

CONARC® 80G**MMA (SMAW)****HIGH STRENGTH BASIC ELECTRODE****PRODUCT DESCRIPTION**

Basic all position extremely low hydrogen electrode (HDM < 4 ml/100g)
 Weldable on AC and DC
 110 - 120% recovery
 Good impact values down to -60°C, meets requirements of 5Y approval
 Suitable for welding S690 grade steels for offshore jack up rigs and high strength steels for submarines (Rm up to 800 N/mm²)

CLASSIFICATIONS

AWS A5.5 E11018G-H4
ISO 18275-A E 69 6 Z B 32 H5
APPROVALS ABS, DNWGL; LR

ASME IX QUALIFICATION

QW432 F-No 4
QW442 A-No 10

WELDING POSITIONS (ISO/ASME)**PA/1G****PB/2F****PC/2G****PF/3Gu****PE/4G****PH/5Gu****CURRENT TYPE**

AC / DC +/-

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	P	S	Cr	Ni	Mo	HDM
min.	--	--	--	--	--	--	--	--	--
max.	--	1.0	0.8	0.030	0.030	0.3	0.5	0.2	--
Typical	0.06	1.5	0.4	0.01	0.01	0.3	2.2	0.3	3 ml/100 g

ALL-WELD MECHANICAL PROPERTIES

	Required: AWS A5.5	ISO 18275-A	Typical
Tensile strength (MPa)	Min. 760	760-960	800
0.2% proof strength (MPa)	Min. 670	Min. 690	760
Elongation (%)	Min. 15	Min. 17	18
Impact ISO-V(J) - 60°C	-	Min. 47	90

OPERATING PARAMETERS, DC +VE OR AC (OCV: 70V MIN)

Diameter (mm)	2.5	3.2	4.0	5.0
min. A		80	110	160
max. A		130	180	240

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				pack	box	pack	box
SRP	2.5	350	523942	67	670	1.3	13.3
	3.2	350	523949	49	392	1.8	15.0
	4.0	350	523956	27	216	1.5	12.5
	5.0	450	523963	23	184	2.5	20.8

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.