

SUPERCITO A

TOP FEATURES

- Hydrogen < 5ml H₂/100g deposited weld metal.
- Weld metal recovery: ~120%.
- DC welding current.

CLASSIFICATION

AWS A5.1	E7018 H4
EN ISO 2560-A	E 42 4 B 42 H5

CURRENT TYPE

DC-, DC+

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	P	S
0.05-0.9	0.80-1.20	0.25-0.65	≤0.025	≤0.015

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -40°C
AWS A5.1	AW	≥400	≥490	≥22	not specified
EN ISO 2560-A	AW	≥420	500-640	≥20	≥47
Typical values	AW	490	565	27	135

* AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 350	120-140
3.2 x 450	120-140
4.0 x 450	160-190

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOX	180	4.0	W000287280
3.2 x 350	CBOX	112	4.0	W000287281
5.0 x 450	VPMD	117	2.5	W000279905

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.