

Shielded Metal Arc Welding

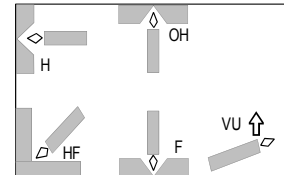
LB-1SJ
FAMILIARC

Extra low hydrogen type covered electrode for 490 to 550MPa high tensile strength steel for low temperature service

Classification: ASME / AWS A5.5 E8016-G
 JIS Z3241 DL5016-6AP1

- Features :**
- Suitable for butt and fillet welding of low temperature steel
 - Good CTOD properties at temperatures down to -45°C
 - Good impact values at temperatures down to -80°C
 - AC current is recommended for 550MPa HT class steel

Redrying Conditions: 350~400°Cx1h

Welding Positions:

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

	C	Si	Mn	P	S	Ni	Ti	B
Example	0.08	0.31	1.32	0.007	0.004	1.33	0.020	0.0018
Guaranty	≤0.10	0.15~ 0.50	1.10~ 1.70	≤0.020	≤0.020	1.10~ 1.70	0.005~ 0.035	0.0005~ 0.0045

Mechanical properties of all-weld metal as AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cxh)
Example	520	610	29	-80°C: 127	AW
	490	580	29	-80°C: 130	620x1
Guaranty	≥460	≥550	≥19	-60°C≥27	AW
	≥460	≥550	≥19	-60°C≥27	620±15x1

Recommended welding parameters

	3.2mm	4.0mm	5.0mm
F, HF, H	90~130A	130~180A	180~240A
VU, OH	80~120A	110~170A	150~200A

Polarity

Example	AC
Guaranty	AC

Approvals

LR	NV	BV	NK
5Y40m(H15)	5YH10,NV2-4L, 4-4L	4Y40MHH, MG	KMW5Y42H10

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
3.2	350	5	20	31
4.0	400	5	20	55
5.0	450	5	20	97