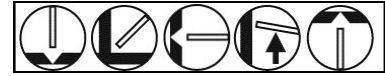


Pipemaster[®] 90



AWS E9010-G
EN ISO 2560-B-E5710-G A

WELDING POSITIONS:



FEATURES:

- Quick-starting
- All-position
- Excellent vertical down
- Excellent arc stability
- Superior arc drive
- Excellent wash-in
- Light slag

BENEFITS:

- Easy arc striking and increased welding efficiency
- Welds in flat, horizontal, vertical and overhead positions
- Faster travel speeds
- Welding accuracy and efficiency
- Excellent penetration
- Maximizes fusion of joints
- Quick and easy cleaning of weld bead

APPLICATIONS:

- Drill platforms
- Shipbuilding
- Storage tanks
- Construction

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

RECOMMENDED WELDING TECHNIQUES:

- GENERAL:** Electrode positive, work negative (DCEP)
ARC LENGTH: Average length (1/8" to 1/4")
FLAT: Stay ahead of puddle and use slight whipping motion
VERTICAL-UP: Slight whipping or weaving technique
VERTICAL-DOWN: Use higher amperage and faster travel, staying ahead of puddle
OVERHEAD: Use similar technique as for vertical-up, multi-pass for build-up
PIPE: Use downhill travel

STORAGE: Dry at room temperature.

RECONDITIONING: Not recommended

TYPICAL WELD METAL PROPERTIES* (Chem Pad):

Weld Metal Analysis (%)	
Carbon (C)	0.25
Manganese (Mn)	1.10
Silicon (Si)	0.24
Phosphorus (P)	0.005
Sulphur (S)	0.010
Nickel (Ni)	0.78
Molybdenum (Mo)	0.18
Vanadium (V)	<0.01

TYPICAL MECHANICAL PROPERTIES* (As Welded):

		AWS Spec (min)
Tensile Strength	103,000 psi (713 MPa)	90,000 psi
Yield Strength	86,000 psi (590 MPa)	77,000 psi
Elongation % in 2"	23%	17%

TYPICAL CHARPY V-NOTCH IMPACT VALUES* (As Welded):

		AWS Spec (min)
Avg. at -20°F (-29°C)	38 ft•lbs (52 Joules)	Not required
Avg. at -50°F (-46°C)	24 ft•lbs (33 Joules)	Not required

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Hobart Brothers Company expressly disclaims any liability incurred from any reliance thereon. Typical data are those obtained when welded and tested in accordance with the AWS A5.5 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by Hobart Brothers Company.

Pipemaster® 90

Diameter		Type of Power	Minimum Amps	Optimum* Amps	Maximum Amps
Inches	mm				
1/8	3.2	DCEP	70	110	140
5/32	4.0	DCEP	80	160	190
3/16	4.8	DCEP	120	190	230

*For out of position welding, reduce amperages shown by 15%.

TYPICAL DEPOSITION DATA (at optimum):

Diameter		Type of Power	Amps	Volts	Deposition Rate lbs/hr	Deposition Efficiency*%
Inches	mm					
1/8	3.2	DCEP	140	34.0	3.00	75.5
5/32	4.0	DCEP	185	34.0	3.14	65.2
3/16	4.8	DCEP	215	32.5	4.42	74.3

*Allowance made for 2" stub loss included.

- **Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded.**

STANDARD DIAMETERS AND PACKAGES: For a complete list of diameters and packaging, please contact Hobart Brothers at (800) 424-1543, or (937) 332-5188 for International Customer Service.

Diameter		Length		50-lb Can
Inches	mm	Inches	mm	
1/8	3.2	14	355	S116844-035
5/32	4.0	14	355	S116851-035
3/16	4.8	14	355	S116858-035

CONFORMANCES AND APPROVALS:

- **AWS A5.5, E9010-G**
- **ASME SFA 5.5, F-3, A-10, E9010-G**

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW LeJune Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210

Material Safety Data Sheets on any Hobart Brothers Company product may be obtained from Hobart Customer Service or at www.hobartbrothers.com.

Because Hobart Brothers Company is constantly improving products, Hobart reserves the right to change design and/or specifications without notice.

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Revision Date: 131001 (Replaces 130701)

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