

ETC PH27 VERTICORD 80



MMA Electrodes C-Mn and low-alloy steels

VERTICORD 80 is a basic coated MMA electrode with very low hydrogen content for welding vertical down during pipeline construction. Improved efficiency compared to vertical welding with basic MMA electrodes. Suitable for welding steel type X70 with high ISO-V weld metal toughness at -40°C. Welds are of X-ray quality.

Classification	
EN ISO	2560-A: E 46 4 B 4 5 H5
EN	499: E 46 4 B 35 H5
AWS	A5.5: E 8018 G
GOST	9467-75: 55-E51 5

Approvals	Grade
TÜV	●

Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.07	1.5	0.5	≤ 0.020	≤ 0.015

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+20 °C	-50 °C
As Welded	≥ 460	560-650	≥ 27	≥ 120	≥ 45

Materials

API 5LX 50-70; L210-L415

Storage

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 280-300 °C for 1 hour, 5 times max.

Current condition and welding position

DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CAN	
				PC	Code
3.2	350	130-170	34.0	200	ETC PH2732
4.0	350	160-210	49.8	175	ETC PH2740
4.5	350	200-240	62.3	150	ETC PH2745

