SL® 12G

TOP FEATURES

- Service temperature from -40 up to 500°C.
- DC welding preferred.
- 115 - 120% recovery.

CLASSIFICATION

AWS A5.5	E7018-A1-H4R
EN ISO 3580-A	E Mo B 32 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

DNV	TÜV	DB
+	+	+

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

C	Mn	Si	P	S	Mo	HDM
0.05	0.8	0.6	0.020	0.010	0.55	2 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) +20°C	-20°C
Required: AWS A5.5	SR(1)	min. 390	min. 490	min. 25	not specified	
EN ISO	SR(2)	min. 355	min. 510	min. 22	min. 47	
Typical values	SR(3)	560	620	25	140	50
	AW	550	610	25	160	70

AW = As welded

Stress relieved: SR(1) = 620±14°C/1h, SR(2) = 570-620°C/1h, SR(3) = 620°C/1h

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	60-90
3.2 x 350	80-130
4.0 x 350	120-180
5.0 x 450	160-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOH	94	2.0	516999-1
3.2 x 350	CBOX	108	4.0	516968-1
4.0 x 350	CBOX	80	4.3	516975-1
5.0 x 450	CBOX	50	5.3	516982-1

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.