

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	not specified	not specified
EN ISO 2560-A	AW	≥420	500-640	≥20	not specified	≥47	not specified
Typical values	AW	≥420	510-640	≥24	≥27	≥47	≥70

*AW: As-welded

OUTPUT 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

PACKAGING AND AVAILABLE SIZES

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	55	1.9	W000258593
	CBOX	120	4.2	W000258599
3.2 x 450	VPMD	54	2.4	W000258594
	CBOX	120	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.