

# Conarc® 85

## TOP FEATURES

- Basic all position extremely low hydrogen electrode (HDM < 3 ml/100g)
- For steels with a tensile strength UTS of max. 835 N/mm<sup>2</sup>
- For high strength steels such as T1, HY 100, Naxtra 70, HRS 650, Dillimax. 690
- Good impact values down to -50°C.

## CLASSIFICATION

AWS A5.5 E12018-G-H4R  
EN ISO 18275-A E 69 5 Mn2NiCrMo B 3 2 H5

## CURRENT TYPE

DC+/AC

## WELDING POSITIONS

All except vertical down

## APPROVALS

ABS	DNV
+	+

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

	C	Mn	Si	P	S	Ni	Mo	Cr	HDM
Min.	0.03	1.4	not specified	not specified	not specified	1.8	0.3	0.3	not specified
Max.	0.10	2.0	not specified	0.025	0.020	2.6	0.6	0.6	not specified
Typical	0.06	1.4	0.3	0.010	0.010	2.0	0.4	0.4	2 ml/100 g

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

		Required: AWS A5.5	EN ISO 18275-A	Typical	PWHT 620°C/1h
Tensile strength	(MPa)	830	760-960	890	840
0.2% Proof strength	(MPa)	740	690	840	780
Elongation (%)		14	17	21	20
Impact ISO-V (J)	-40°C	not specified	not specified	80	75
	-50°C	not specified	47	60	60

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	80-130
4.0 x 350	120-180

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	VPMD	53	2.0	523881-2
4.0 x 350	VPMD	37	1.9	523898-2

## 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](http://www.lincolnelectric.eu) for any updated information.

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