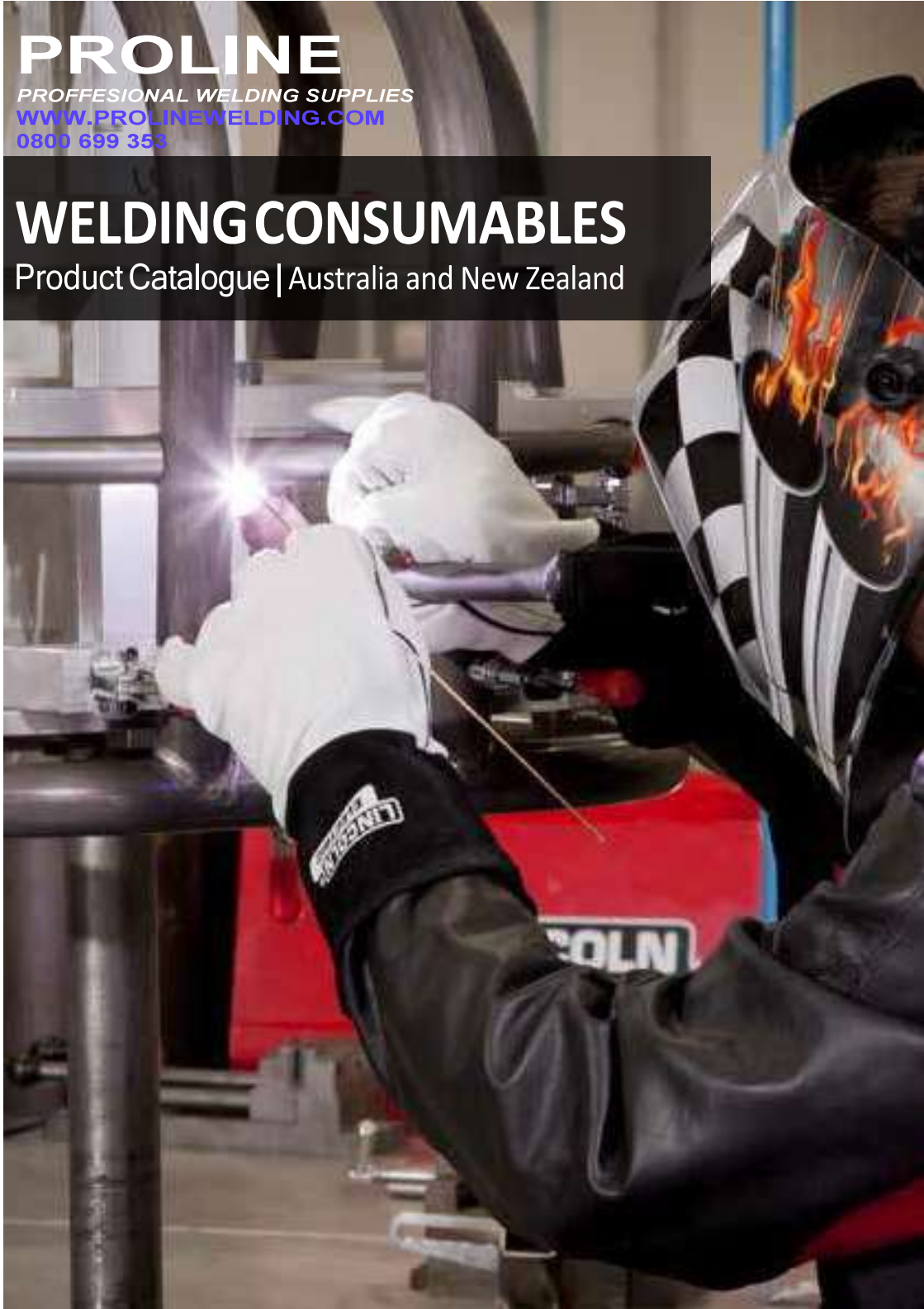
PROFFESIONAL WELDING SUPPLIES

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## WELDING CONSUMABLES

Product Catalogue | Australia and New Zealand



## Pipelinor® G70M-E

### Key Features

- All positional gas shielded low alloy cored wire
- Specifically designed for pipeline applications
- Superior weldability, low spatter, low hydrogen
- Outstanding operator appeal
- Capable of producing weld deposits with impact toughness >47J at -50°C
- Excellent wire feeding

### Conformances

**AWS A5.29/A5.29M:** E81T1-GM H4

**AS/NZS ISO 17632-B:** T55 4T1-1 MA-N1-UH5

### Typical Applications

- Hot, fill and cap pass welding up to X70 grade pipe
- Suitable for automated and semi-automatic pipe welding

### Shielding Gas

- M21 : 75-85% Argon / 15-25% CO<sub>2</sub>
- Flow Rate: 15-25 L/min

### Welding Positions



### Diameter / Packaging

Diameter mm	Part Number	Packaging
1.2	944252	Spool S200 4.5kg
	944238	Spool S200 VFB 14kg

### Mechanical Properties - As Required per AWS A5.29 / A5.29M

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -40°C	Charpy V-Notch J @ -50°C
<b>Requirements</b> - AWS E81T1-GM	470 min	550-690	19 min	-	-
<b>Typical Results</b> - As Welded	580	630	23	90	70

### Deposit Composition

	%C	%Mn	%Si	%P	%S
<b>Typical Results - As Welded</b>	0.05	1.45	0.2	0.013	0.01
	%Ni				
<b>Typical Results - As Welded</b>	Diffusible Hydrogen (mL/100g weld deposit)				
	0.95	< 5			

### Typical Operation Procedures

Diameter, Polarity, Shielding Gas	CTWD mm	Wire Feed Speed in/min	Voltage volts	Current amps	Deposition Rate kg/hr
1.2 mm, DC+ M21	15-20	175-500	21-30	130-275	1.6-4.5