

CONARC® 85

MMA (SMAW)

LOW ALLOY STEELS

HIGH STRENGTH BASIC ELECTRODE

PRODUCT DESCRIPTION

Basic all position extremely low hydrogen electrode (HDM < 2 ml/100g)
 For steels with a tensile strength UTS of max. 835 N/mm²
 For high strength steels such as T1, HY 100, Naxtra 70, HRS 650, Dillimax. 690
 Good impact values down to -50°C

CLASSIFICATIONS

AWS A5.5	E12018-G-H4R
ISO 18275-A	E 69 5 Mn2NiCrMo B 3 2 H5
APPROVALS	ABS, DNVGL; CCS

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	Ni	Mo	Cr	HDM
min.	0.03	1.4	--	--	--	1.8	0.3	0.3	--
max.	0.10	2.0	--	0.025	0.020	2.6	0.6	0.6	--
Typical	0.06	1.4	0.3	0.010	0.010	2.0	0.4	0.4	2 ml/100 g

ALL-WELD MECHANICAL PROPERTIES

	Required: AWS A5.5	ISO 18275-A	Typical	PWHT: 620°C/1h
Tensile strength [MPa]	830	760-960	890	840
0.2% proof strength [MPa]	740	690	840	780
Elongation [%]	14	17	21	20
Impact ISO-V(I) - 40°C	-	-	80	75
- 50°C	-	47	60	60

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

Diameter (mm)	2.5	3.2	4.0	5.0
min. A		80	120	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	523935	68	680	1.4	14.5
	3.2	350	523881	50	400	1.9	15.8
	4.0	350	523898	28	224	1.5	12.5
	4.0	450	523928	28	224	1.9	15.8
	5.0	450	523904	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.