

FINCORD

TOP FEATURES

- Easy striking and restriking and used for touch-welding
- The arc is stable with very low spatter and the slag is generally self-releasing.
- The weld beads are finely-rippled and clean, blending into the base plate without undercut.
- Suitable for use with mains transformers.

CLASSIFICATION

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

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All position, except vertical down

APPROVALS

LR	DNV	TÜV	DB
+	+	+	+

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

C	Mn	Si
0.08	0.6	0.45

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	530	26	64

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
1.6 x 250	30-60
2.0 x 250	50-70
2.0 x 350	50-75
2.5 x 250	65-90
2.5 x 350	65-90
3.2 x 350	100-140
3.2 x 450	100-140
4.0 x 350	140-210
4.0 x 450	150-195
5.0 x 450	170-240
6.0 x 450	240-320

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
1.6 x 250	CBOH	220	1.3	W000287198
2.0 x 350	CBOH	170	2.2	W000380798
2.5 x 350	CBOX	210	4.2	W000287201
3.2 x 350	CBOX	125	4.3	W000287202
3.2 x 450	CBOX	118	5.7	W000287203
4.0 x 350	CBOX	78	4.3	W000287204
4.0 x 450	CBOX	78	5.6	W000287205
5.0 x 450	CBOX	50	5.2	W000287206

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.