

FINCORD DB

TOP FEATURES

- Easy weldability, easy striking and restriking and used extensively for tack-welding.
- Mostly self-releasing slag.
- Smooth weld bead surface.

CLASSIFICATION

AWS A5.1 E6013
EN ISO 2560-A E 42 0 RR 12

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All position, except vertical down

APPROVALS

TÜV	DB
+	+

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

C	Mn	Si
0.08	0.5	0.35

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 0°C
AWS A5.1	AW	≥330	≥430	≥17	not specified
EN ISO 2560-A	AW	≥420	500-640	≥20	≥47
Typical values	AW	485	565	30	50

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-100
3.2 x 350	95-140
4.0 x 450	130-190
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	CBOX	225	4.4	W000258265
3.2 x 350	CBOX	140	4.4	W000258266
5.0 x 450	CBOX	55	5.6	W000258268

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.