

Conarc® 51

Key Features

- Excellent root pass stick electrode
- Moisture resistant extremely basic coating
- Reliable impacts and CTOD data available
- Available in Sahara Ready Pack (SRP)

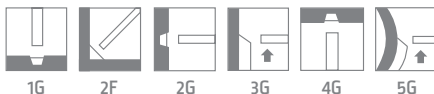
Typical Applications

- Suitable for welding prequalified procedures for steel groups 1-7C according to AS/NZS 1554.1 Table 4.61.
- Suitable for many mild and low alloy steels
- Used for general construction welding applications such as bridges, buildings and pressure vessels
- Low hydrogen electrode for critical applications e.g. offshore, oil and gas

Conformances

AWS A5.1/A5.1M:	E 7016-1 H4R
AS/NZS 4855-A:	E 42 5 B 12 H5
AS/NZS 4855-B:	E 4916-1 A U H5
Lloyds Register:	3Y H5

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	511567-1	SRP 1.3 kg (10 x SRP per carton)
3.2	350	511581-1	SRP 1.7 kg (8 x SRP per carton)

Mechanical Properties - As required per AWS A5.1 & AS/NZS 4855-A

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -45°C
Requirements - AWS	400 min	490 min	22 min	27
Requirements - AS/NZS	420 min	500-640	20 min	-
Typical Results - As Welded	520	575	28	60

Deposit Composition

	%C	%Mn	%Si	%P	%S	Diffusible Hydrogen
Typical Results - As Welded	0.06	1.40	0.5	0.020	0.015	3 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)	
	2.5mm	3.2mm
AC / DC	40-80	70-120