

SUPERCORD

TOP FEATURES

- Suitable for vertical down welding of thin plates.
- Operates on low open circuit voltage, recommended for tack welding.
- Good slag detachability and excellent bead appearance.

CLASSIFICATION

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

WELDING POSITIONS

All positions

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

C	Mn	Si	P	S
0.05-0.11	0.4-0.7	0.2-0.4	≤0.03	≤0.02

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	470	540	25	≥47

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	65 - 90
3.2x350	100 - 140

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOX	220	4.4	W000287168
3.2 x 350	CBOX	140	4.5	W000287176

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.