

Conarc® ONE

TOP FEATURES

- Reliable impact toughness -40°C, good CTOD at -10°C.
- The off-shore electrode when Ni-alloying is not allowed.
- 115 - 120% recovery.

CLASSIFICATION

AWS A5.1 E7018-1 H4R
EN ISO 2560-A E 42 5 B 32 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	RINA	TÜV
+	+	+	+	+	+

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

C	Mn	Si	P	S	HDM
0.05	1.3	0.4	0.015	0.010	3 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -46°C/-50°C
Required: AWS A5.1		min. 400	min. 490	min. 22	min. 27
EN ISO		min. 420	500-640	min. 20	min. 47
Typical values	AW	480	575	28	80
	PWHT 620°C/1h	420	500-590	22	90

* AW = As welded, PWHT = Post Weld Heat Treatment

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-100
3.2 x 450	90-145
4.0 x 450	110-160
5.0 x 450	160-250

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	86	2.0	573574-2
	CBOX	172	4.0	573536-2
3.2 x 450	VPMD	53	2.5	573581-2
	CBOX	120	5.6	573543-2
4.0 x 450	VPMD	37	2.5	573598-2
	CBOX	80	5.4	573550-2
5.0 x 450	VPMD	25	2.5	573605-2

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.