

Conarc® 70G

Key Features

- Basic all positional high strength stick electrode
- Moisture resistant extremely basic coating
- 115-120% recovery
- Supplied in Sahara Ready Pack (SRP)

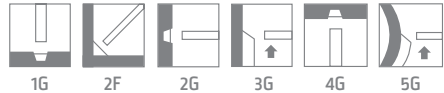
Typical Applications

- Suitable for welding prequalified procedures for steel groups 8Q according to AS/NZS 1554.4 Table 4.6.1.
- Suitable for a wide range of high strength low alloy steels – e.g. Bisplate 60 and 70
- Can be used for fill and cap welding on up to X70 pipe and root pass in X80 pipe grades
- Low hydrogen electrode for critical applications e.g. Offshore

Conformances

AWS A5.5/A5.5M:	E9018-G-H4R
AS/NZS 4857-A:	E 55 4 1NiMo B 3 2 H5
DNV:	4Y 50 H5

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	523706-1	SRP 1.2kg (10 x SRP per carton)
3.2	350	523737-1	SRP 1.9kg (8 x SRP per carton)
4.0	350	523713-1	SRP 1.5kg (8 x SRP per carton)

Mechanical Properties - As required per AWS A5.5 & AS/NZS 4857-A

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -40°C
Requirements - AWS	530 min	620 min	17 min	-
Requirements - AS/NZS	550 min	610-780	18 min	47 min
Typical Results - As Welded	600	655	24	90

Deposit Composition

	%C	%Mn	%Si	%P	%S
Typical Results - As Welded	0.06	1.20	0.40	0.014	0.009
	%Ni	%Cr	%Mo	%V	Diffusible Hydrogen
Typical Results - As Welded	1.0	<0.15	0.40	<0.08	2 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)		
	2.5mm	3.2mm	4.0mm
DC+	60-100	80-130	120-180