

SAFER NF 59

TOP FEATURES

- Very low diffusible hydrogen content
- High impact toughness down to - 50°C and CTOD tested
- DC welding current

CLASSIFICATION

AWS A5.5 E8018-G H4
EN ISO 2560-A E 50 6 Mn1Ni B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All positions, except vertical down

APPROVALS

CE

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

C	Mn	Si	P	S	Ni
0.06	1.6	0.3	≤0.020	≤0.015	0.75

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					+20°C	-60°C
AWS A5.5	AW	≥460	≥550	≥19	-	-
AWS A5.5	PWHT	≥460	≥550	≥19	-	-
EN ISO 2560-A	AW	≥500	560-720	≥18	-	≥47
Typical values	AW	≥510	590-680	≥24	≥150	≥80
Typical values	PWHT 580°C/1.5h	≥510	590-680	≥24	≥150	≥80

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

PWHT: In accordance with the agreement between the purchaser and the supplier.

- = not specified

OPERATING CURRENT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 350	95-130

AVAILABLE SIZES AND PACKAGING INFORMATION

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	VPMD	87	2.0	W100380224
3.2 x 350	VPMD	54	2.0	W100380225

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.