Conarc® 60G

TOP FEATURES

- Good impact values down to -51°C.
- DC welding preferred.
- 115 - 120% recovery.

CLASSIFICATION

AWS A5.5	E9018M-H4
EN ISO 18275-A	E 55 4 Z B 32 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

DNV	TÜV
+	+

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

C	Mn	Si	P	S	Ni	Mo	HDM
0.06	1.0	0.4	0.015	0.010	1.6	0.3	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -20°C	-40°C	-51°C
Required: AWS A5.5		540-620*	min. 620	min. 24			min. 27
EN ISO		min. 550	610-780	min. 18		min. 47	
Typical values	AW	600	670	25		98	
	SR:1h/620°C	550	640	24	90		40

AW = As welded; SR = Stress relieved

* Diameter 2.5 mm max 655 MPa

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	80-130
4.0 x 350	120-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	53	2.0	523652-2
4.0 x 350	VPMD	36	2.0	523645-2

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.