

# Conarc® 49C

## TOP FEATURES

- Reliable impact toughness -40°C, good CTOD at -10°C
- The off-shore electrode when Ni-alloying is not allowed
- 100 - 120% recovery

## CLASSIFICATION

AWS A5.1 E7018-1 H4R  
EN ISO 2560-A E 46 4 B 32 H5

## CURRENT TYPE

AC/DC(+/-)

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

ABS	LR	BV	DNV	TÜV	DB
+	+	+	+	+	+

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

C	Mn	Si	P	S	HDM
0.06	1.4	0.3	0.015	0.010	2 ml/100 g

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)		
					-20°C	-50°C	-46°/-50°C
Required: AWS A5.1		min. 400	min. 490	min. 22			min. 27
EN ISO		min. 460	530-680	min. 20		min. 47	
Typical values	AW	480	580	28	200	170	100

AW = As welded

Suitable for both As Welded and Stress Relieve (PWHT) conditions

CTOD value at -10°C > 0.25mm

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5x350	55-80
3.0x350	70-110
3.2x350	80-130
4.0x350	120-160
4.0x450	120-160
5.0x450	180-240

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5x350	SRP	70	1.3	511420-1
	CBOH	110	2.0	509236-1
3.2x350	SRP	50	1.9	511437-1
	CBOX	108	4.0	509243-1
3.2x450	SRP	50	2.4	511475-1
	CBOX	108	5.2	509250-1
4.0x350	SRP	28	1.5	511505-1
	CBOX	80	4.3	509359-1
4.0x450	SRP	28	2.0	511536-1
	CBOX	80	5.6	509366-1
5.0x450	SRP	23	2.4	511529-1
	CBOX	50	5.3	509465-1

## 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.  
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