

# Conarc® 50

## TOP FEATURES

- Good impact values down to -50°C.
- Basic very low hydrogen electrode.
- Excellent for general purpose welding.

## CLASSIFICATION

AWS A5.1 E7018-1 H4R  
EN ISO 2560-A E 46 5 B 3 2 H5

## CURRENT TYPE

AC/DC+

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

ABS	LR	BV
+	+	+

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

C	Mn	Si	P	S
0.07	1.2	0.4	≤0.020	≤0.010

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -50°C
Typical values	AW	480	580	28	150
	SR:1h/620°C	≥420	500-590	≥22	≥90

AW = As welded; SR = Stress relieved

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 350	120-140
3.2 x 450	120-140
4.0 x 350	160-190
4.0 x 450	160-190
5.0 x 450	180-230

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	86	2.0	619260-1
3.2 x 350	VPMD	53	1.9	619261-1
3.2 x 450	VPMD	53	2.5	629263-1
4.0 x 450	VPMD	37	2.5	629264-1
5.0 x 450	VPMD	25	2.5	629265-1

## 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](http://www.lincolnelectric.eu) for any updated information.