

## Shielded Metal Arc Welding

**LB-52U**
**FAMILIARC**

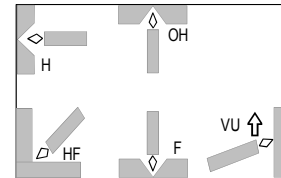
Low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel

**Classification:** ASME / AWS A5.1 E7016  
 EN ISO 2560-A-E 42 2 B  
 JIS Z3211 D4316

**Features :**

- Suitable for one side welding of pipes
- Extremely good arc stability in one side welding with relatively low 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	0.08	0.64	0.86	0.012	0.008
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)
Example	480	560	31	-29°C: 80
Guaranty	≥400	≥480	≥22	-29°C≥27

**Recommended welding parameters**

	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	60~90A	90~130A	130~180A	180~240A
VU, OH	50~80A	80~120A	110~170A	150~200A
Root pass	30~80A	60~110A	90~140A	130~180A

Root pass: DC-EN is also suitable.

**Polarity**

Example	AC
Guaranty	AC, DC-EP

**Approvals**

AB	LR	NV	BV	NK	Others
3H10,3Y	3m,3Ym(H15)	3YH10	3,3YHH	KMW53H10	CCS

**Packages**

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	350	5	20	20
3.2	400	5	20	35
4.0	400	5	20	53
5.0	400	5	20	82