

Conarc® 49

TOP FEATURES

- Almost no spatter, nice wetting and full weld pool control
- One current setting for all positions possible
- Perfect welding and 120% recovery contributes to high productivity

CLASSIFICATION

AWS A5.1 E7018 H4
EN ISO 2560-A E 46 3 B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	RINA	TÜV
+	+	+	+	+	+

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

C	Mn	Si	P	S	HDM
0.09	1.1	0.6	0.015	0.010	4 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-20°C	-30°C	-40°C
Required: AWS A5.1		min. 400	min. 483	min. 22		min. 27	27
EN ISO		min. 460	530-680	min. 20		min. 47	
Typical values	AW	480	560	28	140	120	80

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	70-80
3.2x350	110-130
4.0x450	140-180
5.0x450	160-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x350	VPMD	90	2.0	609271-1
	CBOX	190	4.1	609266-1
3.2x350	VPMD	55	2.0	609272-1
	CBOX	118	4.3	609267-1
3.2x450	VPMD	55	2.4	609277-1
4.0x350	VPMD	40	2.1	609273-1
	CBOX	85	4.6	609268-1
4.0x450	VPMD	40	2.7	609274-1
	CBOX	85	5.8	609269-1
5.0x450	CBOX	55	5.7	609270-1

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.