Conarc® 48

TOP FEATURES

- Recovery 130%
- Excellent weldability on DC+ in all positions, especially overhead and vertical up.
- Excellent impact toughness down to -40°C.
- Excellent X-ray soundness.

CLASSIFICATION

AWS A5.1	E7018-1 H4R
EN ISO 2590-A	E 46 4 B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

DNV
+

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

C	Mn	Si	P	S	HDM
0.06	1.4	0.3	0.015	0.010	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-20°C	-50°C	-46°/-50°C
Required: AWS A5.1		min. 400	min. 490	min. 22			min. 27
EN ISO		min. 460	530-680	min. 20		min. 47	
Typical values	AW	480	580	28	200	170	100

AW = As welded

Suitable for both As Welded and Stress Relieve (PWHT) conditions

CTOD value at -10°C > 0.25mm

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.0 x 300	50-80
2.5 x 350	60-90
3.2 x 450	80-130
4.0 x 450	120-160

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.0 x 300	VPMD	130	1.6	503609-3
2.5 x 350	VPMD	86	2.0	503616-3
3.2 x 450	VPMD	52	2.5	503630-3
4.0 x 450	VPMD	37	2.5	503652-3

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.