

SAFER NF 510S

TOP FEATURES

- Very low hydrogen content after re-drying.
- Easy slag removal.
- Excellent mechanical properties.

CLASSIFICATION

AWS A5.1 E7018-1 H4
EN ISO 2560-A E 42 5 B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	RINA	DB	CE
+	+	+	+	+	+	+

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

C	Mn	Si	P	S
0.07	1.1	0.4	≤0.020	≤0.020

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-30°C	-46°C	-50°C
AWS A5.1	AW	≥400	≥490	≥22	≥27	≥27	not specified
EN ISO 2560-A	AW	≥420	500-640	≥20	not specified	not specified	≥47
Typical values	AW	≥430	510-640	≥22	≥27	≥27	≥50

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	65-90
2.5 x 350	65-90
3.2 x 350	100-140
3.2 x 450	100-140
4.0 x 450	140-190
5.0 x 450	190-250

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOX	185	3.5	W000380889
2.5 x 350	CBOX	185	4.1	W000279875, W000288330
3.2 x 350	CBOX	120	4.2	W000279876
3.2 x 450	CBOX	120	5.5	W000279877, W000288332
4.0 x 450	CBOX	85	5.8	W000279878
5.0 x 450	CBOX	55	5.5	W000279879

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.