

SAFER R 600

TOP FEATURES

- Weld metal hardness~57-62HRC, the deposit can only be machined by grinding
- Excellent weldability in all position except Vertical Down and Overhead positions
- Shall be used in DC+ or AC current

TYPICAL APPLICATIONS

- Civil works and mining equipment

CLASSIFICATION

EN 14700 E Fe2*

(*: Nearest classification, Si max 1.0%)

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All positions, except vertical down

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

C	Mn	Si	Cr	Fe
0.6	1.1	1	2.8	bal.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition	Hardness (HRC)
EN ISO 14700	AW	30-58
Typical values	AW	52-57

AW: As-welded

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 450	85-125
4.0 x 450	100-150
5.0 x 450	150-210

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 450	CBOX	140	5.7	W000258791
4.0 x 450	CBOX	95	5.9	W000258792
5.0 x 450	CBOX	60	5.9	W000258793

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.