

CUMULO

TOP FEATURES

- Excellent for pipe welding and construction work
- Smooth side wall wetting
- Good X-ray soundness

CLASSIFICATION

AWS A5.1 E 6013
EN ISO 2560-A E 38 0 R 12

CURRENT TYPE

AC/DC-

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	TÜV
+	+	+	+	+

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

C	Mn	Si
0.08	0.6	0.4

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					0°C	10°C
Required: AWS A5.1		min. 330	min. 430	min. 17	not specified	
EN ISO		min. 380	470-600	min. 20	min. 47	
Typical values	AW	≥ 420	500-600	≥ 24	≥ 60	≥ 47

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	70-95
3.2x350	100-135
4.0x350	130-190

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x350	CBOH	114	2.1	588601-1
3.2x350	CBOX	155	4.8	588602-1
4.0x350	CBOX	105	4.8	588603-1

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.