

## SELECTION GUIDE

API 5L PIPE STEEL GRADE	MINIMUM YIELD STRENGTH	MINIMUM TENSILE STRENGTH	CELLULOSIC ELECTRODES	LOW-HYDROGEN ELECTRODES VERTICAL UP	LOW-HYDROGEN ELECTRODES VERTICAL DOWN	FLUX-CORED WIRES	SOLID WIRES
<b>X52</b>	360 MPa (52200 psi)	460 MPa (66700 psi)					
Root			Pipeweld 6010P/PLUS	Pipeweld 7016	NA	NA	Pipeweld 70S-6/Plus
Hot Pass			Pipeweld 6010P/PLUS	Pipeweld 7016	Pipeweld 80 DH	Pipeweld 71-T1	Pipeweld 70S-6/Plus
Fill and cap			Pipeweld 6010P/PLUS	Pipeweld 7016	Pipeweld 80 DH	Pipeweld 71T-1	Pipeweld 70S-6/Plus
<b>X60</b>	415 MPa (60200psi)	520 MPa (75400 psi)					
Root			Pipeweld 6010P/PLUS	Pipeweld 7016	NA	NA	Pipeweld 70S-6/Plus
Hot Pass			Pipeweld 7010 PLUS	Pipeweld 7016	Pipeweld 80 HD	Pipeweld 91T-1	Pipeweld 70S-6/Plus
Fill and cap			Pipeweld 7010 PLUS	Pipeweld 7016	Pipeweld 80 HD	Pipeweld 91T-1	Pipeweld 70S-6/Plus
<b>X65</b>	450 MPa (65300psi)	535 MPa (77600 psi)					
Root			Pipeweld 6010P/PLUS	Pipeweld 7016	NA	NA	Pipeweld 70S-6/Plus
Hot Pass			Pipeweld 8010 PLUS	Pipeweld 8016	Pipeweld 80 HD	Pipeweld 91T-1	Pipeweld 70S-6/Plus
Fill and cap			Pipeweld 8010 PLUS	Pipeweld 8016	Pipeweld 80 HD	Pipeweld 91T-1	Pipeweld 70S-6/Plus
<b>X70</b>	485 MPa (70300 psi)	570 MPa (82700 psi)					
Root			Pipeweld 6010P/PLUS	Pipeweld 7016	NA	NA	Pipeweld 70S-6/Plus
Hot Pass			Pipeweld 8010 PLUS	Pipeweld 8016	Pipeweld 90 DH	Pipeweld 101T-1	Pipeweld 70S-6/Plus
Fill and cap			Pipeweld 8010 PLUS	Pipeweld 8016	Pipeweld 90 DH	Pipeweld 101T-1	Pipeweld 70S-6/Plus
<b>X80</b>	555 MPa (80500psi )	625 MPa (90600 psi)					
Root			Pipeweld 6010P/PLUS	Pipeweld 7016	NA	NA	Pipeweld 70S-6/Plus
Hot Pass			Pipeweld 9010 PLUS	Pipeweld 10018	Pipeweld 100 DH	Pipeweld 111T-1	Pipeweld 100S
Fill and cap			NA	Pipeweld 10018	Pipeweld 100 DH	Pipeweld 111T-1	Pipeweld 100S