

Conarc® 85

Key Features

- Basic all positional high strength electrode
- Impact properties down to -50°C
- 115-120% recovery
- Supplied in Sahara Ready Pack (SRP)

Typical Applications

- Suitable for welding prequalified procedures for steel groups 9Q and 10Q according to AS/NZS 1554.4 Table 4.6.1.
- For high strength steels such as T1, HY 100, Naxtra 710, HRS 650, 690
- Ideal for applications where very low hydrogen is required

Conformances

| | |
|------------------------|--------------------------|
| AWS A5.5/A5.5M: | E12018-G H4R |
| AS/NZS 4857-A: | E 69 5 Mn2NiCrMo B 32 H5 |
| DNV: | 4Y 69 H5 |

Welding Positions



Diameter / Packaging

| Diameter mm | Length mm | Part Number | Packaging |
|-------------|-----------|-------------|---------------------------------|
| 3.2 | 350 | 523881-1 | SRP 1.9 kg (8 x SRP per carton) |
| 4.0 | 350 | 523898-1 | SRP 1.5kg (8 x SRP per carton) |

Mechanical Properties - As required per AWS A5.5 & AS/NZS 4857-A

| | Yield Strength MPa | Tensile Strength MPa | Elongation % | Charpy V-Notch J @ -50°C |
|------------------------------------|--------------------|----------------------|--------------|--------------------------|
| Requirements - AWS | 740 min | 830 min | 14 min | - |
| Requirements - AS/NZS | 690 min | 760-960 | 17 min | 47 min |
| Typical Results - As Welded | 840 | 890 | 21 | 60 |

Deposit Composition

| | %C | %Mn | %Si | %P | %S |
|------------------------------------|------|------|-----|-------|---------------------|
| Typical Results - As Welded | 0.06 | 1.40 | 0.3 | 0.010 | 0.010 |
| | %Ni | %Cr | %Mo | %V | Diffusible Hydrogen |
| Typical Results - As Welded | 2.0 | 0.4 | 0.4 | <0.08 | 2 ml / 100 g |

Typical Operation Procedures

| Polarity | Current (amps) | |
|----------|----------------|---------|
| | 3.2mm | 4.0mm |
| DC+ | 80-130 | 120-180 |