

Conarc® L150

CLASSIFICATION

AWS A5.1 : E7028 H4R
ISO 2560-A : E 42 2 B 53 H5

GENERAL DESCRIPTION

Basic low hydrogen electrode (HDM< 5 ml/100g)
150% recovery
Easy slag release
Fillet welds and horizontal V- and X-welds
Excellent weldability on AC and DC
Transformers with OCV > 70V recommended
Also available in vacuum sealed Sahara ReadyPack®(SRP)

WELDING POSITIONS

ISO/ASME PA/1G PB/2F PC/2G

CURRENT TYPE

AC/DC + / -

APPROVALS

ABS	BV	DNV	LR	GL	TÜV
3H,3Y	3,3YH	3YH5	3,3YH15	3YH10	+

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

C	Mn	Si	H _{DM}
0.07	0.95	0.4	4 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J)	
					-18°C	-20°C
Required: AWS A5.1 ISO 2560-A Typical values	AW	min. 400 min. 420 540	min. 483 500-640 580	min. 22 min. 20 27	min. 27	min. 47 75

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	3.2	4.0	5.0	6.0
	Length (mm)	450	450	450	450
Unit: carton box	Pieces / unit	-	55	35	-
	Net weight/unit (kg)	-	5.3	5.2	-
Unit: SRP	Pieces / unit	28	21	18	8
	Net weight/unit (kg)	1.9	2.1	2.7	1.6

Identification Imprint: 7028 / CONARC L150 Tip Color: yellow

Conarc®L150: rev. EN 24

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MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275, S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to EH40
Cast steels	
EN 10213-2	G P 240R
Pipe material	
EN 10208-1	L210, L240, L290, L360
EN 10208-2	L240, L290, L360, L415, L445
API 5LX	X42, X46, X52, X60
EN 10216-1	P235T1, P235T2, P275T1
EN 10217-1	P275T2, P355N
Boiler & pressure vessel steel	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	
EN 10025 part 3	S275, S355, S420
EN 10025 part 4	S275, S355, S420

CALCULATION DATA

Sizes Diam. x length (mm)	Current range (A)	Current type	Arc time - per electrode at max. current - (S)*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weld- metal B	kg electrodes/ kg weldmetal 1/N
3.2x450	140-160	AC/DC+	84	375	1.7	64.8	26	1.67
4.0x450	175-220	AC/DC+	80	555	2.6	97.8	17	1.69
5.0x450	275-325	AC/DC+	75	838	4.4	155.7	11	1.72
6.0x450	325-350	AC/DC+	85	1260	5.4	209.4	8	1.64

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions		
	PA/1G	PB/2F	PC/2G
3.2	150A	150A	140A
4.0	210A	200A	190A
5.0	310A	280A	
6.0	360A	300A	

REMARKS / APPLICATION ADVICE

Electrodes after removal from cardboard boxes redry 2-4h 350 ±25°C
Transformers with OCV > 70 V recommended