

Shielded Metal Arc Welding

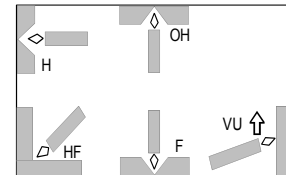
LB-116
FAMILIARC

Low hydrogen and moisture resistant type covered electrode for 780MPa high tensile strength steel

Classification: ASME / AWS A5.5 E11016-G

Features : •Suitable for 780MPa high tensile strength steel

Redrying Conditions: 350~400°Cx1h

Welding Positions:

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

	C	Si	Mn	P	S	Ni	Cr	Mo
Example	0.08	0.63	1.50	0.010	0.006	1.83	0.28	0.43
Guaranty	≤ 0.09	0.40~ 0.75	1.20~ 1.70	≤ 0.020	≤ 0.020	1.50~ 2.10	0.20~ 0.40	0.35~ 0.55

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	730	830	24	-20°C: 110	AW
Guaranty	≥670	≥760	≥15	-20°C≥27	AW

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	55~85A	90~130A	130~180A	180~240A
VU, OH	50~80A	80~120A	100~170A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

AB, NV, NK

Packages

Dia. (mm)	Length (mm)	Weight per pack(kg)	Weight per carton (kg)	Weight per piece (g)
2.6	300	2	20	17
3.2	350	5	20	31
4.0	400	5	20	55
5.0	450	5	20	97