

Conarc® 80G

Key Features

- Basic all positional high strength stick electrode
- Good impact values to -60°C
- 110-120% recovery
- Suitable for welding high strength steels (UTS up to 800 MPa)
- Available in Sahara Ready Pack (SRP)

Conformances

AWS A5.5:	E11018G-H4
AS/NZS 4857-A:	E 69 6 Z B 3 2 H5
DNV:	5Y 69 H5

Typical Applications

- Suitable for welding prequalified procedures for steel groups 9Q and 10Q according to AS/NZS 1554.4 Table 4.6.1.
- Suitable for a wide range of high strength low alloy steels - e.g. Bisplate 70 and 80, Welten 80, T1
- Ideal for applications where very low hydrogen is required

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
3.2	350	523949-1	SRP 1.8kg (8 x SRP per carton)
4.0	450	523956-1	SRP 1.5kg (8 x SRP per carton)

Mechanical Properties - As required per AWS A5.5 & AS/NZS 4857-A

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -60°C
Requirements - AWS	670 min	760 min	15 min	—
Requirements - AS/NZS	690 min	760-960	17 min	47 min
Typical Results - As Welded	760	800	18	90

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.06	1.5	0.4	0.01	0.01
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
Typical Results - As Welded	2.2	0.3	0.3	<0.08	3 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)	
	3.2mm	4.0mm
DC+	80-130	120-180