

LB-52

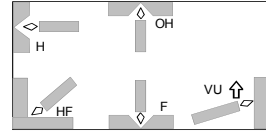
Low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel

Classification: ASME / AWS A5.1 E7016
 EN499 E423B
 JIS Z3212 D5016

Features: •Suitable for butt and fillet welding of heavy structures
 •Excellent mechanical properties

Redrying Conditions: 300~350°Cx0.5~1 h

Welding Positions



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.08	0.60	0.94	0.011	0.006
Guaranty	0.05~0.10	≤0.75	≤1.60	≤0.020	≤0.020

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cxh)
Example	500	570	32	-29°C:120	AW
	420	520	33	-29°C:150	620×1
Guaranty	≥400	≥480	≥22	-29°C ≥27	AW
	≥350	≥460	≥25	-29°C ≥27	620±15x1

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
Dia.	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
F, HF, H	55~85A	90~130A	130~180A	180~240A	210~310A
VU, OH	50~80A	80~120A	110~170A	150~200A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

AB	LR	NV	NK
3H10,3Y,3Y400	3m,3Ym(H15)	3YH10	KMW53HH

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	350	5	20	20
3.2	350	5	20	31
4.0	400	5	20	54
5.0	450	5	20	97
6.0	450	5	20	137