

# Conarc® 51

## TOP FEATURES

- Designed for pipe welding in position with very thin coating to improve joint access when root pass welding.
- Outstanding penetration and stable arc.
- Excellent impact at -50°C.
- Matching NACE requirements.
- Efficiency 100%.

## CLASSIFICATION

AWS A5.1 E7016-1 H4  
EN ISO 2560-A E 42 5 B 12 H5

## CURRENT TYPE

AC/DC(+/-)

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

ABS	LR	BV	DNV	TÜV
+	+	+	+	+

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

C	Mn	Si	P	S
0.06	1.2	0.5	≤0.02	≤0.02

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -47°/-50°C
Required: AWS A5.1		min. 400	min. 490	min. 22	min. 27
EN ISO		min. 420	500-640	min. 20	min. 47
Typical values	AW	490	590	28	180
	620°C x 1h	420	620	22	110

AW = As welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-90
3.2 x 450	80-120
4.0 x 450	125-170
5.0 x 450	170-240

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	110	2.1	511567-2
3.2 x 450	VPMD	65	2.6	509892-2
4.0 x 450	VPMD	45	2.6	509908-2
5.0 x 450	VPMD	30	2.7	511628-2

### 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.