

SUPERCITO

TOP FEATURES

- Very low diffusible hydrogen content, high impact toughness down to - 50°C and CTOD tested.
- Easy slag removal.
- Efficiency 120%.
- DC+ and AC welding current

CLASSIFICATION

AWS A5.1 E7018-1 H4
EN ISO 2560-A E 42 5 B 42 H5

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

LR	DNV	RMRS	TÜV
+	+	+	+

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

C	Mn	Si	P	S
0.05-0.08	1.0-1.5	≤0.55	≤0.020	≤0.020

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -47/-50°C
AWS A5.1	AW	≥400	≥490	≥22	not specified
EN ISO 2560-A	AW	≥420	500-640	≥20	≥47
Typical values	AW	490	545	26	140

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 350	100-140
3.2 x 450	100-140
4.0 x 450	140-190
5.0 x 450	190-250

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	90	2.0	W000387681
	CBOX	185	4.1	W000287295
3.2 x 350	VPMD	55	1.9	W000279902
	CBOX	120	4.2	W000287296
3.2 x 450	VPMD	55	2.5	W000387682
4.0 x 450	VPMD	40	2.7	W000279904, W000387683
	CBOX	85	5.8	W000287298

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.