SAFER NF 510A

TOP FEATURES

- Very low hydrogen content after re-drying
- Excellent mechanical properties
- Deposit free from porosity, excellent slag detachability

CLASSIFICATION

AWS A5.1	E7018 H4
EN ISO 2560-A	E 42 4 B 32 H5

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All positions

APPROVALS

ABS, LR, BV, DNV, RINA, TÜV, CE

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

C	Mn	Si	P	S
0.05	1.2	0.4	≤0.020	≤0.015

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-30°C	-40°C	-50°C
AWS A5.1	AW	≥400	≥490	≥22	≥27	-	-
EN ISO 2560-A	AW	≥420	500-640	≥20	-	≥47	-
Typical values	AW	≥420	510-640	≥24	≥27	≥47	≥70

AW: As-welded

- = not specified

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-95
3.2 x 350	100-135
3.2 x 450	100-135
4.0 x 350	110-210
4.0 x 450	110-210
5.0 x 450	170-240

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMC	28	0.6	W000385538
	VPMD	90	1.9	W000258592
	CBOX	195	4.2	W000258598
3.2 x 350	VPMD	54	1.9	W000258593
	CBOX	119	4.2	W000258599
3.2 x 450	VPMD	54	2.4	W000258594
	CBOX	119	5.3	W000258600
4.0 x 350	VPMD	40	2.1	W000258595
	CBOX	85	4.5	W000258601
4.0 x 450	VPMD	40	2.7	W000258596
	CBOX	85	5.7	W000258602
5.0 x 450	CBOX	55	5.7	W000258603

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.