

SAFER N 49

TOP FEATURES

- ISO-V toughness at -30°C. Deposit free from porosity and good of X-ray quality.
- Optimum AC weldability requires an OCV > 65V.
- Very good gap bridging and ideally suited for root passes and positional welding.
- The glassy slag is easily removed from the finely-rippled.

CLASSIFICATION

AWS A5.1 E7016-H8
EN ISO 2560-A E 38 3 B 12 H10

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV	DB	CE
+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.06	0.9	0.7	≤0.020	≤0.015

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -30°C
AWS A5.1	AW	≥400	≥490	≥22	≥27
EN ISO 2560-A	AW	≥380	470-600	≥20	≥47
Typical values	AW	≥400	490-600	≥22	≥47

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0 x 350	55-65
2.5 x 350	50-95
3.2 x 350	80-150
3.2 x 450	95-150
4.0 x 450	120-190

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.0 x 350	CBOX	330	4.2	W000380888
2.5 x 350	CBOX	200	3.9	W000288524
3.2 x 350	CBOX	125	4.1	W000288525
3.2 x 450	CBOX	125	5.3	W000288526
4.0 x 450	CBOX	80	5.2	W000288527

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.