FLEXAL 60

TOP FEATURES

- Also used for root passes on higher-strength pipe steels, up to X 80.
- Excellent weldability in all position
- Shall be used in DC+ or DC- current.

CLASSIFICATION

AWS A5.1	E6010
EN ISO 2560-A	E 38 3 C 21

CURRENT TYPE

DC-, DC+

WELDING POSITIONS

All positions

APPROVALS

ABS	LR	DNV	TÜV
+	+	+	+

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

C	Mn	Si
0.1	0.6	0.2

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-30°C
AWS A5.1	AW	≥330	≥430	≥22	not specified	≥27
EN ISO 2560-A	AW	≥380	470-600	≥20	not specified	≥47
Typical values	AW	490	520	28	80	64

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	40-80
3.2 x 350	60-110
4.0 x 350	90-140
5.0 x 350	110-170

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	MCAN	555	9.0	W000287257
3.2 x 350	MCAN	355	9.5	W000287258
4.0 x 350	MCAN	237	9.5	W000287259

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.