

Shielded Metal Arc Welding

LB-62L

FAMILIARC

Extra low hydrogen and moisture resistant type covered electrode for 550 to 610MPa high tensile strength steel for low temperature service

Classification: ASME / AWS A5.5 E8016-C1

Features : •Suitable for butt and fillet welding

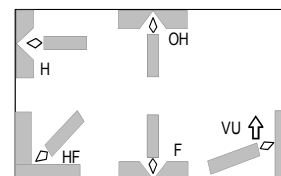
•Good CTOD properties at temperatures down to -10°C

•Better impact values at temperatures down to -60°C

•AC current is recommended for 570 to 610MPa class steel

Redrying Conditions: 350~400°Cx1h

Welding Positions:



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

	C	Si	Mn	P	S	Ni	Mo	Ti	B
Example	0.07	0.34	0.97	0.012	0.005	2.10	0.13	0.022	0.0016
Guaranty	≤ 0.10	≤ 0.60	≤ 1.20	≤ 0.03	≤ 0.03	2.00~ 2.75	-	-	-

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	El (%)	IV (J)	PWHT (°C×h)
Example	540	650	27	-60°C: 130	AW
	530	640	28	-60°C: 120	608x1
Guaranty	≥460	≥550	≥19	-60°C≥27	AW
	≥460	≥550	≥19	-60°C≥27	605±15x1

Recommended welding parameters

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

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

AB
5YQ500(H10)

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