Supra®

TOP FEATURES

- Excellent on painted or rustcovered steel
- Recommended for bridging wide gaps
- Weldable in all positions with one current setting

CLASSIFICATION

AWS A5.1	E 6012
EN ISO 2560-A	E 38 0 RC 11

CURRENT TYPE

AC/DC-

WELDING POSITIONS

All positions

APPROVALS

LR	BV	DNV	TÜV	DB
+	+	+	+	+

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

C	Mn	Si
0.12	0.5	0.6

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) 0°C
Required: AWS A5.1		min. 330	min. 430	min. 17	not specified
EN ISO		min. 380	470-600	min. 20	min. 47
Typical values	AW	470	550	23	56

AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	70-90
3.2 x 350	95-130
4.0 x 350	130-170
5.0 x 350	170-250

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOH	110	2.1	588694-1
3.2 x 350	CBOX	165	4.8	588695-1
4.0 x 350	CBOX	115	4.9	588696-1
5.0 x 350	CBOX	74	4.9	588697-1

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.