

Conarc® 51

TOP FEATURES

- Designed for pipe welding in position with very thin coating to improve joint access when root pass welding
- Outstanding penetration and stable arc
- Excellent impact at - 50°C
- Matching NACE requirements
- Efficiency 100%

CLASSIFICATION

AWS A5.1 E7016-1 H4
EN ISO 2560-A E 42 5 B 12 H5

CURRENT TYPE

AC/DC(+/-)

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	TÜV
+	+	+	+	+

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

C	Mn	Si	P	S
0.06	1.2	0.5	≤0.02	≤0.02

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -29°/-30°C
Required: AWS A5.1		min. 400	min. 490	min. 22	min. 27
EN ISO		min. 420	500-640	min. 20	min. 47
Typical values	AW	≥420	500-640	26	≥110
	620°C x 1h	≥390	500-620	≥22	≥110

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	60-90
3.2x350	80-130
3.2x450	80-120
4.0x350	125-170
4.0x450	125-170
5.0x450	170-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x350	SRP	69	1.3	511567-1
	CBOH	110	2.1	509816-1
3.2x350	SRP	56	1.6	511581-1
	CBOX	140	4.4	509823-1
3.2x450	SRP	56	2.2	509892-1
4.0x450	SRP	28	1.6	509908-1
5.0x450	SRP	25	2.2	511628-1

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.