

LB-52-18

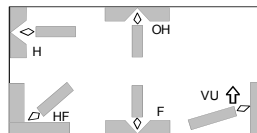
Iron powder low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel

Classification: ASME / AWS A5.1 E7018
EN499 E423B
JIS Z3212 D5016

Features : •Suitable for butt and fillet welding of heavy structure
•Good performance by DC-EP current

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 | 0.07 | 0.59 | 0.97 | 0.013 | 0.007 |
| 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 | 560 | 31 | -29°C:110 | AW |
| | 420 | 520 | 32 | -29°C:140 | 620x1 |
| Guaranty | ≥400 | ≥480 | ≥22 | -29°C≥27 | AW |
| | ≥350 | ≥460 | ≥25 | -29°C≥27 | 620±15x 1 |

Recommended welding parameters

| | 2.6mm | 3.2mm | 4.0mm | 5.0mm |
|----------|--------|---------|----------|----------|
| Dia. | 2.6mm | 3.2mm | 4.0mm | 5.0mm |
| F, HF, H | 65~95A | 90~130A | 130~190A | 190~250A |
| VU, OH | 60~90A | 80~120A | 110~170A | 165~210A |

Polarity

| | |
|----------|-----------|
| Example | AC |
| Guaranty | AC, DC-EP |

Approvals

| AB | LR | NV | NK |
|---------|-------------|-------|---------|
| 3H10,3Y | 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 | 24 |
| 3.2 | 400 | 5 | 20 | 41 |
| 4.0 | 450 | 5 | 20 | 69 |
| 5.0 | 450 | 5 | 20 | 106 |