

Shielded Metal Arc Welding

LB-52NS

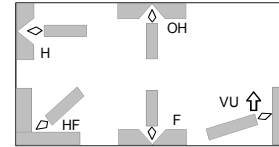
FAMILIARC

Extra low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel for low temperature service

Classification : ASME / AWS A5.5 E7016-G
 EN ISO 2560-A-E 42 6 Z B
 JIS Z3212 D5016

Features : •Suitable for butt and fillet welding
 •Good CTOD properties at temperatures down to -30°C
 •Better impact values at temperatures down to -60°C

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	0.40	1.38	0.012	0.007	0.48	0.023	0.0021
Guaranty	≤0.10	0.30~ 0.90	1.00~ 1.60	≤0.020	≤0.020	0.30~ 0.70	0.005~ 0.035	0.0005~ 0.0045

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	490	580	29	-60°C: 130	AW
	470	570	31	-60°C: 120	620x1
Guaranty	≥390	≥480	≥25	-60°C≥27	AW
	≥390	≥480	≥25	-60°C≥27	620±15x1

Recommended welding parameters

	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
F, HF,H	55~85A	90~130A	130~180A	180~240A	250~310A
VU, OH	50~80A	80~120A	110~170A	150~200A	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

AB	LR	NV	BV	NK
3H10,3Y,MG	5Y40m(H15)	5YH10,NV2-4(L), 4-4(L)	4Y40MHH,MG	KMWL3HH

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
6.0	450	5	20	140