

Conarc® 49C

TOP FEATURES

- Reliable impact toughness -40°C, good CTOD at -10°C
- The off-shore electrode when Ni-alloying is not allowed
- Efficiency about 115-120%

CLASSIFICATION

AWS A5.1 E7018-1 H4R
EN ISO 2560-A E 46 4 B 32 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All positions, except vertical down

APPROVALS

ABS, LR, BV, DNV, TÜV, DB

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

C	Mn	Si	P	S	HDM
0.06	1.4	0.3	0.015	0.010	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-20°C	-40°C	-46°/-50°C
Required: AWS A5.1		min. 400	min. 490	min. 22	-	-	min. 27
EN ISO		min. 460	530-680	min. 20	-	min. 47	-
Typical values	AW	480	580	28	200	170	100

AW = As welded

Suitable for both As Welded and Stress Relieve (PWHT) conditions. CTOD value at -10°C > 0.25mm

- = not specified

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	55-80
3.2 x 350	80-130
4.0 x 350	120-160
4.0 x 450	120-160
5.0 x 450	180-240

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOH	110	2.0	509236-1
	VPMD	110	2.0	511420-2
3.2 x 350	VPMD	53	2.0	511437-2
	CBOX	108	4.0	509243-1
3.2 x 450	VPMD	53	2.5	511475-2
	CBOX	108	5.2	509250-1
4.0 x 350	VPMD	37	2.0	511505-2
	CBOX	80	4.3	509359-1
4.0 x 450	VPMD	37	2.6	511536-2
	CBOX	50	5.3	509465-1

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.