

Blucord

TOP FEATURES

- Good slag detachability and excellent bead appearance
- Efficiency 100%
- Operates on low open circuit voltage

CLASSIFICATION

AWS A5.1 E6013
EN ISO 2560-A E 42 0 R 12

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All position, except vertical down

APPROVALS

ABS	LR	BV	DNV	CE
+	+	+	+	+

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

C	Mn	Si	P	S
0.08	0.6	0.40	0.025	0.010

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 0°C
AWS A5.1	AW	≥330	≥430	≥17	not specified
EN ISO 2560-A	AW	≥420	500-640	≥20	≥47
Typical values	AW	≥430	510-550	≥24	≥47

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
1.6 x 250	35-50
2.0 x 300	50-70
2.5 x 300	60-90
2.5 x 350	55-90
3.2 x 350	80-130
3.2 x 450	90-130
4.0 x 450	120-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.0 x 300	CBOH	161	1.9	W000380882
2.5 x 300	CBOX	215	3.8	W000380884
2.5 x 350	CBOX	240	4.1	W000380886
3.2 x 350	CBOX	140	4.3	W000380887
3.2 x 450	CBOX	130	5.7	W000380893

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.