

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 position, 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	not specified	not specified
AWS A5.5	PWHT**	≥460	≥550	≥19	not specified	not specified
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.

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 350	95-130
4.0 x 450	130-180
5.0 x 450	170-230

PACKAGING AND AVAILABLE SIZES

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	VPMC	21	0.8	W100382959
	VPMD	54	2.0	W100380225
4.0 x 450	VPMD	37	2.5	W100380226

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.