BOR SP6

TOP FEATURES

- Basic double coated electrodes. 550 mm length
- Designed welding of rails using a copper backing. Material to be welded S(P)460: X60-X65.
- Continuous welding of the rail joint is possible without intermediate slag removal. For these special applications, BOR SP6 is only available in 550 mm length.

CLASSIFICATION

EN ISO 2560-A E 46 6 B 34 H10

CURRENT TYPE

AC, DC+

WELDING POSITIONS

Flat and horizontal

APPROVALS

DB
+

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

C	Mn	Si	P	S
0.05	1.7	0.5	0.011	0.01

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-60°C
EN ISO 2560-A	AW	≥460	530-680	≥20	not specified	≥47
Typical values	AW	495	565	26	≥160	99

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
4.0 x 550	160-210
5.0 x 550	180-220
6.0 x 550	210-260

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
4.0x550	VPMD	40	3.4	W000287393
5.0x550	VPMD	25	3.3	W000287394
6.0x550	VPMD	18	3.3	W000287395

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.