

Conarc® 49C

Key Features

- Premium low hydrogen stick electrode
- Moisture resistant extremely basic coating
- Reliable impacts and CTOD data available
- Supplied in Sahara Ready Pack (SRP)
- EN 10204 3.1 type certificates available

Typical Applications

- Suitable for welding prequalified procedures for steel groups 1-7C according to AS/NZS 1554:1 Table 4.6.1.
- Suitable for many mild and low alloy steels
- Used for general construction welding applications such as bridges, buildings and pressure vessels
- Low hydrogen electrode for critical applications e.g. off-shore when Ni-alloying is not allowed

Conformances

AWS A5.1/A5.1M:	E7018-1 H4R
AS/NZS 4855-A:	E 46 4 B 3 2 H5
AS/NZS 4855-B:	E4918-1 A U H5
Lloyds Register:	3Y H5

Welding Positions



Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	511420-1	SRP 1.3 kg (10 x SRP per carton)
3.2	350	511437-1	SRP 1.9 kg (8 x SRP per carton)
4.0	350	511505-1	SRP 1.5 kg (8 x SRP per carton)

Mechanical Properties - As required per AWS A5.1 & AS/NZS 4855-A

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -45°C
Requirements - AWS	400 min	490 min	22 min	27
Requirements - AS/NZS	460 min	530-680	20 min	-
Typical Results - As Welded	480	580	28	100

Deposit Composition

	%C	%Mn	%Si	%P	%S	Diffusible Hydrogen
Typical Results - As Welded	0.06	1.40	0.30	0.015	0.010	2 ml / 100 g

Typical Operation Procedures

Polarity	Current (amps)		
	2.5mm	3.2mm	4.0mm
AC / DC	55-80	80-130	120-160